# ENGINE 21B

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## GENERAL DESCRIPTION

Transit range vehicles may have both diesel engines and various petrol engine types fitted. Petrol engines are in-line as well as V4 and V6 versions.

This section covers the Ford diesel engine **only**. For easier identification this engine is designated with the code letter 'G' in line with other workshop manuals. The table below lists the engine types built in Germany and the United Kingdom respectively.

## ENGINE SUMMARY

| Cubic Capacity Litres | Compression Ratio | Type | HP (kw) | Engine Code | | Source | |
|---|---|---|---|---|---|---|---|
| | | | | Vehicle plate | Workshop Manual | Germany | U.K. |
| 2,4 | DIESEL | OHV/I-4 | 62 (46) | 4A | G | X | X |
| 1,5 | LC | OHV/V4 | 60 (44) | EX | D | X | — |
| 1,6 | LC | OHV/I-4 | 65 (48) | L1 | A | — | X |
| 1,7 | LC | OHV/V4 | 65 (48) | MX | D | X | — |
| 2,0 | LC | OHV/V4 | 70 (51) | NX | E | X | X |
| 2,0 | HC | OHV/V4 | 80 (59) | NY | E | — | X |
| 3,0 | LC | OHV/V6 | 100 (74) | HX | F | — | X |

OHV = overhead valves

I-4 = in-line 4 cylinder engine

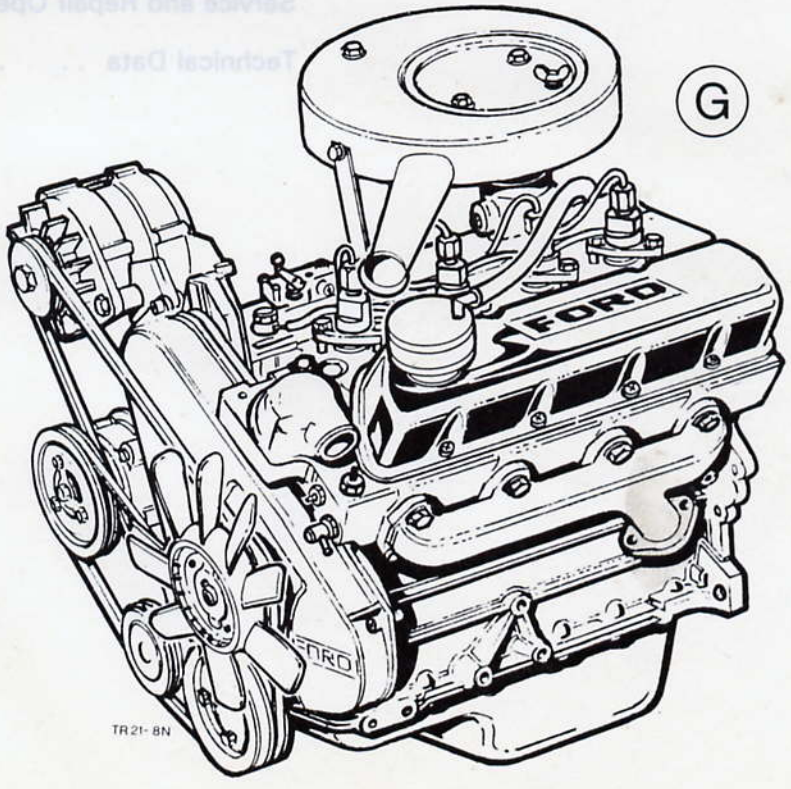



Fig. 1. 'G' Engine

## GENERAL DESCRIPTION (cont'd)

The 'G' engine is a water-cooled 4 cylinder 4 stroke in-line indirect injection diesel engine (Fig. 1).

The combined fuel injection and fuel lift pump, fuel filter, brake pump and full-flow oil filter are all located on the right-hand side of the engine. The rotor oil pump is located at the front and is driven by a crankshaft gear. The fuel injection pump is driven via a toothed belt which also drives the camshaft. Similarly, alternator, brake pump and water pump are driven by the crankshaft via a V-belt.

In order to achieve low overall height (compact layout) the cylinders are mounted at an angle of 22,5 degrees to the left of vertical. To give maximum crankshaft drive stability the crankshaft is carried on five main bearings. Centre main bearing end float is determined by four half thrust washers.

The floating piston pins are located in the connecting rods (with bushes) and secured with two circlips. Pistons have two compression rings and one oil scraper ring. The camshaft which is carried on five bearings is located in the cylinder block on one side of the engine and driven by the crankshaft via a toothed belt which, as already mentioned, also drives the fuel injection pump. A drilling through the shaft carries oil to the replaceable bearings.

Overhead valve timing is effected via tappets, push rods and rocker arms. The rocker shaft has a drilling for rocker arm lubrication. Valves are arranged in the cylinder head in alternating sequence, commencing with an exhaust valve at the front of the engine. Inlet valves have one progressive coil spring and exhaust valves two. Valve adjusting screws are self-locking. Inlet and exhaust valves have different seat angles. Cylinder head valve guides are exchangeable.

The thermostart control incorporated in the inlet manifold ensures quick starting of the engine in low temperature conditions.

An automatic shut-off control fitted to the engine compartment splash shield enables the injection pump to be set to zero lift via a cable, thereby stopping the engine.

The fuel injection pump timing mark is located on the advance unit on top of the pump.

The engine has combustion chambers divided into a turbulence chamber located in the cylinder head and the main combustion chamber in the cylinder itself.

## GENERAL DESCRIPTION (cont'd)

### Lubrication Circuit, Fig. 2

The rotor oil pump located at the front of the engine block is driven by a gear on the crankshaft and draws oil via a strainer and suction pipe (lower drilling) from the oil sump.

The filtered oil is fed through the upper drilling via the pump relief valve into the full-flow oil filter and from there through the central axis of the oil filter cartridge to the main oil gallery. A by-pass valve located on the filter central axis opens in order to enable oil to pass directly into the main gallery in the event of oil filter cartridge blockage (by sludge, etc.).

The pump relief valve in the cylinder block, between the oil pump and the full-flow oil filter, is connected to the main oil gallery. Excessive oil pressure will force a small spring-loaded plunger downwards, with the downward movement of the plunger freeing the valve plunger drillings in the direction of the lower gallery thereby providing a direct connection between oil suction tube and pressure duct.

The five main bearings are connected to the main oil gallery. The big end journals are supplied with oil via diagonal lubrication passages from the nearest main crankshaft bearing.

The first four main bearing supports in the cylinder block have splash oil drillings which ensure splash lubrication of piston pins and better cooling of piston tops.

From the centre main bearing the oil passes via the centre camshaft bearing to the camshaft and from there through drillings to the remaining camshaft bearings.

Oil flows from the centre camshaft bearing through a cylinder block drilling to the cylinder head into the rocker arm shaft and to the rocker arms. Valve stems are lubricated by means of oil discharged through the rocker arm drilling.

Both the fuel injection pump and the lift pump are permanently lubricated with oil from the main oil gallery fed to the pumps via engine block and timing cover drillings. The return oil flow to the pump passes through the timing cover. The oil pressure switch which is screwed into the gallery on the right-hand side of the engine block is in direct communication with the main oil gallery.

## GENERAL DESCRIPTION (cont'd)

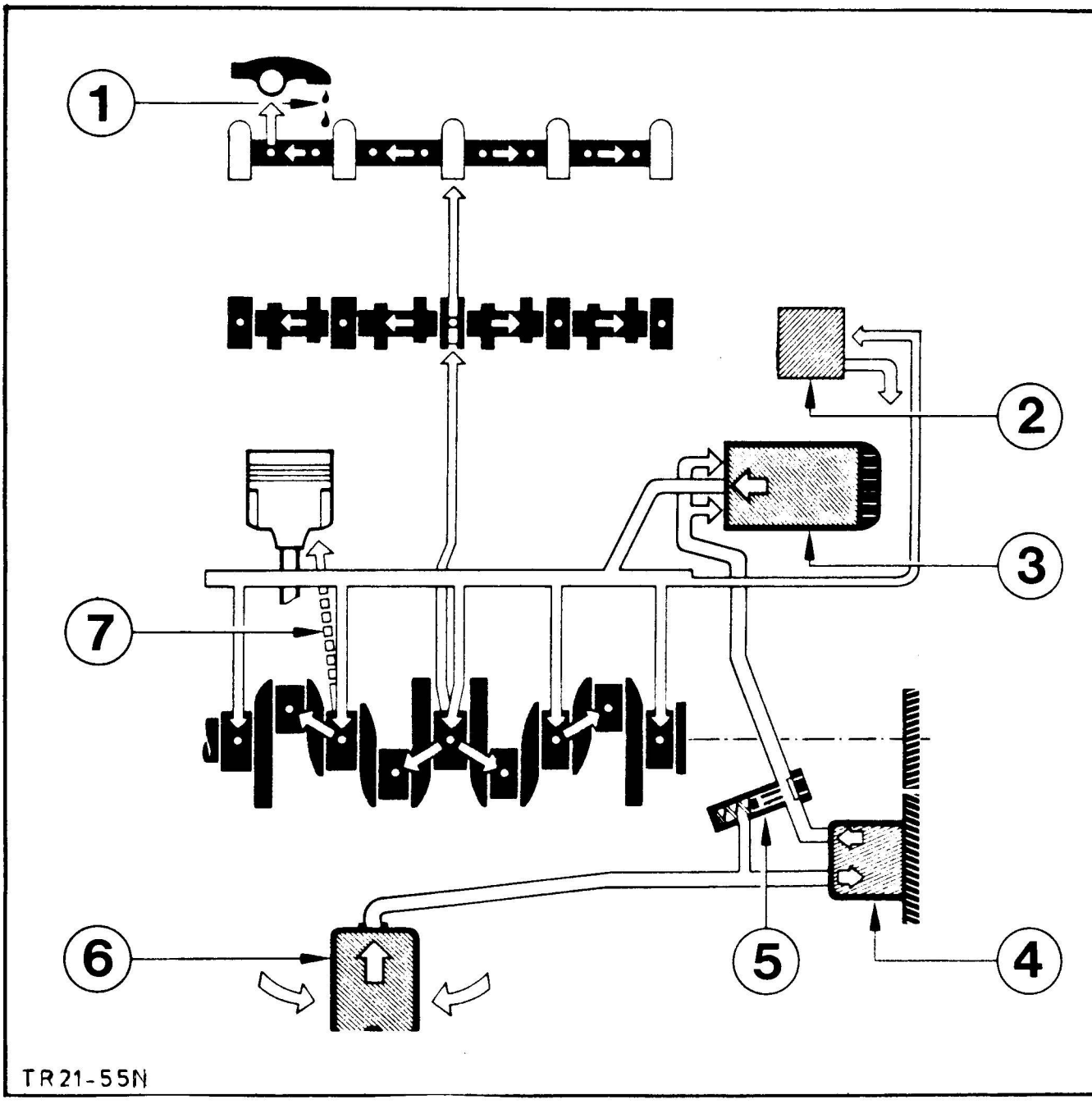



Fig. 2. Lubrication circuit

1. Valve stem drip feed lubrication system
2. Fuel injection pump
3. Exhauster pump
4. Full-flow oil filter
5. Rotor oil pump
6. Oil pump relief valve
7. Oil suction strainer
8. Piston splash lubrication system

## GENERAL DESCRIPTION (cont'd)

### Engine Ventilation System, Fig. 3

The mixture of air and crankcase fumes passes through the cylinder head into the rocker cover from where it is drawn through the oil separator and oil filler connecting hose into the inlet manifold and the filtered air, together with the air drawn through the air cleaner, is fed into the cylinder combustion chambers.

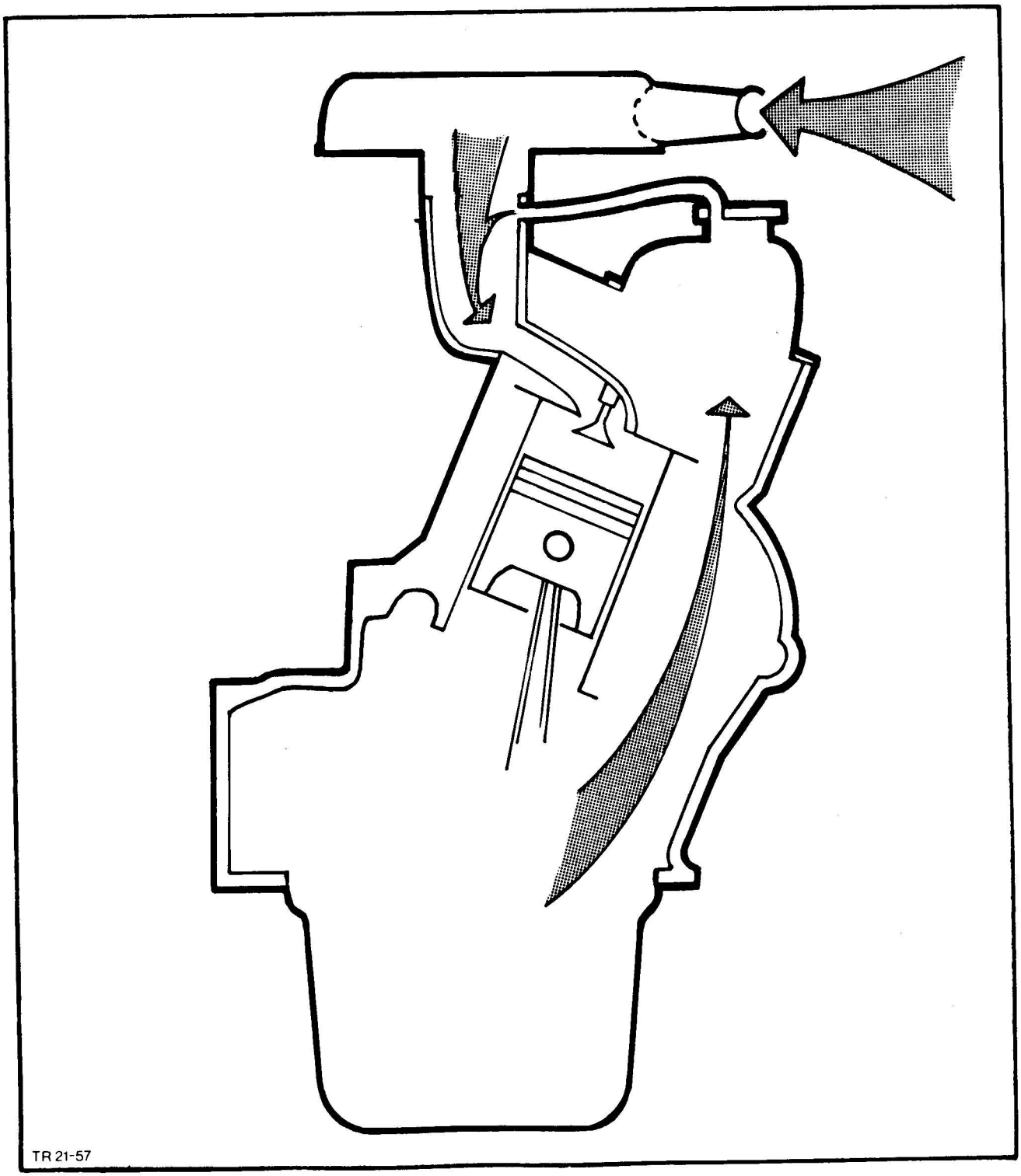



Fig. 3. Engine ventilation

## GENERAL DESCRIPTION (cont'd)

### Engine Identification and Engine Serial Numbers

Regulations in force in certain countries provide for engines to be marked with identification codes and serial numbers. Fig. 4 and 5 show where these data are marked on the engine. Minimum height of letters and numbers is 6 mm (0,25 in) and both codes and serial numbers (e.g. on replacement engines) should be marked in such a manner that they can be clearly recognised by the appropriate testing authorities, thereby preventing rejection of engines.

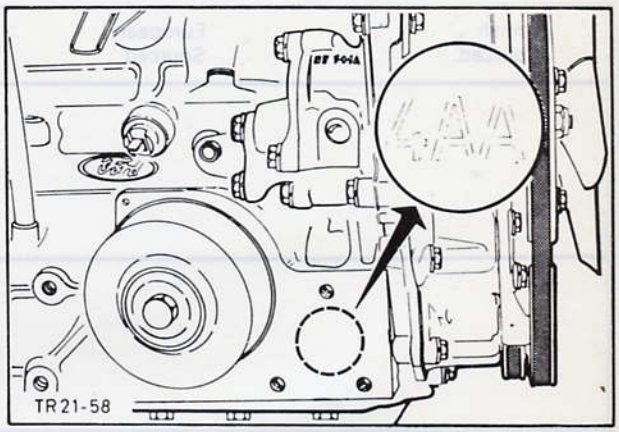



Fig. 4. Engine identification code

## SERVICE ADJUSTMENT AND CHECKS

To check the engine oil level the vehicle should stand on level ground and the engine should be at normal operating temperature. Before carrying out the check, wait a short time to allow all oil to drain back into the sump.

Withdraw the dipstick, wipe it clean with a non-fluffy rag, replace and withdraw it again. The oil on the dipstick indicates the oil level in the sump, which should lie between the two marks, Fig. 6. The quantity of oil required to top up from the bottom mark to the top mark is approximately 1,7 litre (3,0 pints).

If necessary, top up through the filler neck, with engine oil to FORD specification.

Topping up is not necessary until the oil level drops to the bottom mark. Do not allow the oil level to drop any further. Never top up to above the top mark since the excess oil is wasted, i.e. the oil consumption is increased.

The engine oil should be changed and the full-flow oil filter renewed at 5000 km (3000 mile) intervals. If conditions of use are severe, e.g. short trips, frequent starts from cold, dusty roads, etc., the oil should be changed and the oil filter renewed at shorter intervals.

If the specified engine oil is not used the inevitable consequence will be excessive wear or damage to the engine. The oil film becomes discontinuous and engine components under high thermal stresses are subjected to increased wear. Residues collect in the sump and block oil passages. In addition, poor quality oil does not protect against corrosion so that rust forms on the cylinder walls. After a relatively short time the efficiency of the engine will decrease and there will be increased fuel and oil consumption. Always use a branded oil complying with FORD specifications.

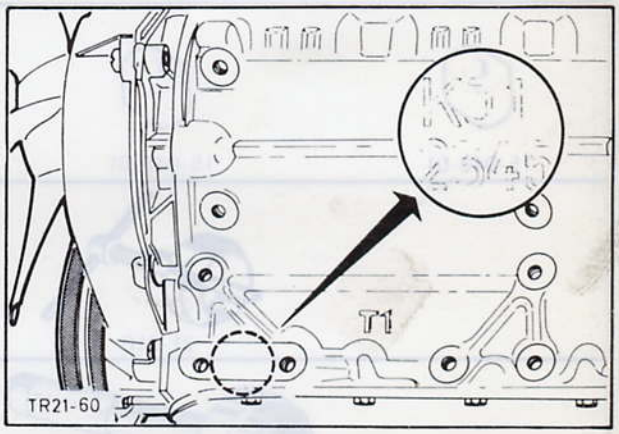



Fig. 5. Engine serial number

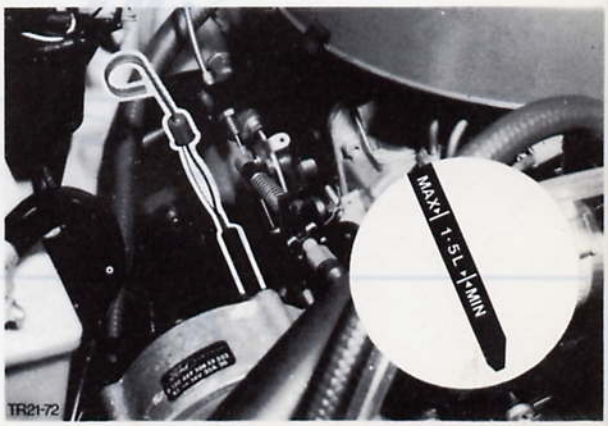
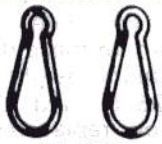
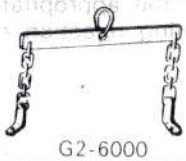
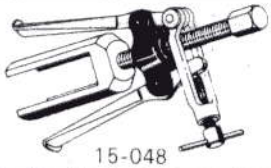
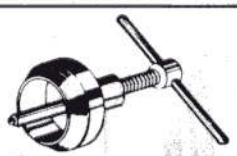
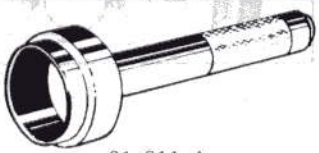
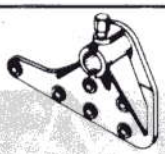
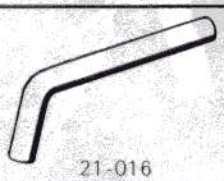
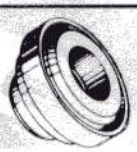


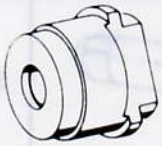

Fig. 6. Engine oil dipstick

## SPECIAL SERVICE TOOL RECOGNITION

| British Sourced | European Sourced | German Sourced | Tool Name |
|---|---|---|---|
| | |  G1-6000 | Engine lifting eyes (additional for G2–6000) |
| | |  G2-6000 | Engine lifting tackle |
| |  15-048 |  G2-4676-A1 | Camshaft oil seal remover |
|  15-048-01 |  15-048-01 |  G2-4676-A2 | Camshaft oil seal remover adaptor (for use with 15–048) |
| |  21-010 | | Crankshaft rear oil seal remover |
| |  21-011-A | | Crankshaft rear oil seal replacer |
| |  21-015 | | Engine mounting bracket |
| |  21-016 | | Timing gear alignment pin |
| |  21-017 | | Camshaft oil seal replacer and aligner |

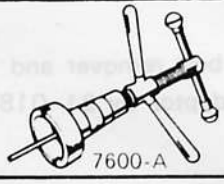
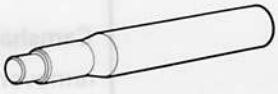
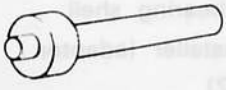
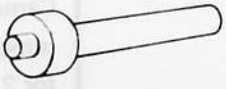
G/7/070/D

## SPECIAL SERVICE TOOL RECOGNITION (cont'd)

| British Sourced | European Sourced | German Sourced | Tool Name |
|---|---|---|---|
|  21-018 | | | Crankshaft flange holding wrench |
|  21-019 | | | Crankshaft bolt remover and replacer (adaptor for 21–018) |
|  21-021 | | | Valve guide – remover/installer |
|  21-022 | | | Camshaft bearing remover/installer (main tool) |
|  21-022-01 | | | Camshaft bearing shell remover/installer (adaptor for 21–022) |
|  21-022-02 | | | Camshaft bearing shell remover/installer (adaptor for 21–022) |
|  21-023 | | | Universal spindle |
|  21-025 | | | Crankshaft front oil seal aligner |
|  21-026 | | | Engine lifting eye – front |

G/7/071/D

## SPECIAL SERVICE TOOL RECOGNITION (cont'd)

| British Sourced | European Sourced | German Sourced | Tool Name |
|---|---|---|---|
| |  21-027 | | Engine lifting eye – rear |
|  7600-A |  21-036 |  G1-7600-A | Spigot bearing remover |
|  CT-9044 |  21-041 |  CT-9044 | Injector pipe nut wrench |
|  CP-7112-A |  21-044 |  G1-7600-B | Clutch disc locator |
|  CP-7123 |  21-045 |  G3-7041-B2 | Spigot bearing installer |

G/7/072/D

## SERVICE AND REPAIR OPERATIONS – CONTENT

| ENGINE | | Description in this publication | Contained in Operation | Unique for TRANSIT |
|---|---|---|---|---|
| 21 111 | Engine – check compressions | X | | X |
| 21 112 | Oil pressure – check | X | | X |
| 21 132 | Engine and transmission assembly – remove and install | X | | X |
| 21 134 8 | Engine – dismantle and reassemble (engine removed) | X | | X |
| 21 146 | Cover-timing belt – remove and install | — | 21 288 | X |
| 21 148 | Timing cover – remove and install | — | 21 467 | X |
| 21 154 | Sump – remove and install | X | | X |
| 21 163 | Cylinder head – remove and install | X | | X |
| 21 213 | Valve clearances – adjust | X | | X |
| 21 217 4 | Valves – remove and install (cylinder head removed) | X | | X |
| 21 231 9 | Valve seat – recut (valves removed) | X | | X |
| 21 235 4 | Valve guides – replace (valves removed) | X | | X |
| 21 255 9 | Rocker shaft assembly – overhaul (rocker shaft removed) | X | | X |
| 21 286 6 | Bearings – camshaft – replace (engine dismantled) | X | | X |
| 21 288 | Seal – camshaft – replace | X | | X |
| 21 304 | Timing belt – replace | X | | X |
| 21 467 | Seal – crankshaft front – replace | X | | X |
| 21 468 4 | Seal – crankshaft rear – replace (engine or transmission removed) | X | | X |
| 21 505 5 | Piston – replace (piston and connecting rod assembly removed) | X | | X |
| 21 584 5 | Ring gear – flywheel – replace (flywheel removed) | X | | X |
| 21 714 | Oil pump – remove and install | X | | X |
| 21 714 8 | Oil pump – overhaul (oil pump removed) | X | | X |
| 21 875 | Engine rubber mounting – front – replace | X | | X |

## SERVICE AND REPAIR OPERATIONS

### 21 111 ENGINE – CHECK COMPRESSIONS

**Special Service Tools and Testing Equipment Required:**

Injection pipe nut wrench .. .. 21–041
Standard compression testing equipment

**The majority of test instruments are of different design and usually enable compression to be checked on one cylinder only. Determination of the actual compression pressure is dependent on several factors, e.g. varying starter motor speeds, or state of charge of the battery. It is, however, essential for at least two requirements to be met, namely, that the engine temperature is normal and valve clearances are adjusted as specified in Technical Data.**

**To Check**

1. Remove inlet manifold.
2. Disconnect cable from shut-off unit to interrupt fuel supply.
3. Unscrew fuel injector pipes using Special Tool 21–041, Fig. 7 and disconnect overflow pipe from nozzle brackets.
4. Remove injectors and withdraw nozzle bracket sealing ring and heat balancing plate.
5. Screw compression pressure tester with new graph paper to injector nozzle orifice concerned, Fig. 8 and crank engine until pointer of tester rises no further (compression pressure data see Technical Data).
6. Vent tester, adjust graph paper for next cylinder and repeat sub-op 5 for all other cylinders.
7. Fit new sealing ring and new heat balancing plate with domed side facing upwards, Fig. 9 and tighten injector nozzles as specified in Technical Data.
8. Fit injector pipes as specified, using Special Tool 21–041 and install overflow pipe.
9. Connect cable to shut-off motor and fit air cleaner.

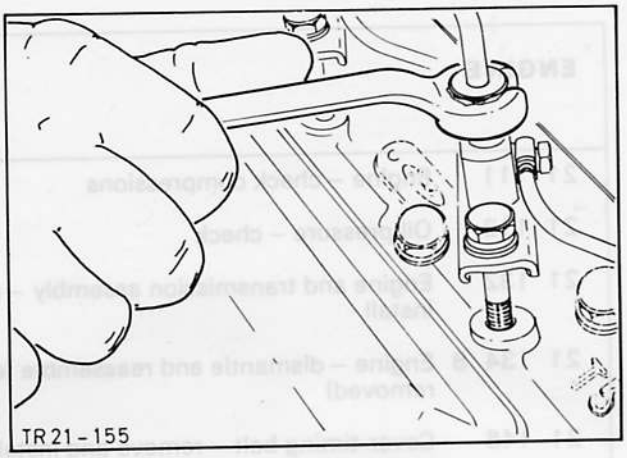



Fig. 7. Remove injector pipes using Special Tool 21–041

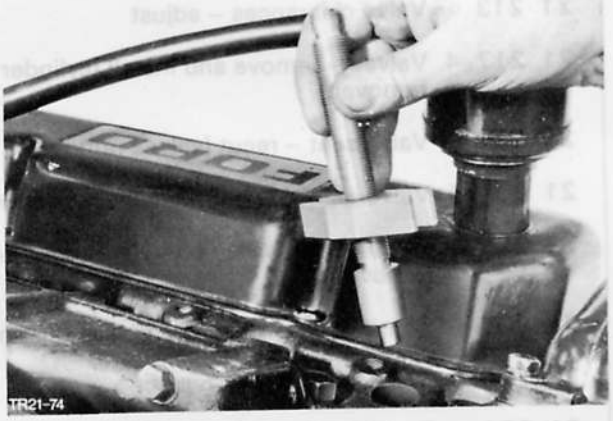



Fig. 8. Install compression tester adaptor into orifice

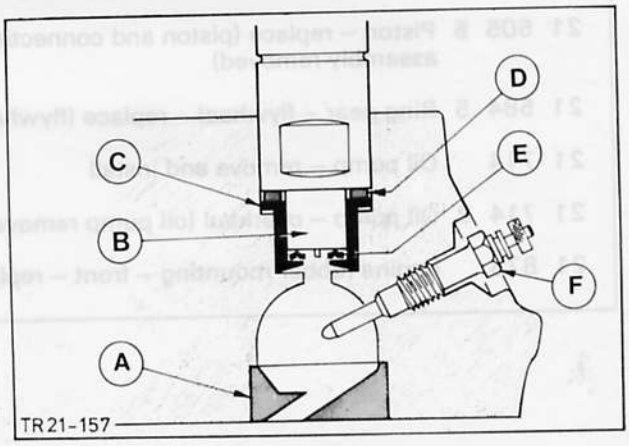



Fig. 9. Turbulence combustion chamber
A – Turbulence combustion chamber element
B – Engine heat shield
C – Engine heat shield gasket
D – Nozzle bracket sealing ring
E – Heat balancing plate

## 21 112 OIL PRESSURE – CHECK

**Testing equipment required:**

Oil pressure test gauge

**Oil pressure depends on various factors (engine speed, oil temperature, oil pump rotor clearance, etc.). Pressure should always be checked at an oil temperature of 355 °K (80 °C) (176 °F). At idling speed oil pressure should be 1,0 bar (kgf/cm²) (14,2 lbf/in²). Maximum pressure should however, not exceed 5 bar (kgf/cm²) (71 lbf/in²) at speeds above 2000 rpm.**

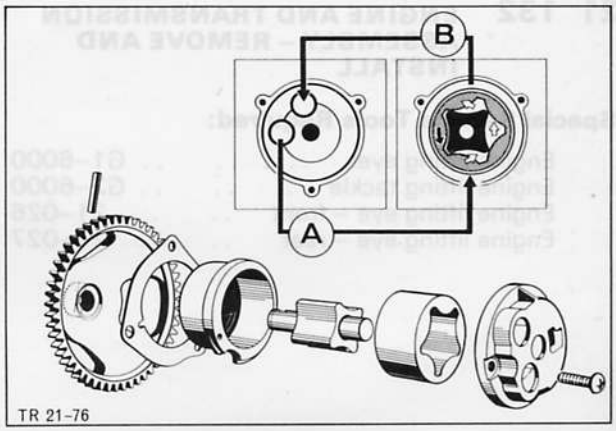



Fig. 10. Oil pump dismantled
A – Suction pipe
B – Pressure pipe

If pressures are outside these limits first eliminate oil pump, Fig. 10 or relief valve, Figs. 11 and 12, as possible sources of fault. The following faults can occur, e.g.:

Pressure too high at speeds over 2000 rev/min; Failure of relief valve to open because of fouling.

Pressure too low at all engine speeds: Clogged intake strainer, intake pipe loose or broken, oil pump worn, etc.

Pressure too low at low engine speeds: Relief valve jammed in open position due to dirt.


Fig. 11. Relief valve location (vacuum pump removed for clarity)

**To measure oil pressure**

1. Remove oil pressure switch connecting lead and remove oil pressure switch.
2. Connect test pressure gauge to engine block, using adaptors, if necessary.
3. Start engine and check oil pressure at idling speed and at over 2000 rev/min.
4. Remove test pressure gauge. Replace oil pressure switch and connect lead as specified in Technical data.

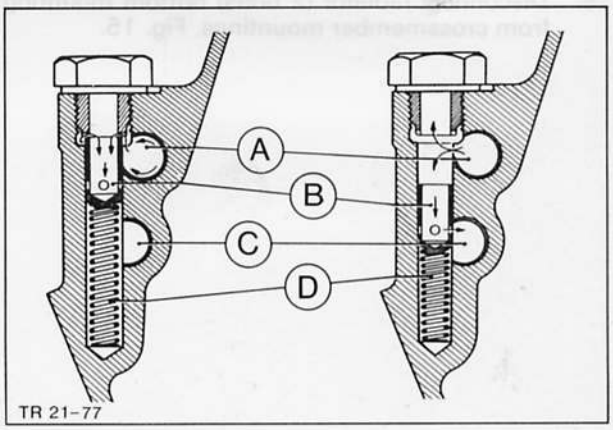



Fig. 12 Relief valve
A – Pressure pipe
B – Suction pipe
C – Valve plunger
D – Compression spring

## 21 132 ENGINE AND TRANSMISSION ASSEMBLY – REMOVE AND INSTALL

**Special Service Tools Required:**

| | |
|---|---|
| Engine lifting eyes | G1–6000 |
| Engine lifting tackle | G2–6000 |
| Engine lifting eye – front | 21–026 |
| Engine lifting eye – rear | 21–027 |

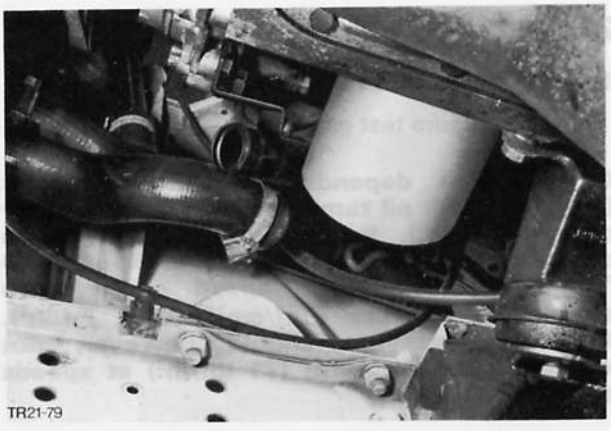



Fig. 13. Drain coolant

**To Remove**

1. Disconnect both battery earth cables, as well as positive lead from left-hand battery.
2. Disconnect washer assembly hoses from nozzles and retaining clamps and remove hood (4 bolts).
3. Drain coolant into tray, disconnecting lower radiator hose from water neck, Fig. 13, and upper hose from thermostat water neck and remove.
4. Remove coolant expansion tank connecting pipe (2 bolt), Fig. 14 and remove expansion tank complete with bracket from engine (3 bolts).

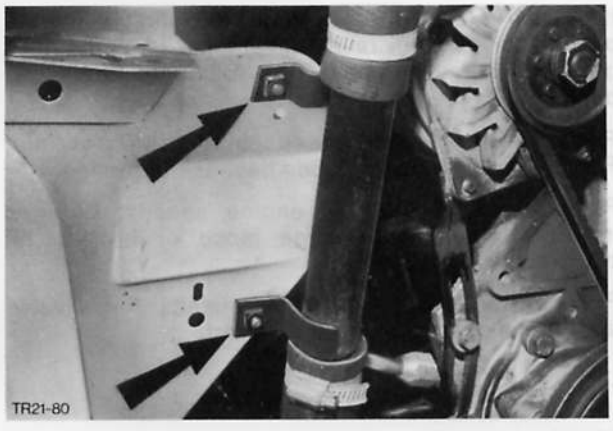



Fig. 14. Unscrew expansion tank connecting pipe

5. Disconnect radiator (2 bolts) bottom mounting from crossmember mountings, Fig. 15.

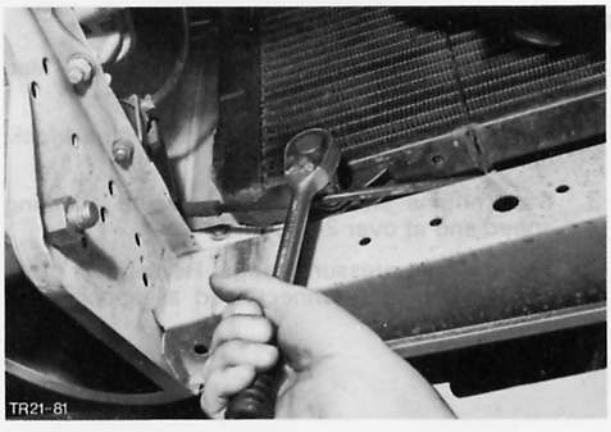



Fig. 15. Remove radiator bottom mounting from crossmember

6. Unhook hood cable at catch end (Fig. 16) and disconnect from radiator grille panel.

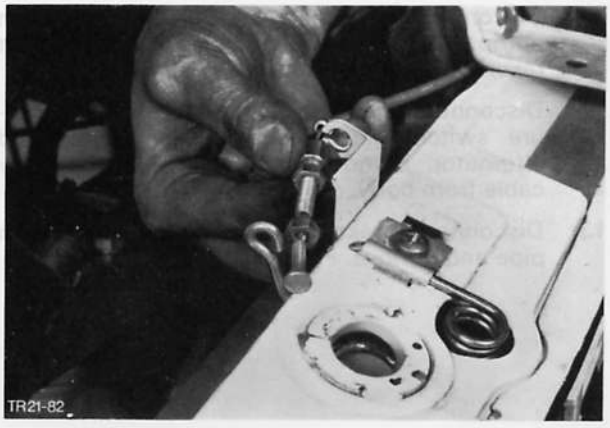



Fig. 16. Unhook hood cable

7. Remove right-hand and left-hand headlamp surround (1 bolt each).
8. Remove radiator grille panel complete with radiator and expansion tank, as well as connecting pipe, Fig. 17.


Fig. 17. Remove radiator grille panel complete with radiator, expansion tank and connecting pipe

9. Remove air cleaner (2 bolts).
10. Disconnect cables from shut-off motor and injection pump, Fig. 18.

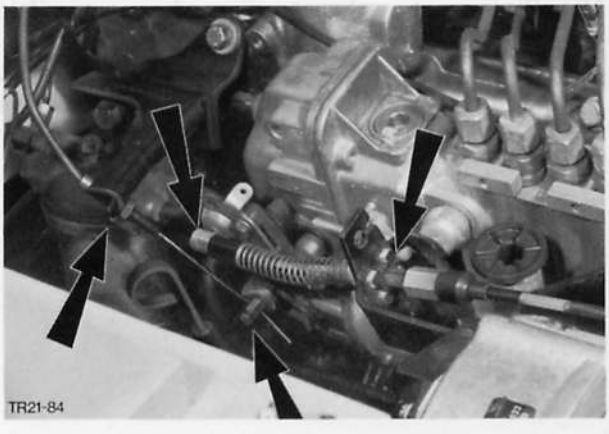



Fig. 18. Disconnect shut-off motor and injection pump cables

## 21 132 (cont'd)

11. Disconnect fuel feed and return line from pump and remove fuel filter and thermostart reservoir lines from intake manifold.
12. Disconnect temperature sender unit, oil pressure switch, glow plugs, starter motor and alternator. Remove positive left-hand battery cable from body.
13. Disconnect brake servo vacuum hose from pipe and remove, Fig. 19.

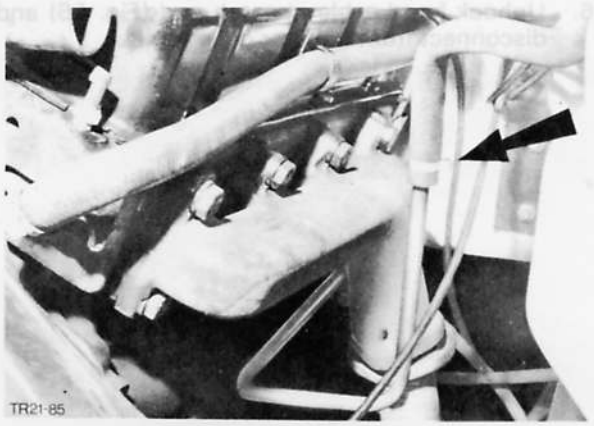



Fig. 19. Remove brake servo vacuum hose

14. Remove water drain neck and heater hoses from splash panel, Fig. 20.

Fig. 20. Remove heater hoses

15. Disconnect exhaust pipe from manifold (2 bolts).
16. Remove transmission gearshift lever mounting bracket (6 bolts) and raise gaiter. Remove gear shift lever cap nut, Fig. 21 and withdraw gearshift lever.

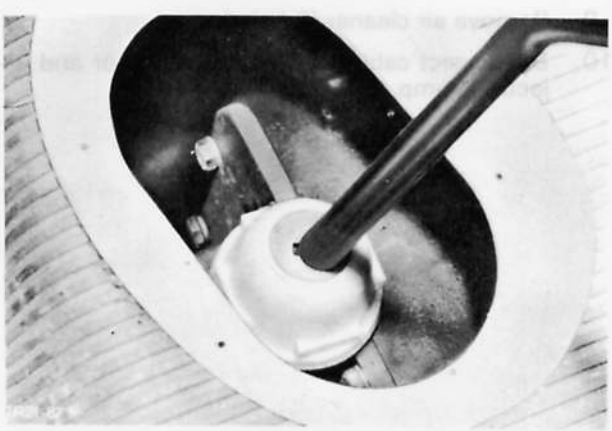


Fig. 21. Remove transmission gearshift lever nut

17. Remove clutch cable from pedal bracket, Fig. 22.

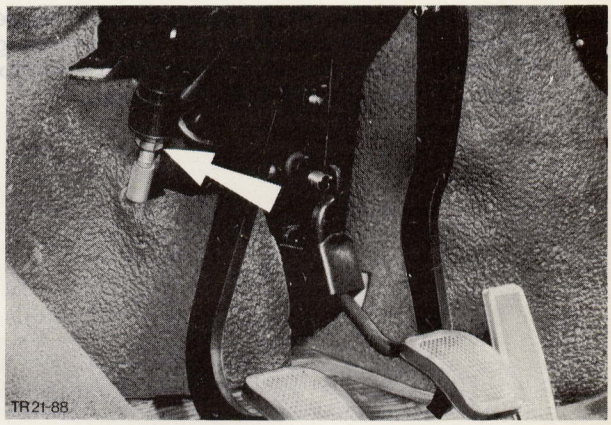



Fig. 22. Remove clutch cable from pedal bracket

18. Disconnect left-hand and right-hand earth cables from clutch housing and remove speedometer drive cable from transmission (1 bolt), Fig. 23.

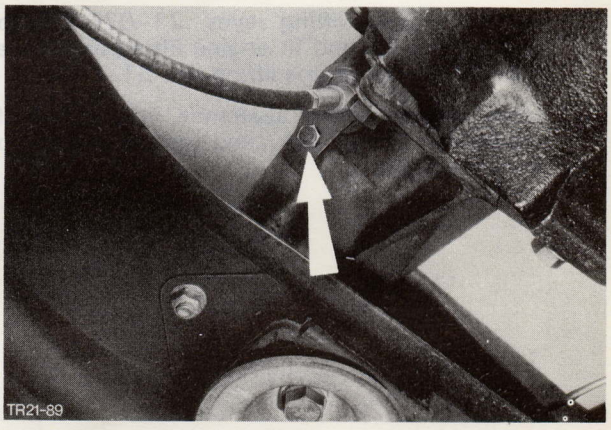



Fig. 23. Remove speedometer drive cable

19. Pull back gaiter and unhook clutch cable from release lever, Fig. 24.

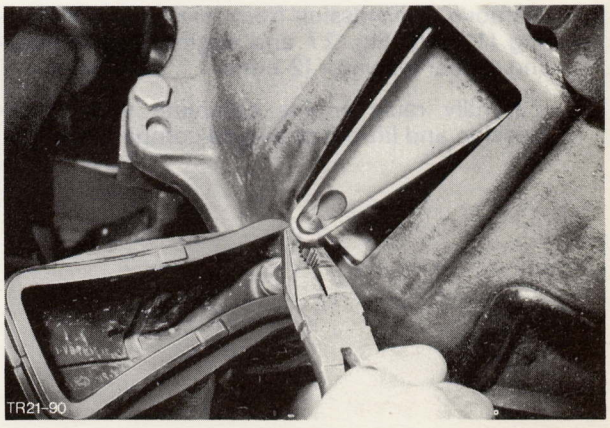



Fig. 24. Unhook clutch cable from release lever

## 21 132 (cont'd)

20. Disconnect drive shaft at rear axle flange (4 bolts), Fig. 25 and floor pan centre bearing (2 bolts), withdraw drive shaft from gearbox extension housing and fit blanking plug.

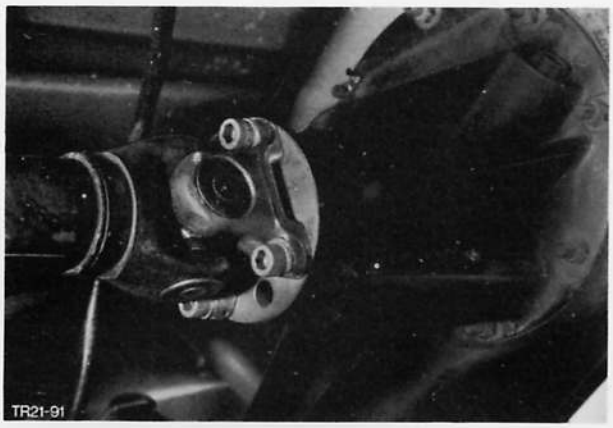



Fig. 25. Remove driveshaft

21. Attach engine lifting eyes 21–026/27 to engine, Fig. 26 and fit engine lifting appliance G2–6000 with engine lifting eye G1–6000.
22. Hook engine lifting appliance into standard workshop lifting jack and gently take up engine weight.

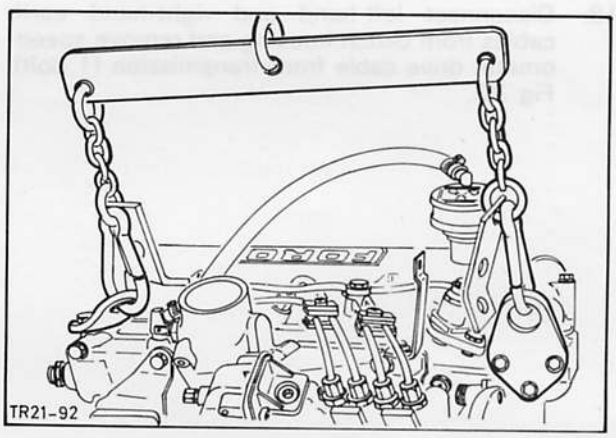



Fig. 26. Fit engine lifting eyes and lifting chain

23. Remove transmission from rear engine mounting (1 bolt), Fig. 27 and engine from mounting rubber insulator (2 nuts).
24. Carefully raise engine complete with transmission and lift out of engine compartment.

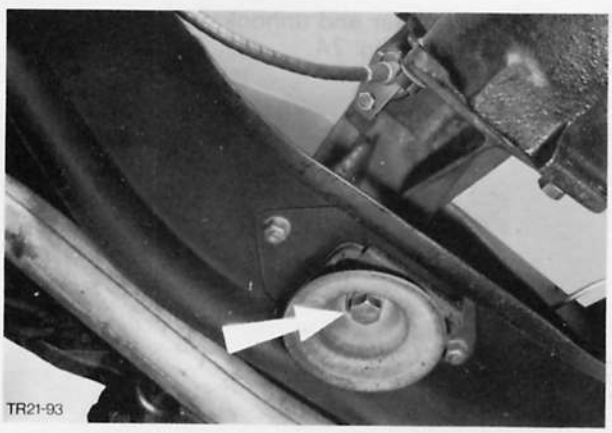



Fig. 27. Remove transmission from rear engine mounting

**To Install**

25. Carefully position engine complete with gearbox in engine compartment and fit on front and rear engine mounting. Tighten as specified in Technical data.
26. Remove engine lifting appliance.
27. Withdraw blanking plug from gearbox extension housing, carefully insert driveshaft and attach to rear axle flange and centre bearing as specified in Technical data, Fig. 28.

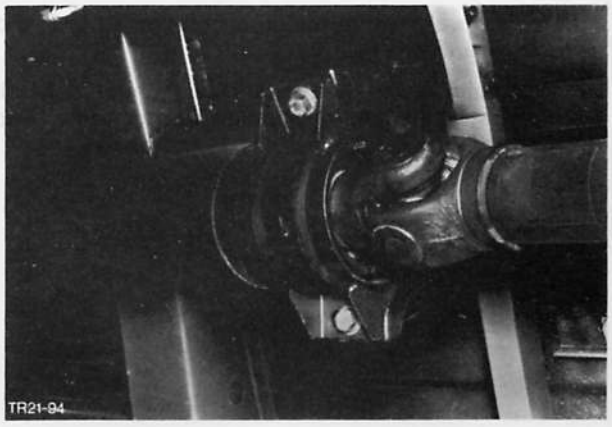



Fig. 28. Fit driveshaft centre bearing

28. Connect speedometer drive cable. Hook clutch cable into release lever and install gaiter. Fit earth cable left and right to clutch housing and attach left-hand battery positive lead to body.
29. Adjust clutch cable clearance at pedal bracket, Fig. 29.

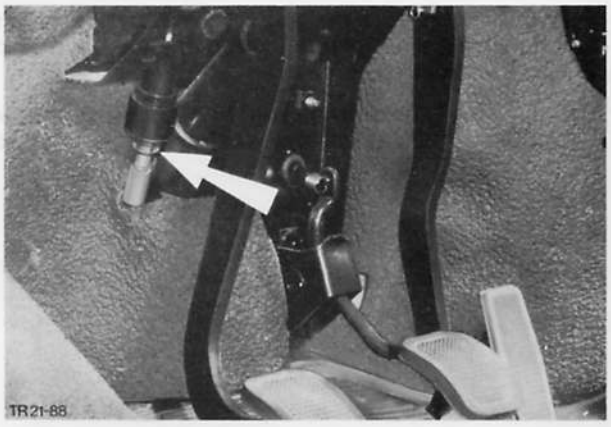



Fig. 29. Adjust clutch cable clearance

30. Install gearshift lever and tighten nut. Locate gaiter and fit mounting bracket.
31. Bolt exhaust pipe to manifold.
32. Fit heater hoses and water drain neck, Fig. 30.


Fig. 30. Fit water drain hose

## 21 132 (cont'd)

33. Slide brake servo vacuum hose on to line and secure, Fig. 31.
34. Connect leads to temperature sender unit, oil pressure switch, glow plugs, starter motor and alternator.

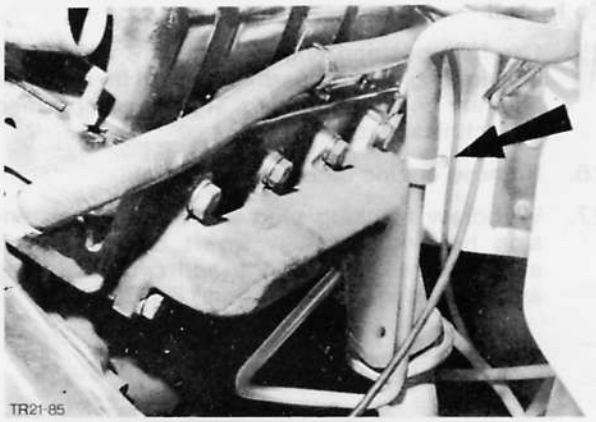



Fig. 31. Slide brake servo vacuum hose on to line and secure

35. Connect fuel filter and thermostart reservoir pipes to inlet manifold and fit fuel feed and return lines to pump.
36. Fit fuel injection pump and shut-off motor cables, then bleed the fuel system – refer to Op. 23 142, Fig. 32/33.

Fig. 32. Vent fuel-filter

37. Fit air cleaner.

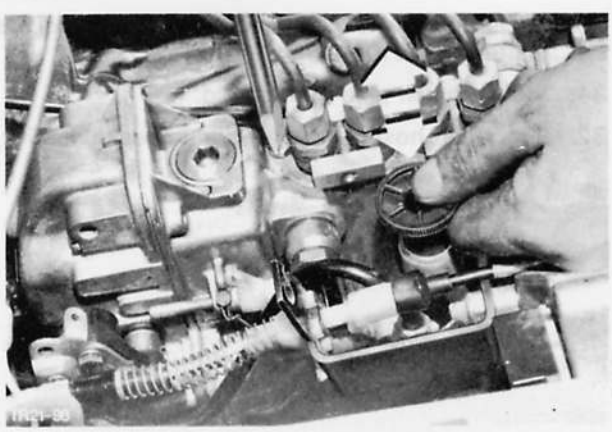


Fig. 33. Vent fuel pump

38. Insert radiator grille panel complete with radiator and expansion tank and secure, Fig. 34. Fit both headlamp surrounds.

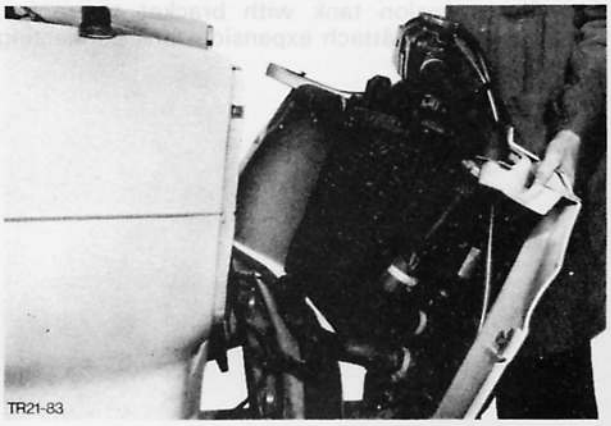



Fig. 34. Install radiator grille panel complete with radiator. connecting pipe and expansion tank

39. Hook hood cable into catch, Fig. 35 and fit to radiator grille panel.

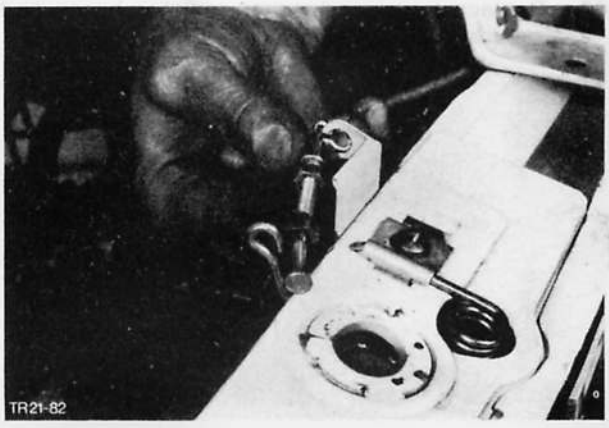



Fig. 35. Fit hood cable

40. Replace radiator at bottom location to cross-member mountings, Fig. 36.

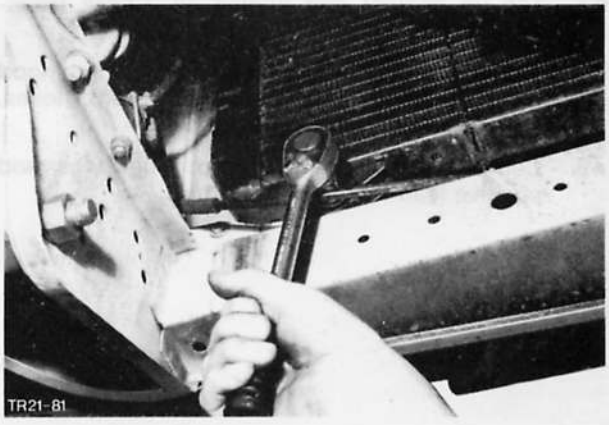



Fig. 36. Fit radiator at bottom location

## 21 132 (cont'd)

41. Fit expansion tank with bracket to engine, Fig. 37 and attach expansion tank connecting pipe.

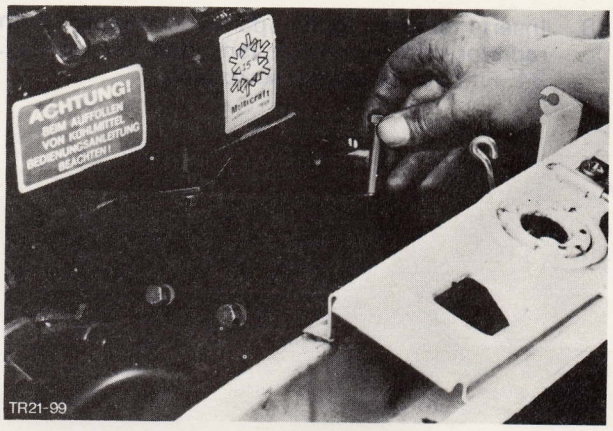



Fig. 37. Fit expansion tank

42. Replace lower and upper radiator hoses and secure, Fig. 38.

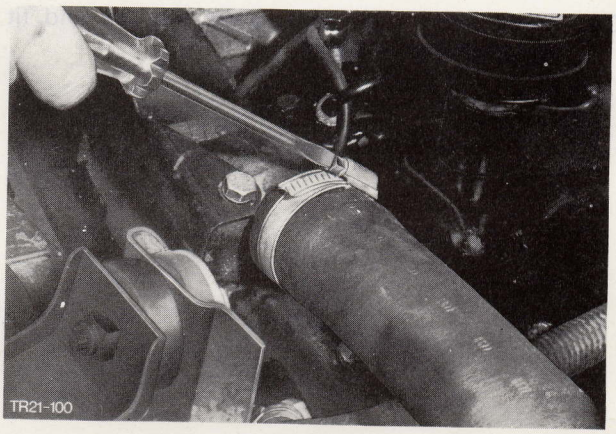



Fig. 38. Fit upper radiator hoses and secure

43. Top up coolant and engine oil. Check transmission oil level and top up, if required.
44. Position hood, hand-tighten bolts, align hood and secure. Position washer system hoses, Fig. 39 and slide on to nozzles.
45. Connect earth cables to both batteries and positive lead to left-hand battery.

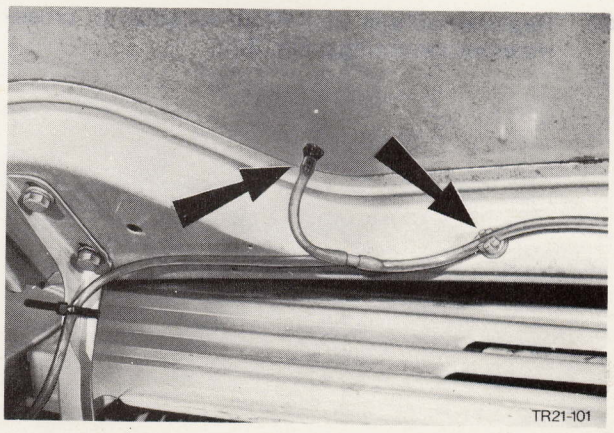
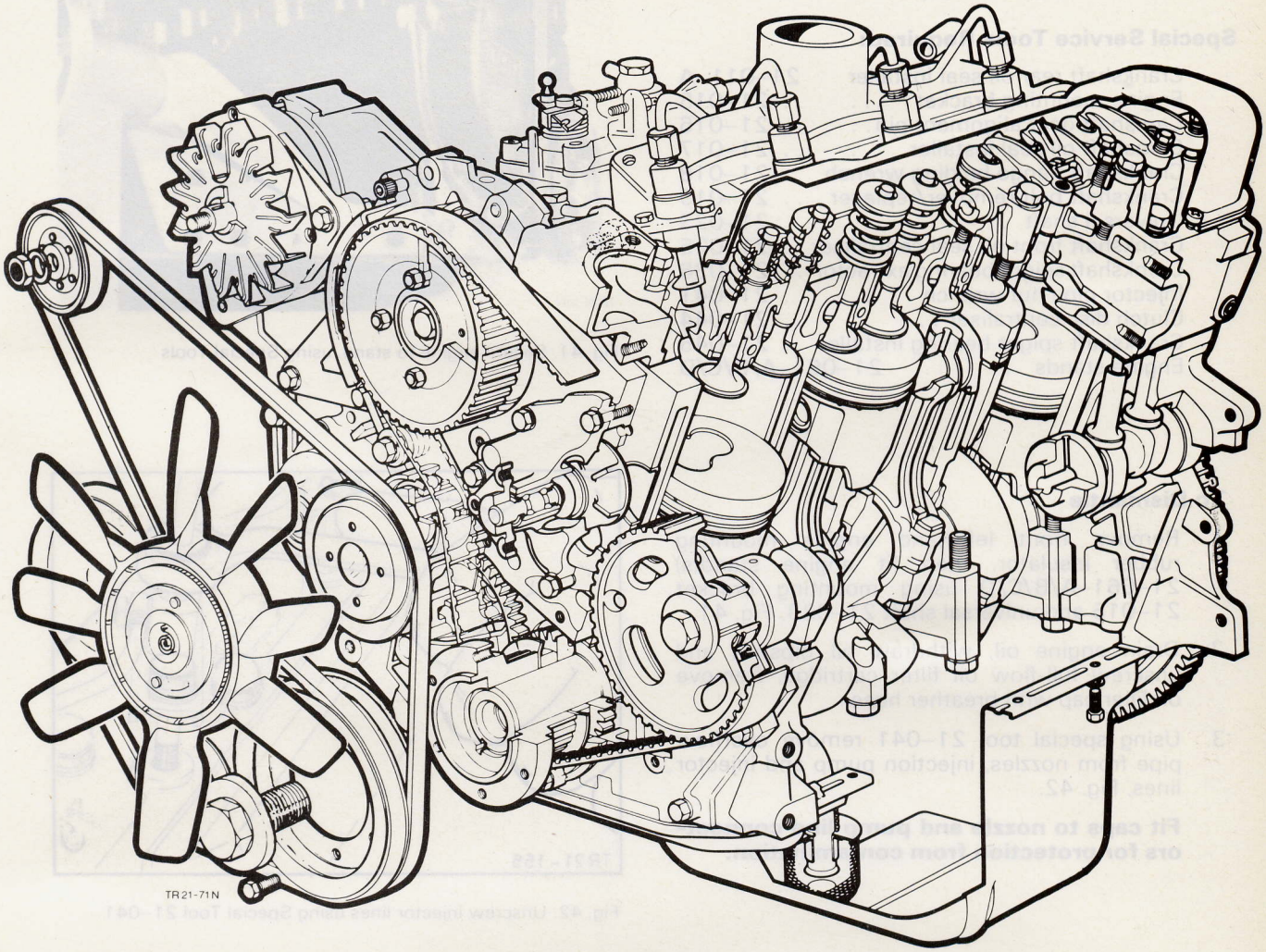



Fig. 39. Position washer system hoses

21 134 8




TR 21-71

Fig. 40. 'G' Engine cutaway

## 21 134 8 ENGINE – DISMANTLE AND REASSEMBLE (ENGINE REMOVED)

**Special Service Tools Required:**

| | |
|---|---|
| Crankshaft rear oil seal installer | 21–011–A |
| Engine mounting bracket | 21–015 |
| Camshaft gear alignment pin | 21–016 |
| Camshaft oil seal installer | 21–017 |
| Crankshaft flange holding wrench | 21–018 |
| Crankshaft bolt remover/replacer | 21–019 |
| Universal shaft | 21–023 |
| Crankshaft front oil seal centraliser | 21–025 |
| Crankshaft spigot bearing extractor | 21–036 |
| Injector pipe nut wrench | 21–041 |
| Clutch disc centraliser | 21–044 |
| Crankshaft spigot bearing installer | 21–045 |
| Engine stands | 21–061–A/B/C/D |

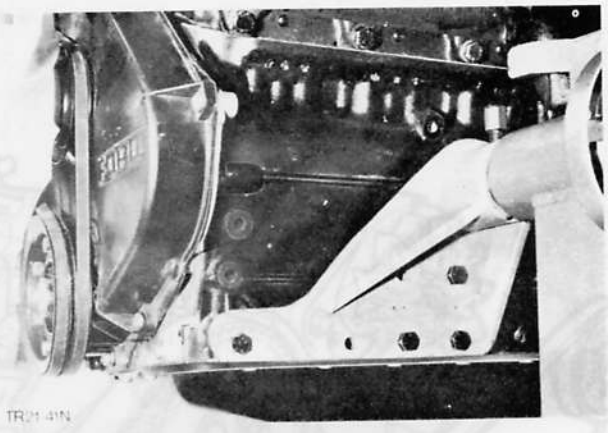


Fig. 41. Secure engine to stand, using Special Tools

**To Dismantle**

1. Remove front left-hand engine mounting rubber insulator, then fit engine stand(s) 21–061–A/B/C/D using mounting bracket 21–015 and universal shaft 21–023, Fig. 41.
2. Drain engine oil, withdraw oil dipstick and unscrew full-flow oil filter cartridge. Remove oil filler cap with breather hose.
3. Using special tool 21–041 remove overflow pipe from nozzles, injection pump and injector lines, Fig. 42.

   **Fit caps to nozzle and pump line connectors for protection from contamination.**

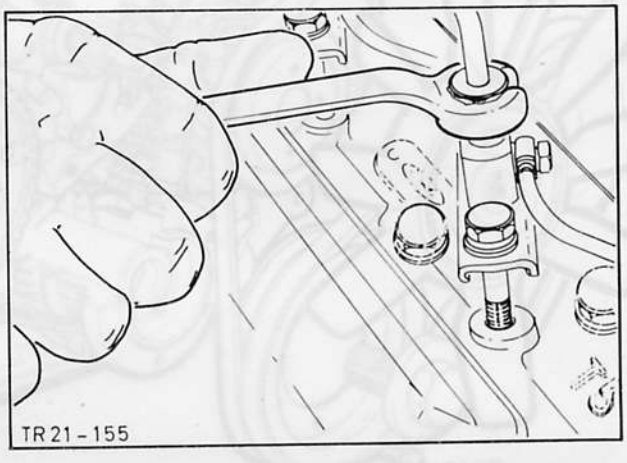



Fig. 42. Unscrew injector lines using Special Tool 21–041

4. Remove injection pump filter fuel lines and engine vacuum pump air line.
5. Remove fuel filter complete with bracket (3 bolts), Fig. 43.

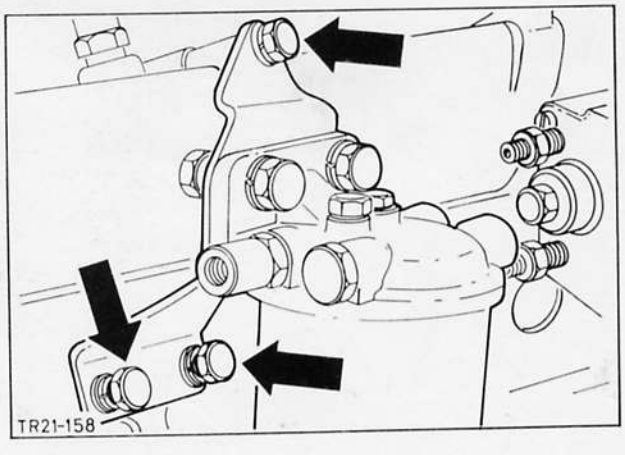



Fig. 43. Remove fuel filter with bracket

6. Slacken vacuum pump V-belt tension roller Fig. 44 and alternator V-belt adjuster, then remove both V-belts.
7. Remove alternator complete with bracket (4 bolts).
8. Remove fan with pulley (4 bolts).
9. Remove crankshaft pulley (6 bolts).

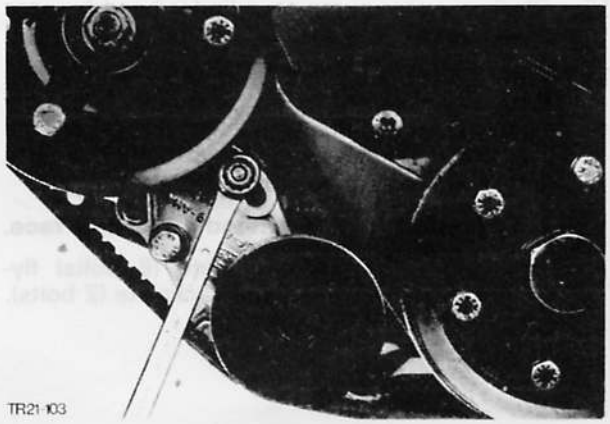



Fig. 44. Slacken vacuum V-belt tension roller

10. Remove upper and lower toothed belt cover bolts and remove cover, Fig. 45.
11. Remove rocker cover (6 bolts).
12. Remove three lower then five upper rocker support bracket bolts. Remove rocker shaft and withdraw push rods.

    **Do not interchange push rods when removing and installing.**

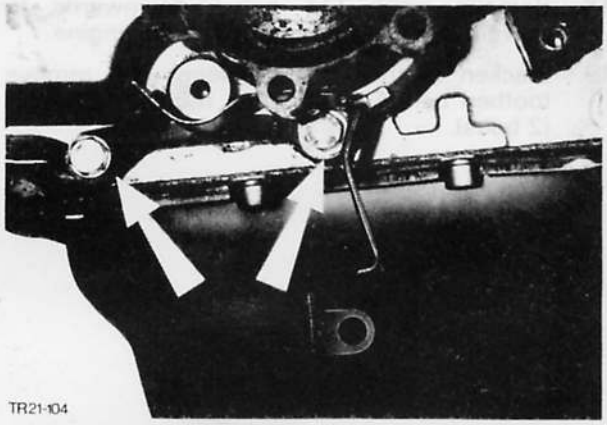



Fig. 45. Remove lower toothed belt cover

13. Remove injector nozzles (2 bolts each), then lift out nozzle holder sealing rings and heat balancing plate. Withdraw heat shields and gaskets, using 2 screwdrivers.
14. Remove water neck (2 bolts) and lift out thermostat, noting location, Fig. 46.

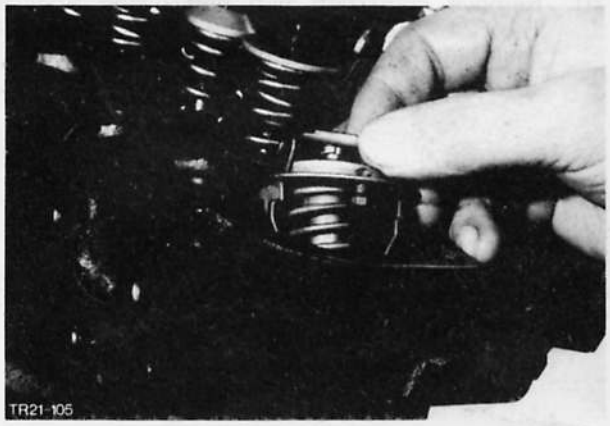



Fig. 46. Remove thermostat

## 21 134 8 (cont'd)

15. Slacken water pump to cylinder head by-pass hose, Fig. 47.
16. Remove cylinder head bolts (18), unscrewing them in reverse order from that in which they were tightened (for tightening sequence see Fig. 90). Lift off cylinder head complete with inlet and exhaust manifolds.

    **Do not place cylinder head on gasket face.**
17. Remove clutch pressure plate (6 bolts) flywheel (8 bolts), and engine backplate (2 bolts).

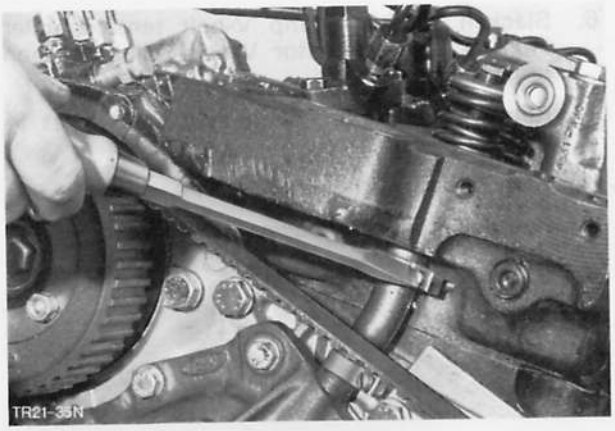



Fig. 47. Slacken by-pass hose

18. Remove sump (24 bolts) downwards to prevent sludge or swarf getting into engine.
19. Slacken toothed belt tensioner and remove toothed belt, Fig. 48, then remove tensioner (2 bolts).

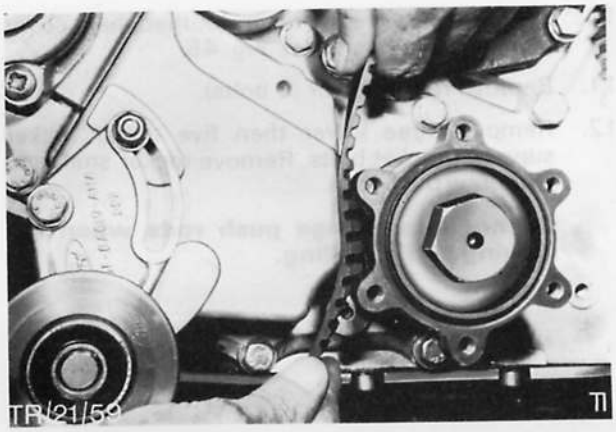



Fig. 48. Remove toothed belt

20. Remove crankshaft hub bolt, using Special Tool 21–018/019, Fig. 49. Remove crankshaft hub using standard extractor.

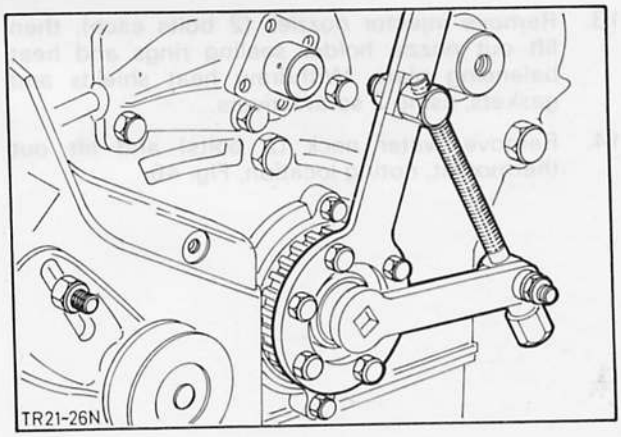



Fig. 49. Slacken crankshaft hub bolt using Special Tool 21–018/019

21. Lock camshaft toothed belt gear with Special Tool 21–016, Fig. 50. Unscrew bolt and press off gear using two levers.

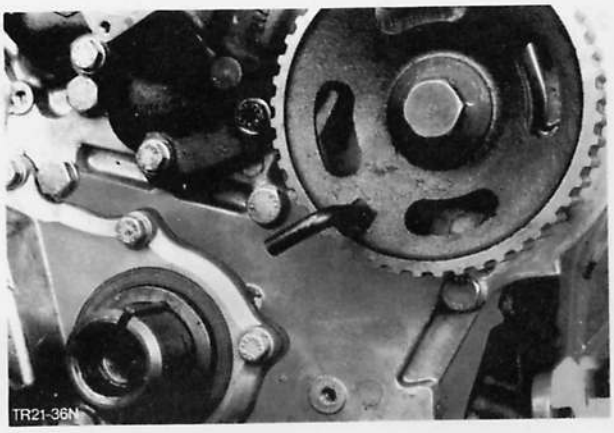



Fig. 50. Lock camshaft toothed belt gear using Special Tool 21–016

22. Remove water pump with by-pass hose from intermediate plate (7 bolts), Fig. 51.

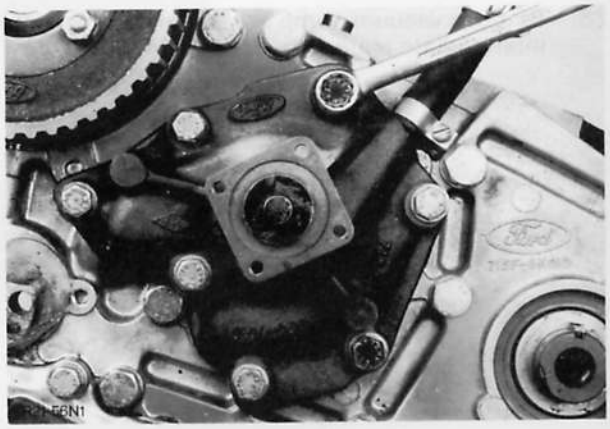


Fig. 51. Remove water pump

23. Remove vacuum pump pulley, Fig. 52, using standard extractor if necessary.

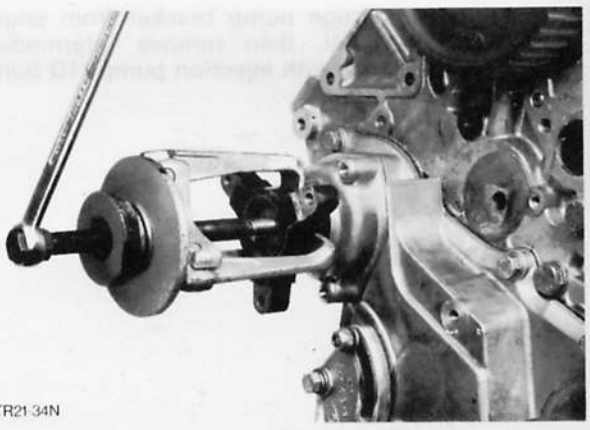



Fig. 52. Remove vacuum pump pulley

## 21 134 8 (cont'd)

24. Remove front cover from intermediate plate (10 bolts).

25. Remove oil pump with mounting (3 bolts) from engine block, Fig. 53.

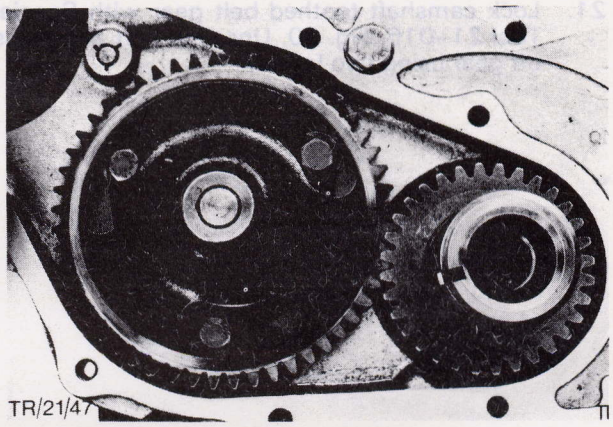



Fig. 53. Remove oil pump

26. Remove vacuum pump bracket and pump from intermediate plate (3 bolts) Fig. 54.

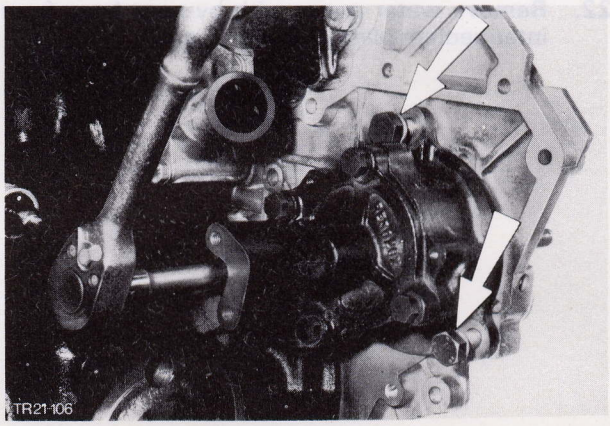



Fig. 54. Remove vacuum pump

27. Remove injection pump bracket from engine block (2 bolts), then remove intermediate plate complete with injection pump (10 bolts), Fig. 55.

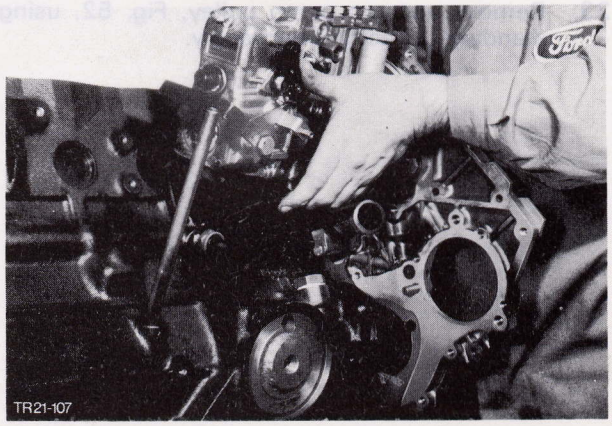



Fig. 55. Remove injection pump and intermediate plate

28. Remove camshaft and crankshaft spacer, as well as crankshaft gear, by hand.
29. Withdraw crankshaft spigot bearing, using Special Tool 21–036, Fig. 56.

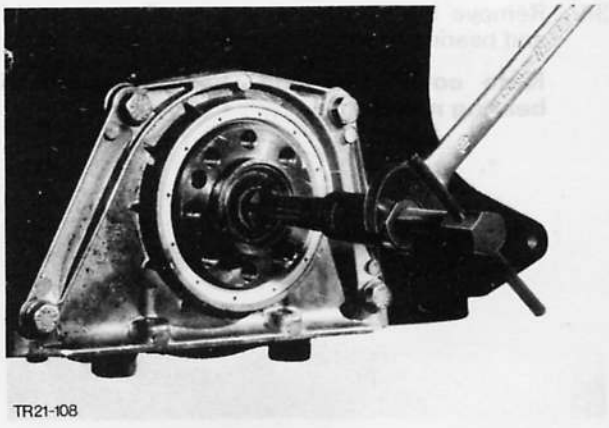



Fig. 56. Remove crankshaft needle bearing using Special Tool 21–036

30. Remove crankshaft rear oil seal carrier (4 bolts), Fig. 57.
31. Remove camshaft rear cover plate bolts (3) and camshaft thrust plate bolts (2), Fig. 58. Remove plates and carefully withdraw camshaft.

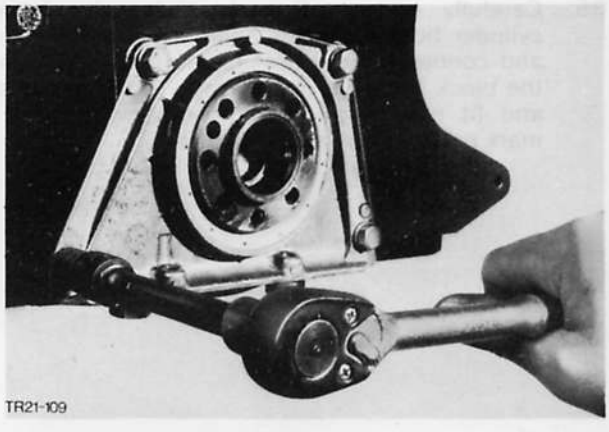



Fig. 57. Remove crankshaft oil seal carrier

32. Remove tappets from engine block.

    **Do not interchange tappets when removing and installing.**
33. Remove oil pump suction pipe (2 bolts).

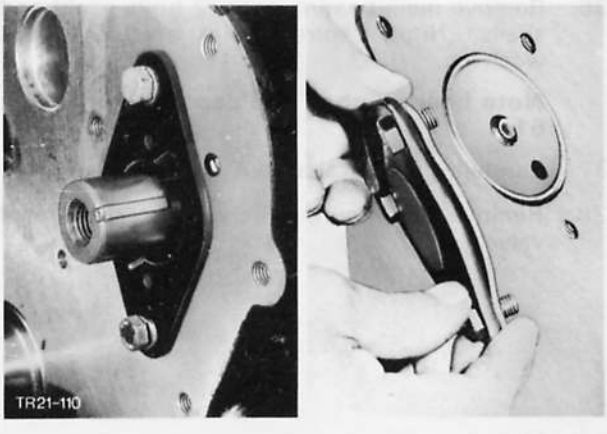



Fig. 58. Remove camshaft thrust plate

## 21 134 8 (cont'd)

34. Remove big end bearing caps (2 nuts each) and bearing shells.

**Note connecting rod, bearing cap and bearing markings.**

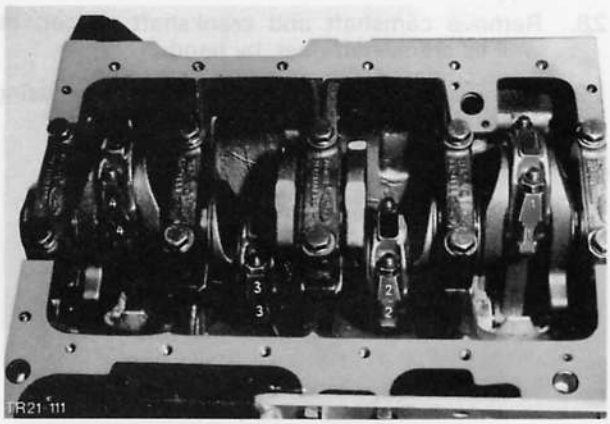



Fig. 59. Big end journal markings

35. Carefully scrape off carbon deposits from cylinder bore top ends, then withdraw piston and connecting rod assemblies upwards from the block. Remove piston rings, clean grooves and fit new rings into grooves, with 'TOP' mark pointing upwards, Fig. 60.

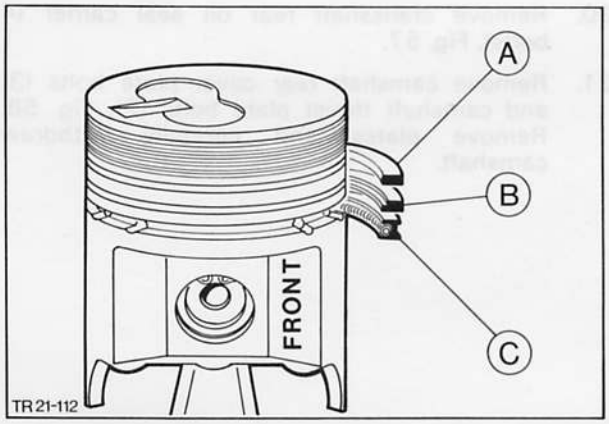



Fig. 60. Fit piston rings
A – Upper piston ring
B – Lower stepped ring
C – Oil scraper ring

36. Remove main bearing caps (2 bolts each) and shells. Note centre main bearing thrust washers.

**Note bearing shell and cap markings, Fig. 61.**

37. Carefully lift crankshaft out of engine block.

38. Remove oil pressure switch and pressure relief valve.

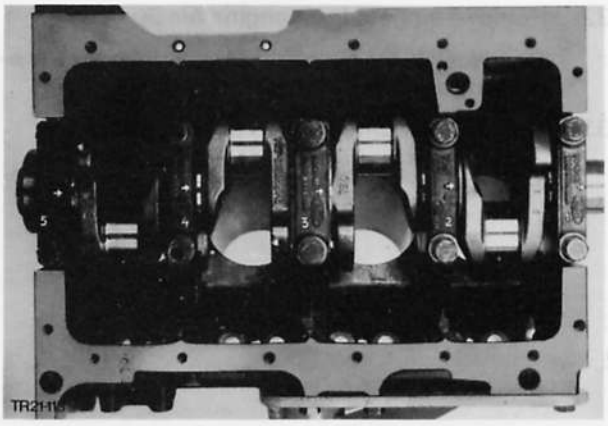



Fig. 61. Main bearing markings

### To Reassemble

**The type and degree of cleaning of a given part before reassembly must depend on the hours the engine has run, the extent of any damage and its possible re-use. This applies particularly to the cylinder block with its corners, angles and bores. If necessary, remove all plugs and covers and clean their seats, using suitable cleaning agents and tools (brushes, scrapers). The oil galleries in particular, e.g. in the cylinder block, cylinder head, etc., should be free from dirt and abrasive particles, Fig. 62. If press-fit plugs and screw plugs are removed, they, like all seals and gaskets, should be renewed.**

### Measuring Bearing Clearance

Measuring bearings (even with undersize crankshafts) can be eliminated and determination of required bearing shells can be considerably simplified by use of:

'PLASTIGAGE' made by:
PERFECT CIRCLE CORPORATION,
HAGERSTOWN, INDIANA, USA.

UK supplier:
Norman Gaydon (International) Ltd.,
68 London Road,
Southend-on-Sea,
Essex, SS1 1PG.

West German supplier:
K. H. ERN,
Schinkelstrasse 46–48,
Dusseldorf.

'PLASTIGAGE' is the name of an accurately calibrated plastic filament.

| Type | Colour | Measuring range |
|---|---|---|
| PG-1 | green | 0,025–0,075 mm (0,001–0,003 in) |
| PR-1 | red | 0,050–0,150 mm (0,002–0,006 in) |
| PB-1 | blue | 0,100–0,230 mm (0,004–0,01 in) |

### Requirements for use of 'Plastigage'

1. Bearing should be dry and clean.
2. Crankshaft should not be turned during measuring operation.
3. Points of measurement should be close to top dead centre position.
4. Bearing caps should not be seated with hammer blows.

Place length of Plastigage across width of bearing on crankshaft or big end journal. Fit main or big end bearing cap together with bearing shells and torque as specified. The plastic filament will be compressed more or less depending on bearing clearance. Remove bearing cap.

**Each main bearing should be measured separately without other bearing caps being fitted.**

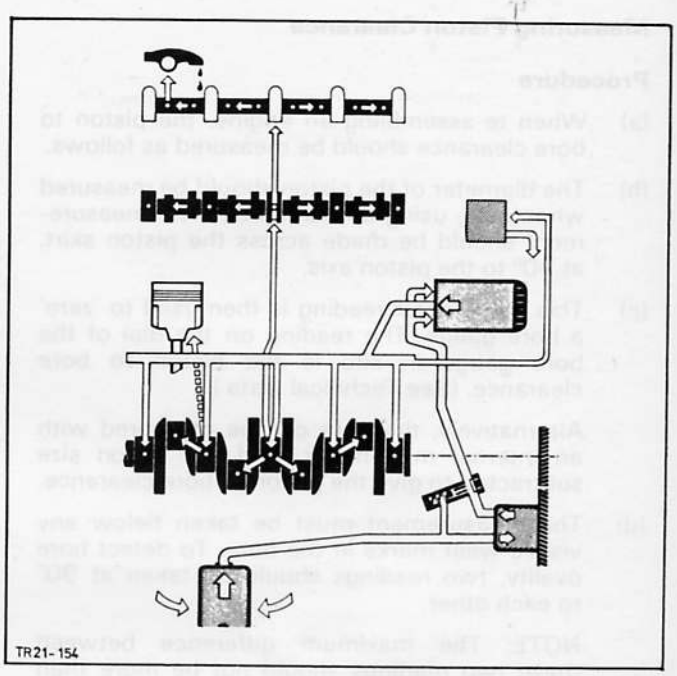



Fig. 62. Oil circuit

Width of compressed plastic filament can be measured by means of scale printed on PLASTIGAGE pack, Fig. 63; reading shows bearing clearance.

**Only bolts in good condition should be used for securing bearing caps on crankshaft and they should not be tightened in excess of specified torque.**

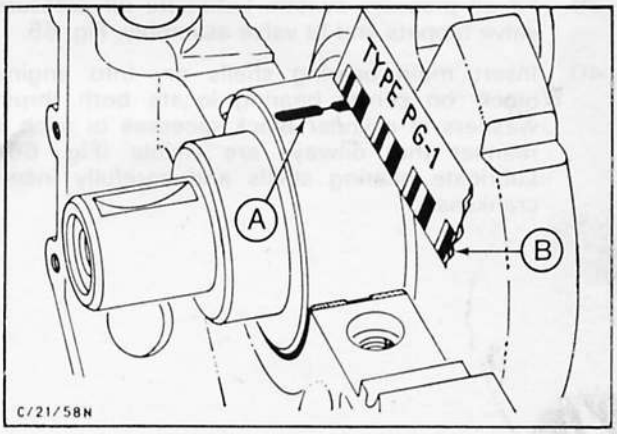



Fig. 63. Measuring bearing play
A – Compressed plastic thread
B – Measurement scale

## 23 134 8 (cont'd)

### Measuring Piston Clearance

**Procedure**

(a) When re-assembling an engine, the piston to bore clearance should be measured as follows.

(b) The diameter of the piston should be measured when cold, using a micrometer. The measurement should be made across the piston skirt, at 90° to the piston axis.

(c) This micrometer reading is then used to 'zero' a bore gauge. The reading on the dial of the bore gauge in situ is the piston to bore clearance. (See Technical Data.)

Alternatively, the bore can be measured with an internal micrometer, and the piston size subtracted to give the piston to bore clearance.

(d) The measurement must be taken below any visible wear marks in the bore. To detect bore ovality, two readings should be taken at 90° to each other.

NOTE: The maximum difference between these two readings should not be more than 0,025 mm (0,001 in).

(e) Inspect the bores for visible wear, damaged lips, etc.

(f) If the clearance in sub-section (c) above is excessive, or if ovality, or any of the faults in sub-section (e) above is detected, the block should be rebored to suit oversize pistons.

(g) Before installing pistons, check piston ring gaps, (Fig. 64).

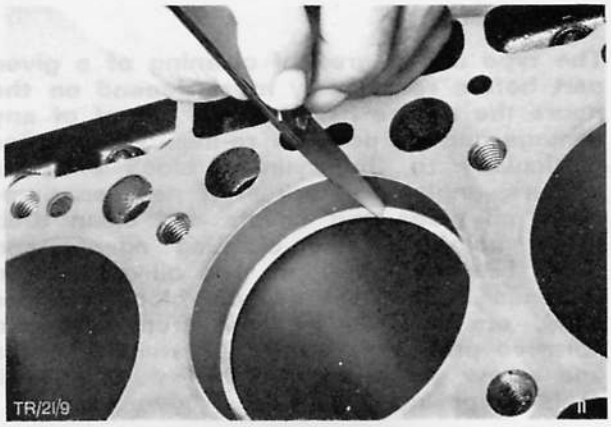



Fig. 64. Check piston ring gap

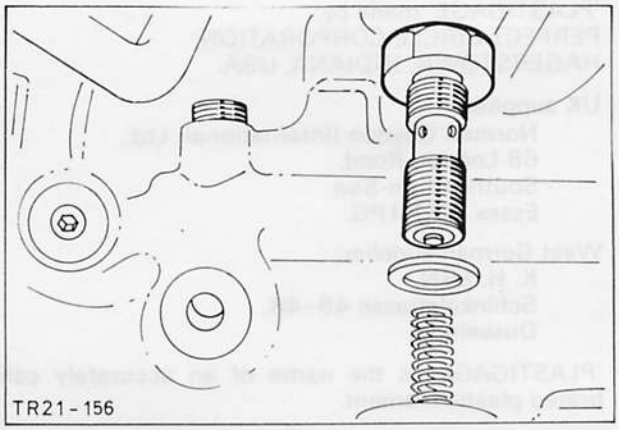



Fig. 65. Fit oil pressure switch

39. Fit oil pressure switch. Lubricate oil pressure valve tappets and fit valve assembly, Fig. 65.

40. Insert main bearing shells dry into engine block, on centre bearing locate both thrust washers in cylinder block recesses in such a manner that oilways are visible (Fig. 66). Lubricate bearing shells and carefully insert crankshaft.

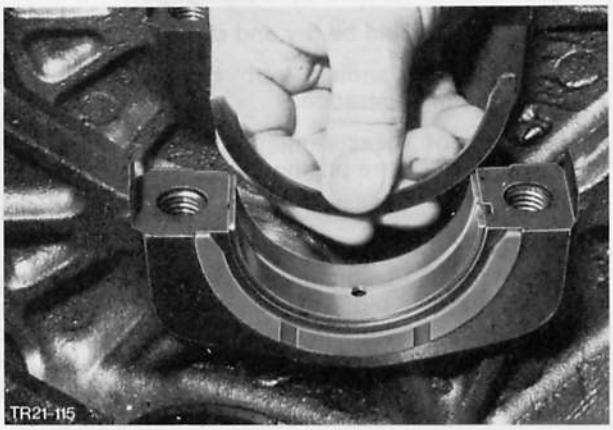



Fig. 66. Fit thrust washers

41 (a) Refit main bearing cap complete with lubricated bearing shells, again paying attention to correct location of thrust half washers on centre main bearing cap, Fig. 67. Tighten bearing cap bolts as specified in Technical Data.

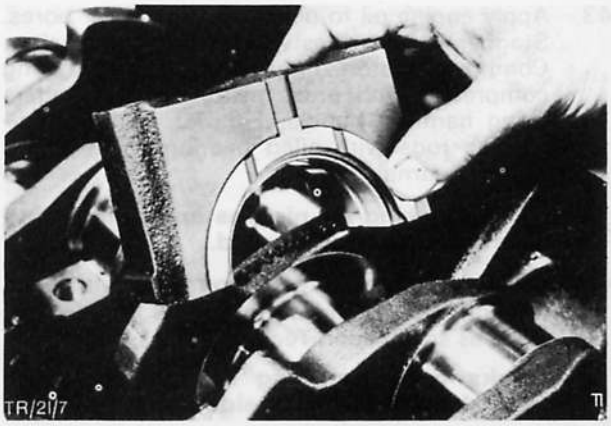



Fig. 67. Fit centre bearing with thrust washers

(b) Fit centre main bearing cap bolts finger-tight only. Press crankshaft first to rear against stop, then slowly and firmly against front stop and hold in position and torque bolts, Fig. 68. (This operation is necessary to ensure uniform seating of thrust washers.)

**Main bearing caps should be fitted with arrow pointed forward.**


Fig. 68. Align thrust washers

42. Check crankshaft end float using standard dial indicator, Fig. 69. Use oversize thrust washers, if necessary.

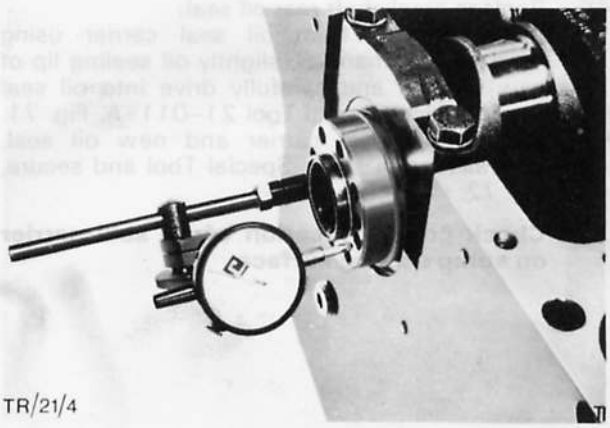



Fig. 69. Check crankshaft end float

## 21 134 8 (cont'd)

43. Apply engine oil to pistons and cylinder bores. Stagger piston rings with maximum spacing. Compress piston rings with standard ring compressor and press pistons into cylinders using hammer handle, Fig. 70, guiding connecting rods with oiled bearing shells on to big end journals by hand.

    **Front marking on pistons and connecting rods should point forward.**

44. Fit big end bearing caps complete with oiled bearing shells and torque new self-locking bolts as specified in Technical Data.

    **Marks on connecting rods and bearing caps should be on one side.**

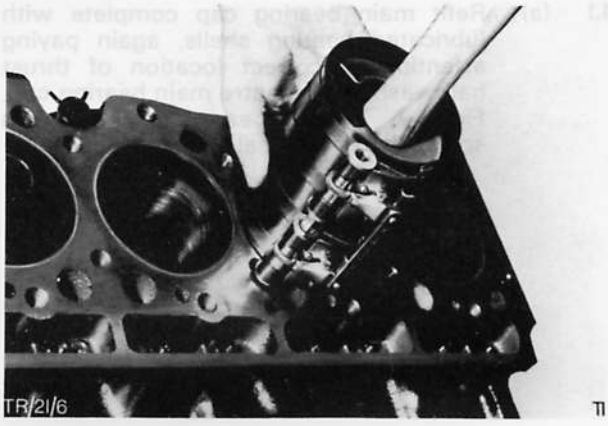



Fig. 70. Fit piston using standard ring compressor

45. Oil valve tappets and fit into same bores as on removal. Oil and carefully insert camshaft, paying attention to correct location of camshaft oil gallery sealing balls. Fit cover plate and thrust plate.


Fig. 71. Press in crankshaft rear oil seal using Special Tool 21–011–A

46. Replace crankshaft rear oil seal:
    Drive oil seal from oil seal carrier using hammer and mandrel, slightly oil sealing lip of new oil seal and carefully drive into oil seal carrier, using Special Tool 21–011–A, Fig. 71. Then fit oil seal carrier and new oil seal, centralise with same Special Tool and secure, Fig. 72.

    **Check correct location of oil seal carrier on sump sealing surface.**

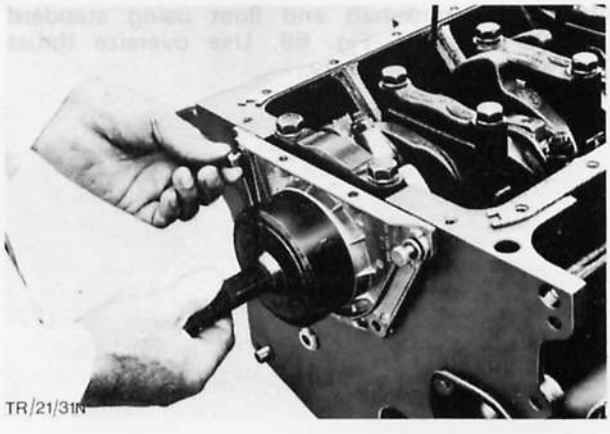



Fig. 72. Centralise rear oil seal carrier using Special Tool 21–011–A

47. Fit oil pump suction pipe with new gasket.

48. Fit crankshaft needle bearing using Special Tool 21–045, Fig. 73.

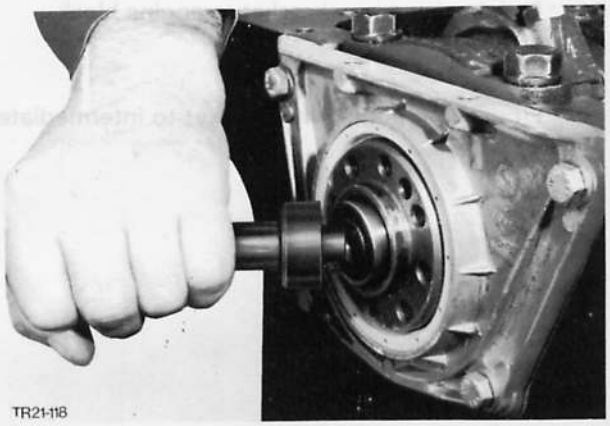



Fig. 73. Fit crankshaft needle bearing using Special Tool 21–045

49. Fit crankshaft gear.

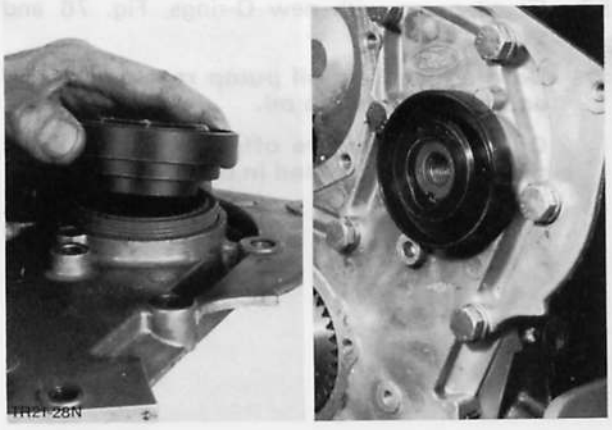



Fig. 74. Fit camshaft oil seal in intermediate plate using Special Tool 21–017

50. Replace camshaft oil seal:
Drive oil seal from intermediate plate using hammer and mandrel, slightly oil sealing lip of new oil seal and carefully draw into intermediate plate using Special Tool 21–017 with bolt and washer, Fig. 74. Then fit intermediate plate with new gasket complete with injection pump (also with new O-rings), centralise with same Special Tool, fit bolts in correct sequence as specified in Technical Data, Fig. 75.

**Check correct location of intermediate plate on oil sump sealing face.**

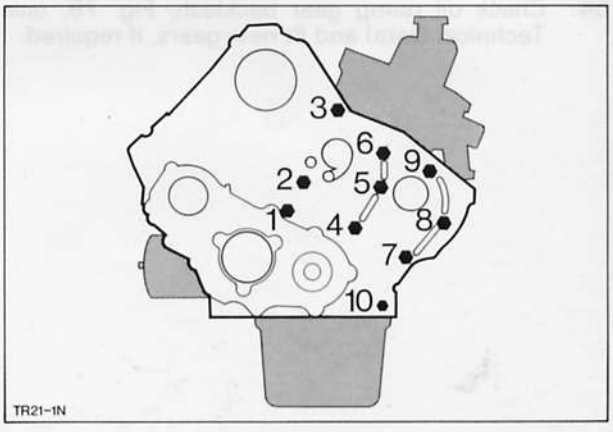



Fig. 75. Intermediate plate bolt tightening sequence

## 21 134 8 (cont'd)

51. Fit injection pump bracket to engine block.

52. Fit vacuum pump with bracket to intermediate plate.

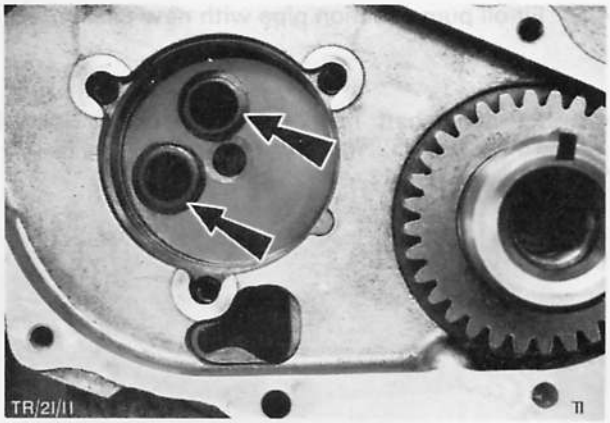



Fig. 76. Fit oil pump O-rings

53. Fit oil pump with new O-rings, Fig. 76 and secure, Fig. 77.

**Before installing oil pump rotate by hand and fill with engine oil.**

**Oil pump bores are offset and pump can therefore be installed in one position only.**

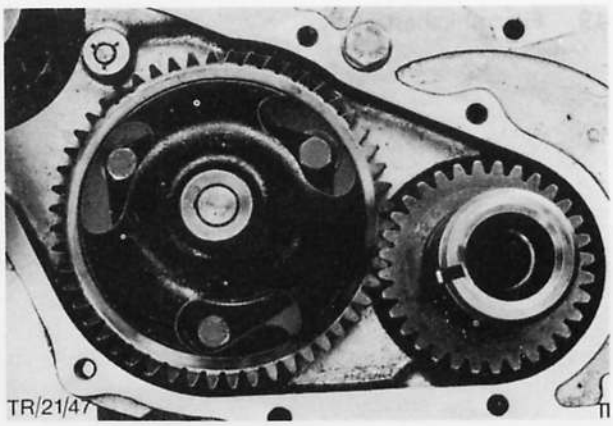



Fig. 77. Fit oil pump

54. Check oil pump gear backlash, Fig. 78, (see Technical Data) and fit new gears, if required.

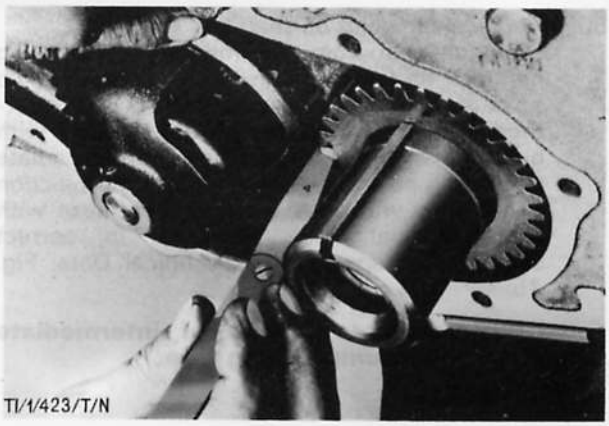



Fig. 78. Check oil pump gear backlash

55. Replace crankshaft front oil seal:
Drive oil seal out of timing cover using hammer and mandrel. Slightly oil sealing lip of new oil seal, carefully drive into timing cover, using Special Tool 21–025, Fig. 79, then fit timing cover and new gasket to intermediate plate. Centralise with same Special Tool, Fig. 80 and secure, fitting bolts coated with sealing compound.

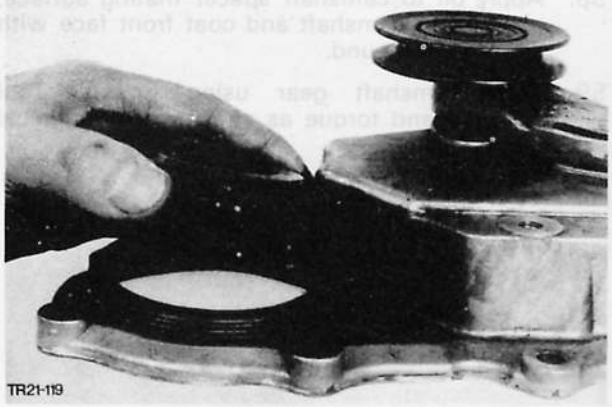



Fig. 79. Fit crankshaft front oil seal to timing cover, using Special Tool 21–025

56. Fit vacuum pump pulley and hub.

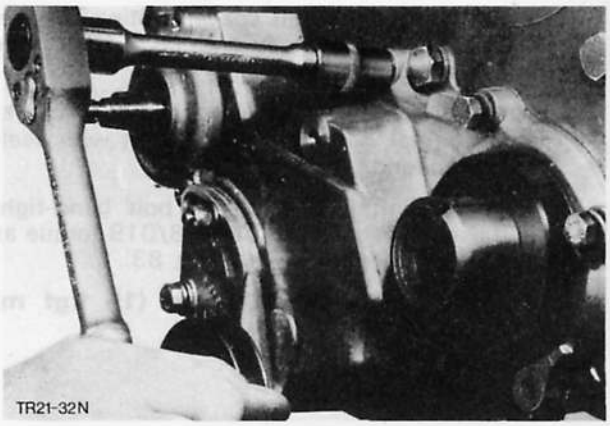



Fig. 80. Centralise timing cover using Special Tool 21–025

57. Fit water pump with new gasket to intermediate plate, Fig. 81.

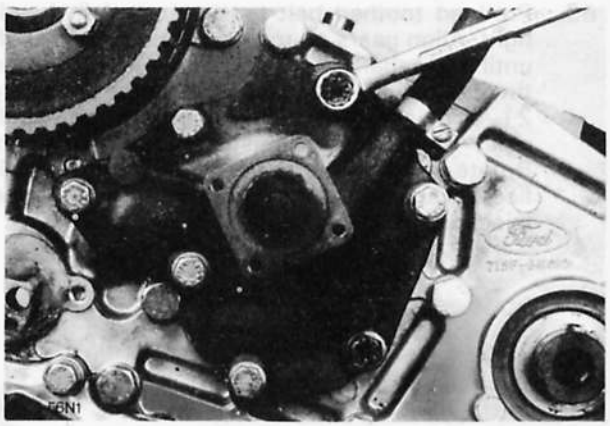



Fig. 81. Fit water pump

## 21 134 8 (cont'd)

58. Apply oil to camshaft spacer mating surface, slide on to camshaft and coat front face with sealing compound.

59. Lock camshaft gear using Special Tool 21–016 and torque as specified in Technical Data, Fig. 82.

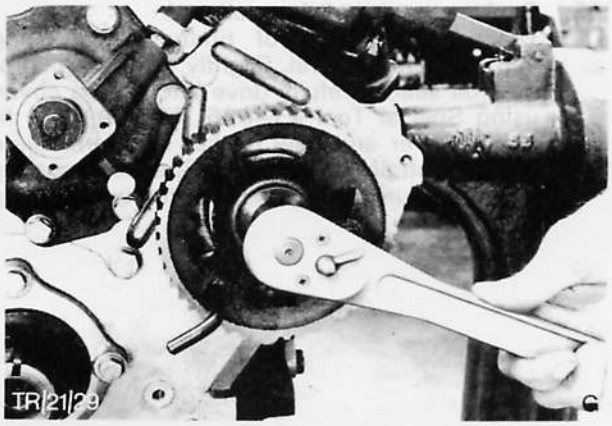



Fig. 82. Lock camshaft gear using Special Tool 21–016 and secure

60. Apply oil to crankshaft spacer mating surface, slide on to crankshaft and coat front face with sealing compound.

61. Fit toothed belt thrust washer and fit crankshaft journal, coating inside of bolt with sealing compound.

62. Fit crankshaft journal centre bolt hand-tight and using Special Tool 21–018/019 torque as specified in Technical Data, Fig. 83.

**10 spindle turns = 150 Nm (15 kgf m) (108 lbf ft).**

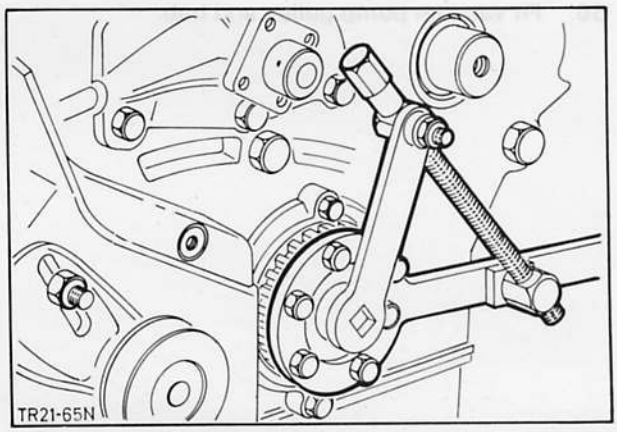



Fig. 83. Secure crankshaft journal bolt using Special Tool 21–018/019

63. Pre-load toothed belt tensioner and fit hand-tight. Align gears on marks, rotating crankshaft until crankshaft gear hub groove is aligned on timing cover mark. Check adjusting peg 21–016 is still correctly located in camshaft gear. Set injector adjuster to zero position. Rotate injection pump gear until setting specified in Technical Data is obtained. Then tighten injection pump gear nuts.

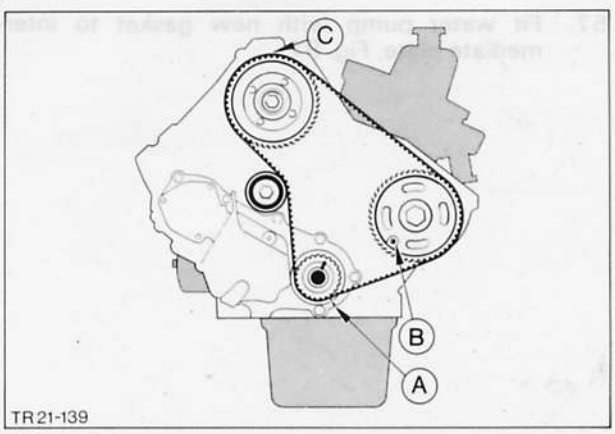



Fig. 84. Fuel injection pump marking

64. Position toothed belt, withdraw adjusting peg 21–016 from camshaft gear, rotate crankshaft through 2 revolutions, recheck markings, press toothed belt tensioner against belt and tighten, Fig. 85.

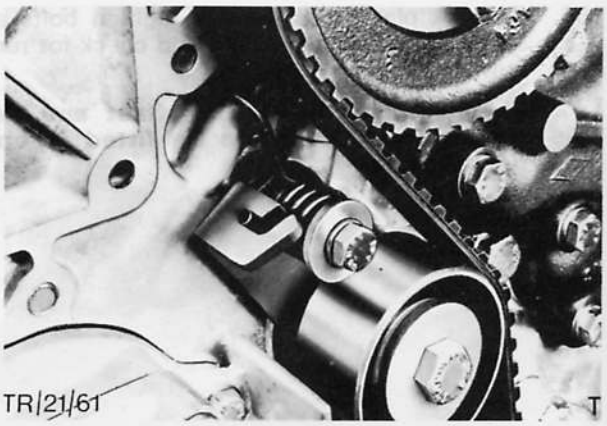



Fig. 85. Tighten belt tensioner

65. Position sump gasket, applying sealer to joints and gasket around joints, Fig. 86. Locate oil sump and torque bolts as specified in Technical Data.

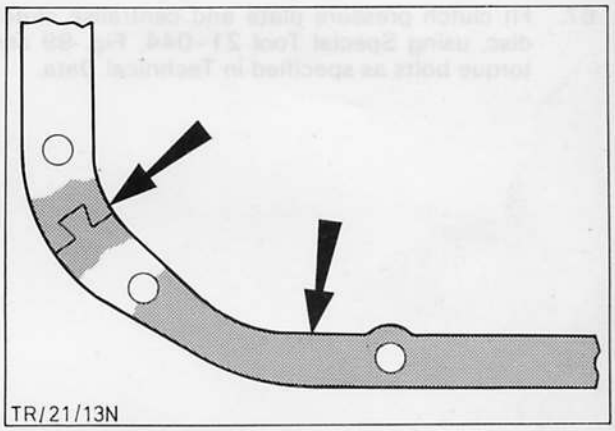



Fig. 86. Apply sealing compound to sump gasket

Fit two Allen screws each, front and rear, and secure, Fig. 87.


Fig. 87. Tighten front and rear sump bolts

## 21 134 8 (cont'd)

66. Fit back plate and flywheel, tighten bolts as specified in Technical Data and check for run-out, Fig. 88.

**Flywheel bolt holes are offset and the flywheel can therefore be fitted in one position only.**

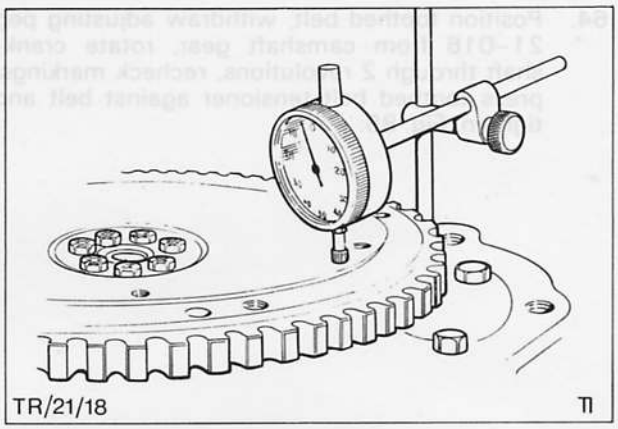



Fig. 88. Check flywheel run-out

67. Fit clutch pressure plate and centralise clutch disc, using Special Tool 21–044, Fig. 89 and torque bolts as specified in Technical Data.

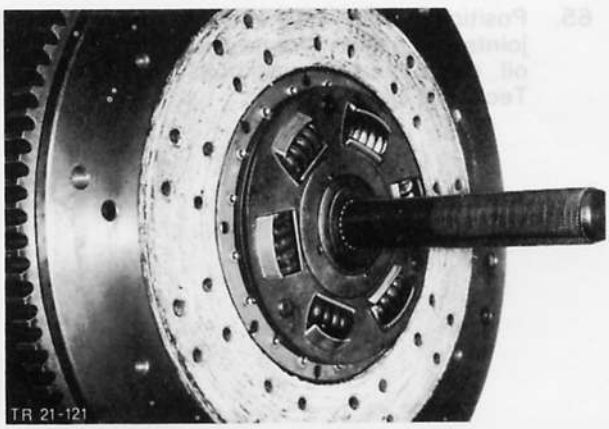



Fig. 89. Centralise clutch disc using Special Tool 21–044

68. Position cylinder head gasket with Part No. facing upwards and carefully locate cylinder head on guide sleeves, taking care to ensure correct assembly of by-pass hose. Fit cylinder head bolts in sequence shown in Fig. 90 and torque as specified in Technical Data.

**Before replacing cylinder head check correct location of combustion chamber inserts.**

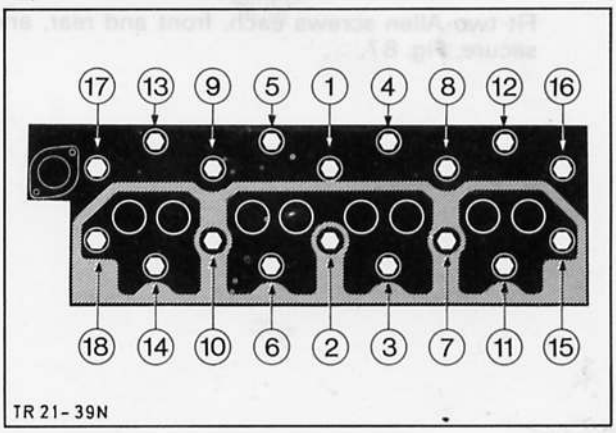



Fig. 90. Cylinder head bolt tightening sequence

69. Fit thermostat, Fig. 91, and install water neck with new gasket.

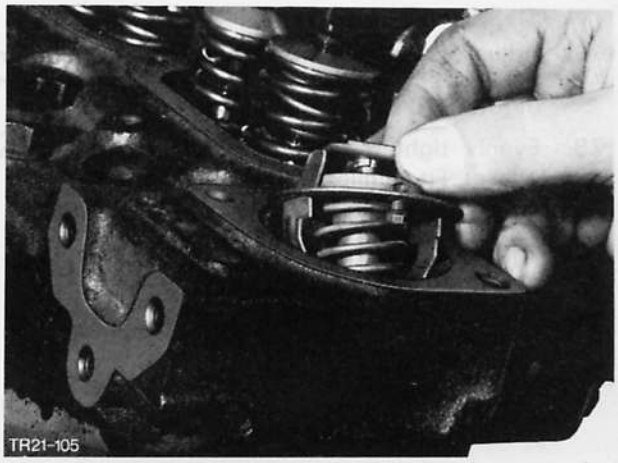



Fig. 91. Fit thermostat

70. Insert heat shields with new gaskets. Position new heat balancing plates, with convex side upwards, and new nozzle holder sealing rings, Fig. 92, and uniformly torque injector nozzles as specified in Technical Data.

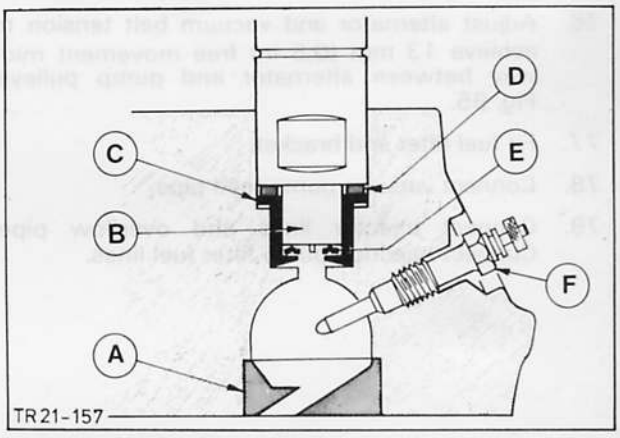



Fig. 92. Combustion chamber – cut-away view
A – Combustion chamber insert
B – Heat shield
C – Heat shield gasket
D – Nozzle holder gasket
E – Heat balancing plate

71. Lubricate push rods and guide them into the same sockets from which they were removed. Fit rocker shaft, inserting push rods into rocker arm sockets, Fig. 93. Tighten upper five rocker shaft bolts, followed by three lower bolts.

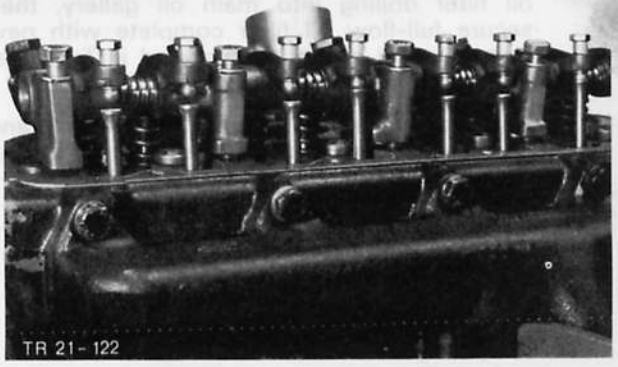



Fig. 93. Fit push rods in rocker arm sockets

## 21 134 8 (cont'd)

72. Adjust valve clearance Fig. 94 (see Operation 21–213), cranking engine **only** in direction of rotation.
73. Evenly tighten rocker cover bolts with new gasket. Fit oil filler cap and breather tube.
74. Fit upper and lower toothed belt cover.
75. Fit crankshaft pulley and fan with spacer. Install alternator complete with bracket.

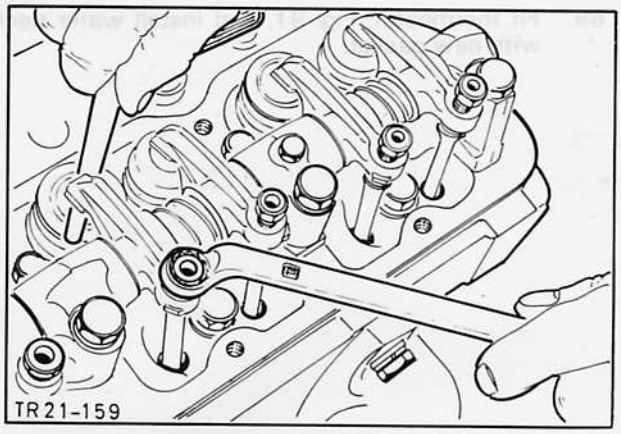



Fig. 94. Adjust valve clearance

76. Adjust alternator and vacuum belt tension to achieve 13 mm (0,5 in) free movement mid-way between alternator and pump pulleys, Fig. 95.
77. Fit fuel filter and bracket.
78. Connect vacuum pump feed pipe.
79. Connect injector lines and overflow pipe. Connect injection pump filter fuel lines.

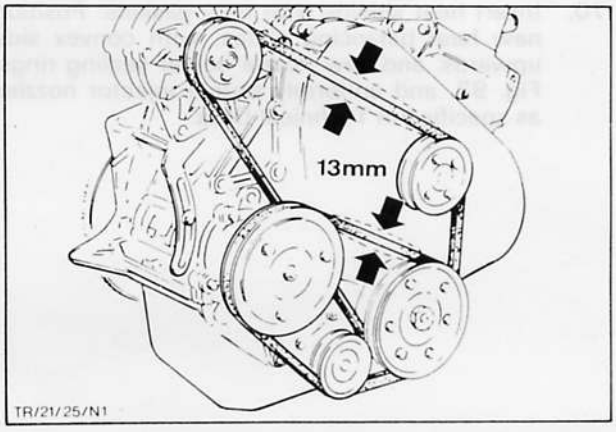



Fig. 95. Adjust alternator and vacuum pump V-belt tension

80. Using suitable hand syringe, fill not less than 1 litre (1,75 pints) engine oil through full-flow oil filter drilling into main oil gallery, then secure full-flow oil filter complete with new cartridge and gasket as specified in Technical Data, Fig. 96. Insert oil dipstick.
81. Remove engine from engine assembly stand and refit front left-hand engine mounting rubber insulator.

Fig. 96. Fit full-flow oil filter

## 21 154 SUMP – REMOVE AND INSTALL

**Special Service Tools Required: None**

**To Remove**

1. Jack up vehicle or drive over pit.
2. Drain engine oil.
3. Remove sump (24 bolts), removing rear Allen screws using standard tool, Fig. 97.

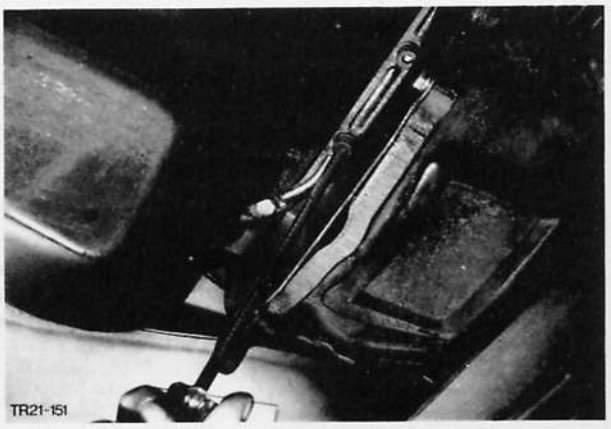



Fig. 97. Remove Allen screws

**To Install**

4. Clean engine block to sump sealing faces. Stick gasket to block using grease, applying sealer to joints and gasket in vicinity of joints, Fig. 98.

5. Carefully locate sump, fit screws (front and rear 2 Allen screws each) and evenly torque as specified in Technical Data.
6. Top up engine oil, start engine and check for leaks.
7. Lower vehicle or remove from pit, as applicable.

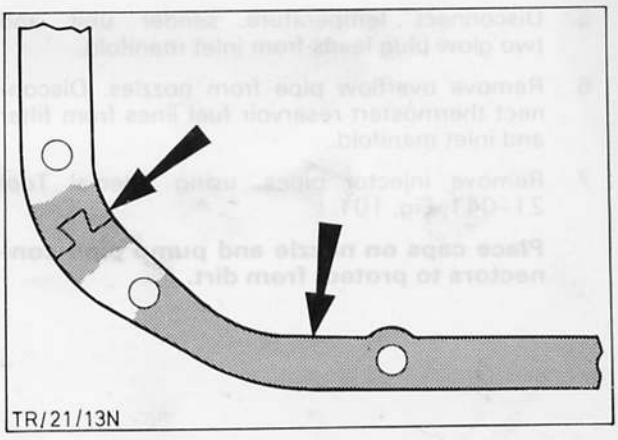



Fig. 98. Apply sealer to sump gasket

## 21 163 CYLINDER HEAD – REMOVE AND INSTALL

**Special Service Tool Required:**

Injector pipe nut wrench . . . . 21–041

**To Remove**

1. Remove earth strap from both batteries.
2. Drain coolant into tray, disconnecting lower radiator hose from water neck, Fig. 99 and top hose from thermostat water neck. Remove thermostat.

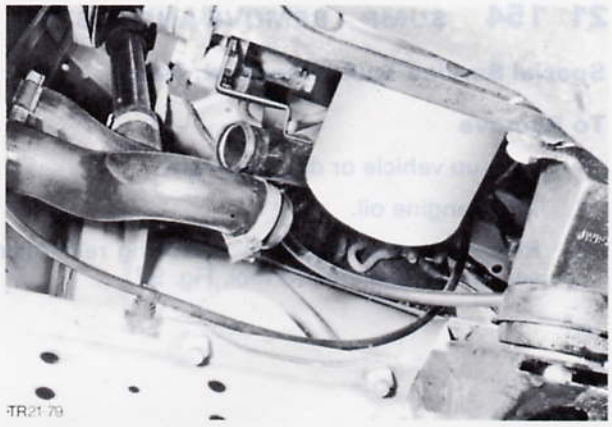



Fig. 99. Drain coolant

3. Remove air cleaner complete with bracket (2 bolts). Remove oil filler cap with breather hose.
4. Remove coolant expansion tank complete with bracket from cylinder head (3 bolts), Fig. 100.

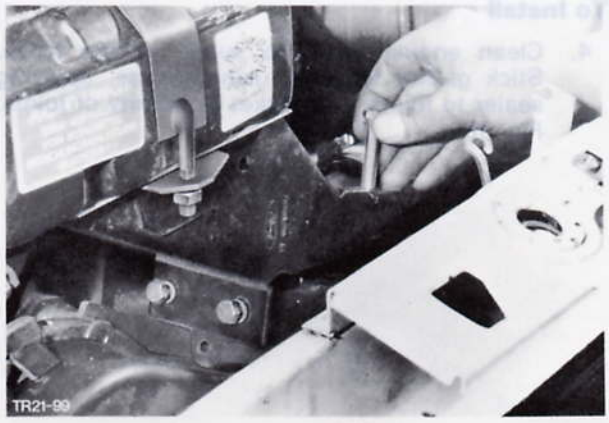



Fig. 100. Remove coolant expansion tank

5. Disconnect temperature sender unit and two glow plug leads from inlet manifold.
6. Remove overflow pipe from nozzles. Disconnect thermostart reservoir fuel lines from filter and inlet manifold.
7. Remove injector pipes, using Special Tool 21–041, Fig. 101.

   **Place caps on nozzle and pump pipe connectors to protect from dirt.**


Fig. 101. Remove injector pipes using Special Tool 21–041

8. Remove fuel filter bracket from inlet manifold (1 bolt).
9. Disconnect water outlet connector (Fig. 102).
10. Disconnect heater hose at cylinder head front.
11. Remove exhaust pipe from manifold (2 nuts).
12. Remove rocker cover (6 bolts). Remove three lower then five upper rocker support bracket bolts. Remove rocker shaft and push rods.

    **Do not interchange push rods when removing and installing.**
13. Remove injector nozzles (2 bolts each).


Fig. 102. Remove water outlet connector

14. Remove engine mounting rubber insulators front right and left-hand side (2 nuts) and carefully raise engine from underneath sump to gain access for removal of toothed belt cover to cylinder head bolt and of water pump to cylinder head by-pass hose, Fig. 103.

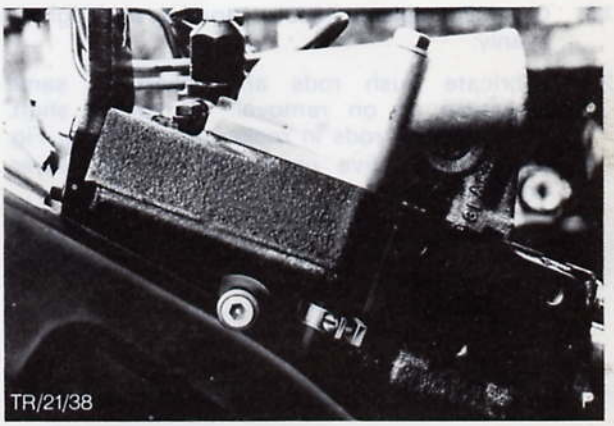



Fig. 103. Remove by-pass hose

15. Remove cylinder head bolts (18), reversing tightening sequence (for tightening sequence see Fig. 104). Lift out cylinder head complete with inlet and exhaust manifolds.

**To Install**

16. Clean cylinder head and engine block joint faces. Position new cylinder head gasket with part number facing upwards and carefully place cylinder head on locating bushes, ensuring correct assembly of by-pass hose. Tighten cylinder head bolts in sequence shown in Fig. 104 and torque as specified in Technical Data. Secure by-pass hose.

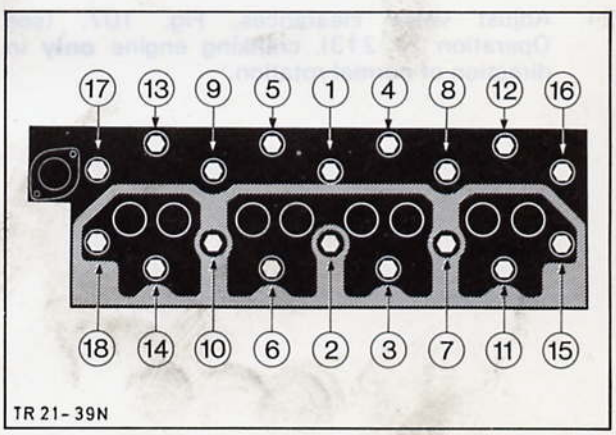



Fig. 104. Cylinder head bolt tightening sequence

## 21 163 (cont'd)

17. Insert toothed belt cover bolt in cylinder head.
18. Lower engine and fit right-hand and left-hand engine mounting rubber insulators, Fig. 105.

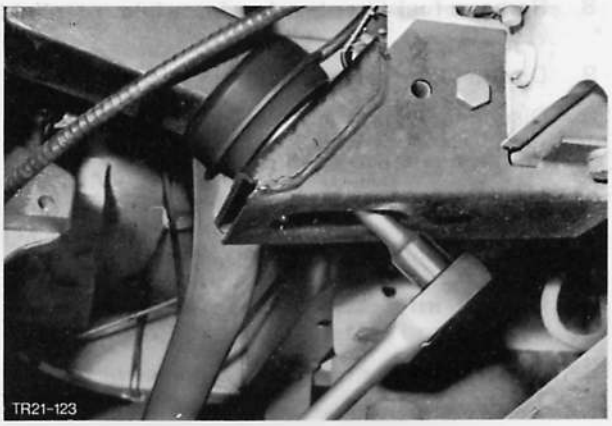



Fig. 105. Fit engine mounting rubber insulators

19. Carefully replace injector nozzles and tighten evenly.
20. Lubricate push rods and insert in same sequence as on removal. Fit rocker shaft, locating push rods in rocker arm sockets, Fig. 106. Tighten five upper, then three lower bracket bolts.


Fig. 106. Insert push rods in rocker arm sockets

21. Adjust valve clearances, Fig. 107, (see Operation 21 213), cranking engine **only** in direction of normal rotation.

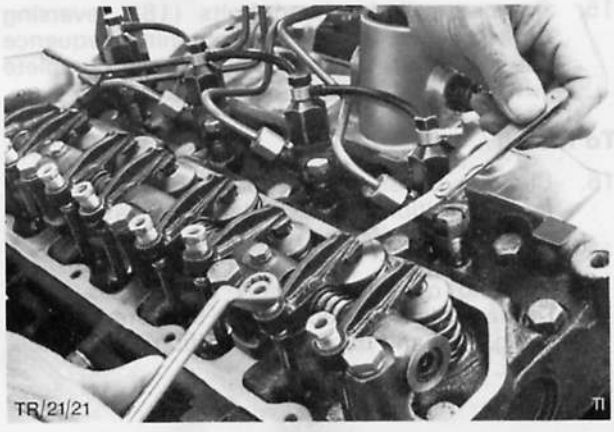



Fig. 107. Adjust valve clearances

22. Uniformly tighten rocker cover with new gasket.
23. Fit exhaust pipe to manifold.
24. Assemble heater hose to cylinder head, Fig. 108.

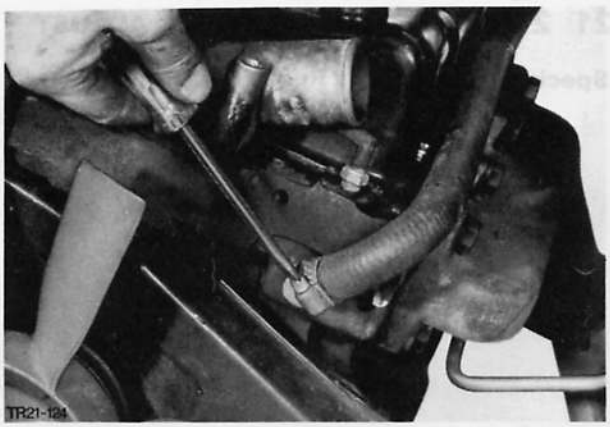



Fig. 108. Fit heater hose

25. Fit water outlet connector, Fig. 109.
26. Fit fuel filter bracket to inlet manifold.
27. Connect injector pipes and tighten as specified in Technical Data, using Special Tool 21–041.
28. Reconnect thermostart reservoir fuel lines to filter and inlet manifold and overflow oil line to nozzles.
29. Connect temperature sender unit and glow plug leads (2).
30. Fit coolant expansion tank with bracket to cylinder head.


Fig. 109. Fit water outlet connector

31. Refit oil filler cap and breather hose. Fit air cleaner complete with bracket, Fig. 110.
32. Slide lower and upper radiator hoses into position, tighten and top up coolant.
33. Reconnect both batteries.
34. Start engine and check for leaks.


Fig. 110. Fit air cleaner

## 21 213 VALVE CLEARANCE – ADJUST

**Special Service Tools Required: None**

1. Remove water outlet connector, Fig. 111 and remove rocker cover (6 bolts).

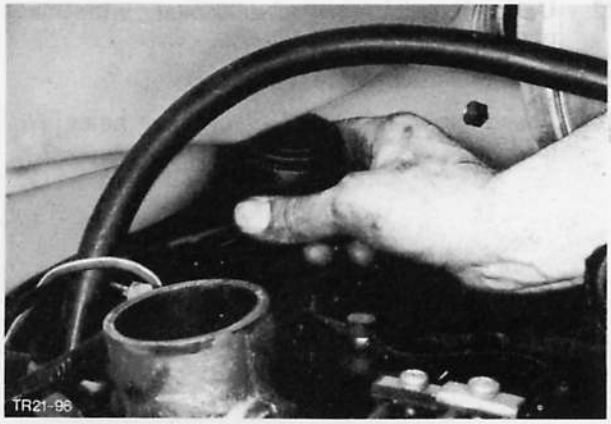



Fig. 111. Remove water outlet connector

2. Adjust valve clearances as follows:

   Rotate crankshaft pulley clockwise until valve No. 1 cylinder is fully open, then adjust valve No. 4 (inlet) and No. 7 (exhaust). Continue rotating crankshaft pulley and adjust all valve clearances as set out below, Fig. 112.

| Valve open | Adjust valve |
|---|---|
| No. 1 | No. 4 (inlet) and 7 (exhaust) |
| No. 2 | No. 5 (exhaust) and 8 (inlet) |
| No. 4 | No. 1 (exhaust) and 6 (inlet) |
| No. 5 | No. 2 (inlet) and 3 (exhaust) |

3. Fit rocker cover with new gasket and tighten. Fit water outlet connector.

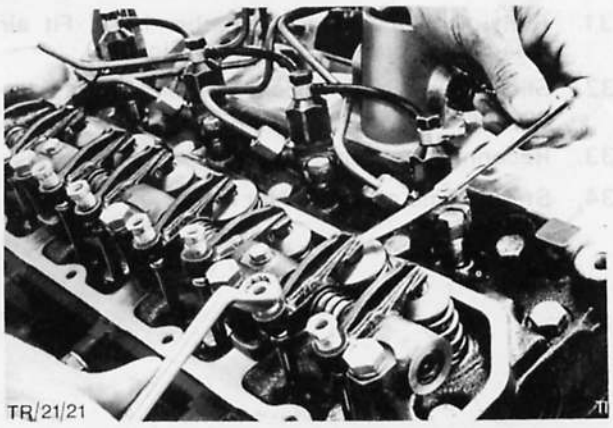



Fig. 112. Adjust valve clearances

## 21 217 4 VALVES – REMOVE AND INSTALL (cylinder head removed)

**Special Service Tools Required: None**

**To Remove**

1. Remove inlet and exhaust manifolds from cylinder head (8 bolts each) Fig. 113.
2. Remove caps from valve retainers and valve stems by tapping with plastic mallet.

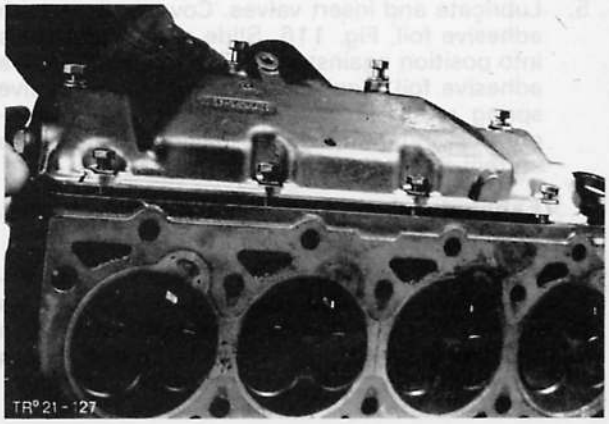



Fig. 113. Remove inlet manifold

3. Compress valve spring(s) using standard valve spring compressor, Fig. 114. Remove collets, release pressure on spring(s) and remove spring(s) and spring retainer. Withdraw valve stem seal and remove valve. Fit valve spring compressor to next valve and similarly remove remaining valves.

   **When removing and refitting valve springs it is essential to ensure that valve stem is not damaged by valve spring when it is pressed down to remove and refit collets. If stem is damaged there is no guarantee that sealing is adequate. The result would be excessive oil consumption and valve guide wear.**

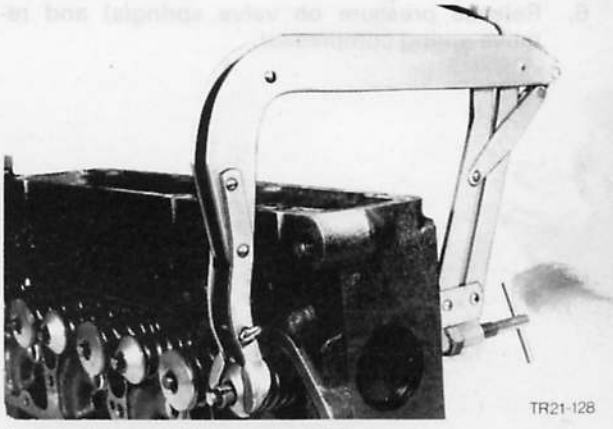



Fig. 114. Compress valve spring using standard compressor

**To Install**

4. Remove carbon and other deposits from valves and cylinder head galleries, then grind in valves, Fig. 115 and remove all traces of grinding paste from cylinder head.

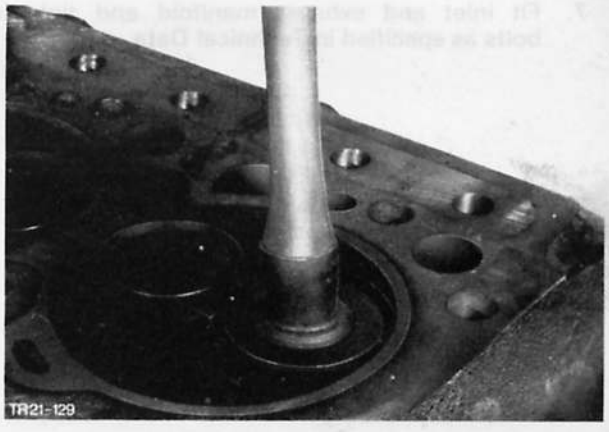



Fig. 115. Grind in valve

5. Lubricate and insert valves. Cover splines with adhesive foil, Fig. 116. Slide valve stem seals into position against stop, Fig. 117 and remove adhesive foil. Replace valve springs and valve spring retainers, compress with spring compressor and refit collets, paying attention to correct collet seating.

   **Exhaust valves have 2 valve springs, Fig. 118.**

   **Every time valves are removed and installed new valve stem seals should be used. Cover valve splines with adhesive foil to prevent damage to valve stem seals.**

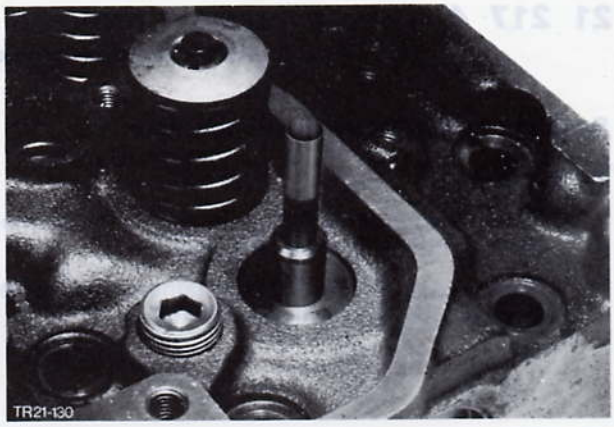



Fig. 116. Cover valve splines with adhesive foil

6. Release pressure on valve spring(s) and remove spring compressor.

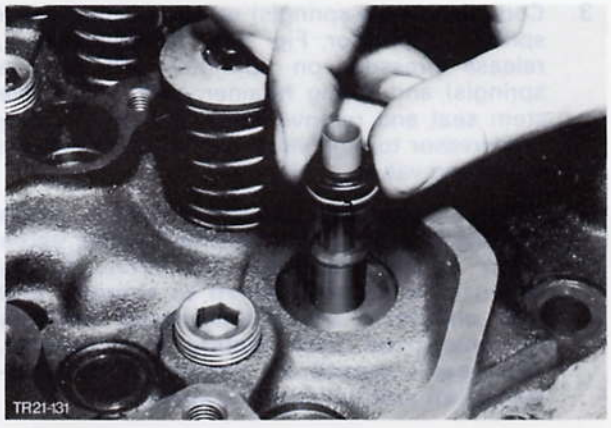



Fig. 117. Fit valve stem seals

7. Fit inlet and exhaust manifold and tighten bolts as specified in Technical Data.


Fig. 118. Exhaust valve – exploded view

## 21 231 9 VALVE SEAT – RECUT

**Special Service Tools Required: None**

**Valve seat cutting will serve a useful purpose only if valve guide bores are not damaged. Prior to cutting therefore check valve stem clearance in guide and if necessary replace valve guide.**

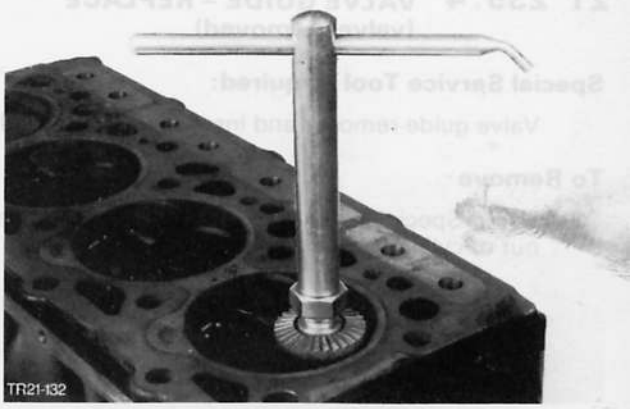



Fig. 119. Cut valve seat

1. Machine valve seat using standard valve seat milling cutters, Fig. 119, then re-machine valve seat width using correcting cutter and measure valve head depth in cylinder head, Fig. 120.

   **When machining valve seat pay attention to differing valve seat angles in cylinder head, Fig. 121 (see Technical Data).**

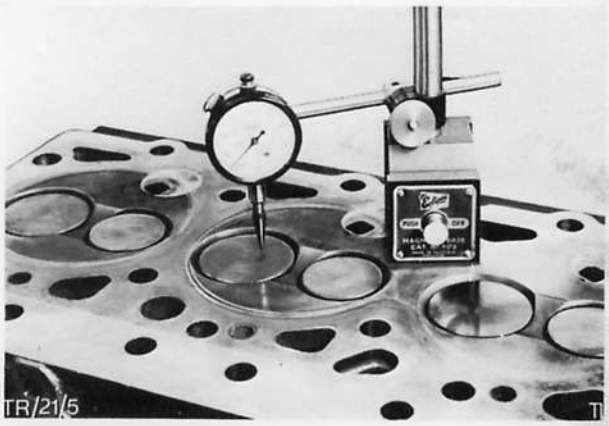



Fig. 120. Valve head depth in cylinder head

2. Remove swarf from cylinder head and valves.

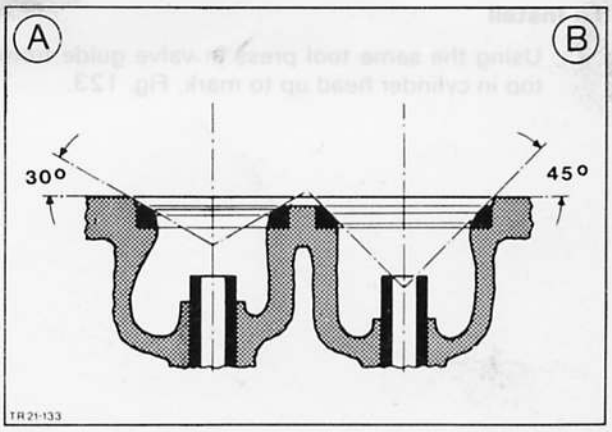



Fig. 121. Valve seat angle
A – Exhaust valve
B – Inlet valve

## 21 235 4 VALVE GUIDE – REPLACE (valves removed)

**Special Service Tool Required:**

Valve guide remover and installer . . 21–021

**To Remove**

1. Using Special Tool 21–021 press valve guide out of cylinder head from below, Fig. 122.

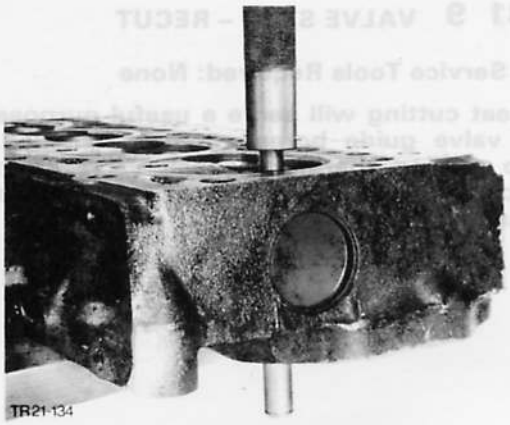



Fig. 122. Remove valve guide

**To Install**

2. Using the same tool press in valve guide from top in cylinder head up to mark, Fig. 123.

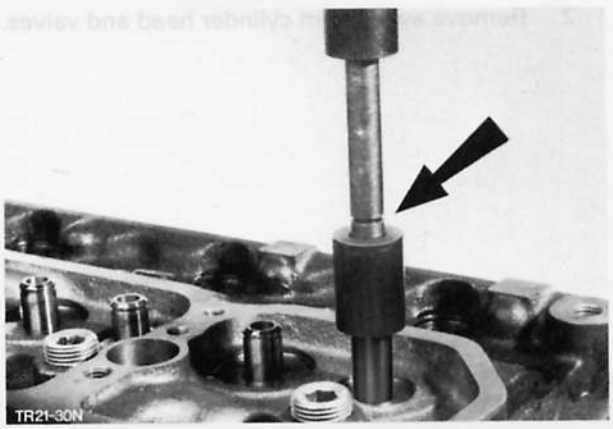



Fig. 123. Fit valve guide

## 21 255 9 ROCKER SHAFT ASSEMBLY – OVERHAUL (rocker shaft removed)

**Special Service Tools Required: None**

**To Dismantle**

1. Remove outer rocker supports (2) and outer rocker arms (4) with springs (2) from rocker shaft.
2. Remove inner rocker supports (2) from shaft (2 bolts), then remove inner rocker arms (4) with springs (2), and centre support.

**To Reassemble**

3. Assemble rocker shaft as shown in Fig. 124, having previously lubricated rocker shaft and rocker arm sliding faces.

   **With rocker shaft fitted oil bores for rocker shaft lubrication must point upwards.**

   On new rocker shafts check plugs in both shaft ends.

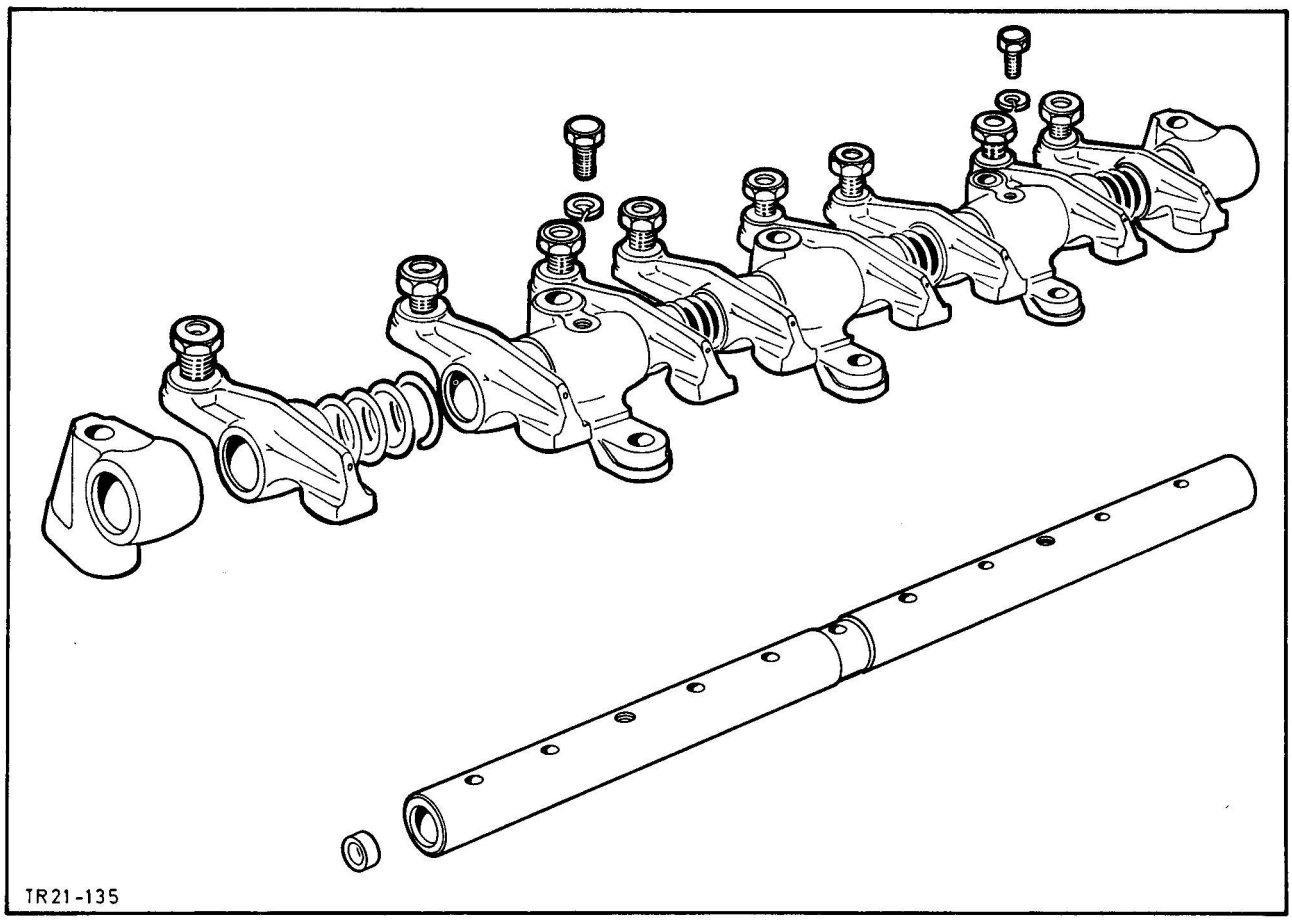



Fig. 124. Rocker shaft assembly dismantled

## 21 286 6 CAMSHAFT BEARINGS – REPLACE (engine dismantled)

**Special Service Tools Required:**

Camshaft bearing remover/replacer .. 21–022
Adaptors .. 21–022–01 and 21–022–02

1. From front of engine remove bushes Nos. 5, 4, 3 and 2 using Special Tool 21–022 and associated adaptors 21–022–01 and 21–022–02, Fig. 125.

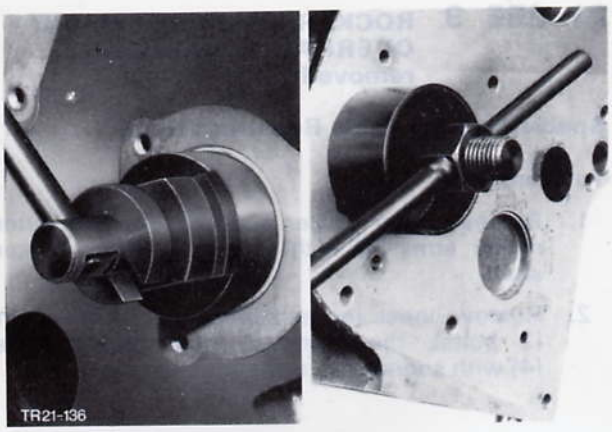



Fig. 125. Withdraw bearing bush No. 5 from front using Special Tool 21–022–01/02

2. Back off main tool spindle and fit new bearing bushes Nos. 5, 4, 3 and 2, using same Special Tool, Fig. 126.

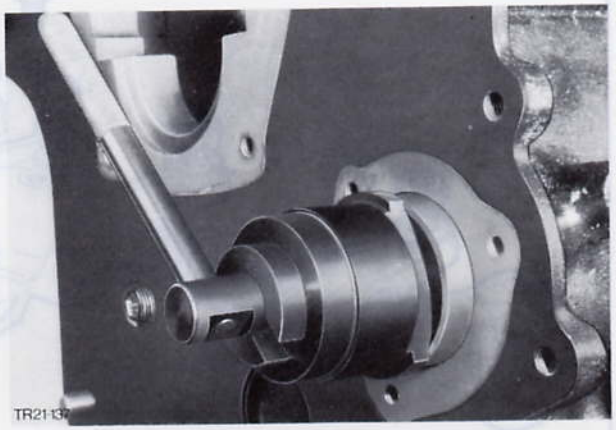


Fig. 126. Back off spindle and fit new bearing bush No. 5

3. Replace bearing bush No. 1, paying attention to lug being aligned on bush bore, then secure bush, Fig. 127.

Fig. 127. Replace bearing bush No. 1

## 21 288 CAMSHAFT OIL SEAL – REPLACE

**Special Service Tools Required:**

| | |
|---|---|
| Camshaft oil seal remover .. .. | 15–048 |
| Remover adaptor .. .. .. | 15–048–01 |
| Camshaft gear timing peg .. | 21–016 |
| Camshaft oil seal replacer .. | 21–017 |

**To Remove**

1. Remove earth strap from both batteries.
2. Drain coolant into trays, removing lower radiator hose from water pipe, Fig. 128 and upper hose from thermostat water neck.

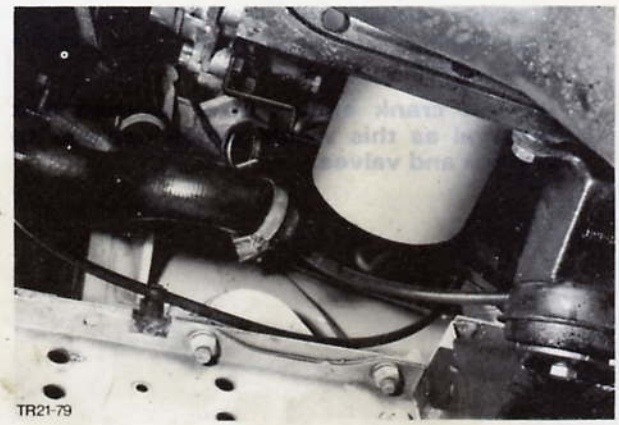



Fig. 128. Drain coolant

3. Remove radiator hose and expansion tank by-pass hose from radiator.
4. Remove radiator (4 bolts) and lift out.
5. Slacken vacuum pump V-belt tensioner (1 bolt and 1 nut), Fig. 129 and alternator bracket (4 bolts) and remove both V-belts.

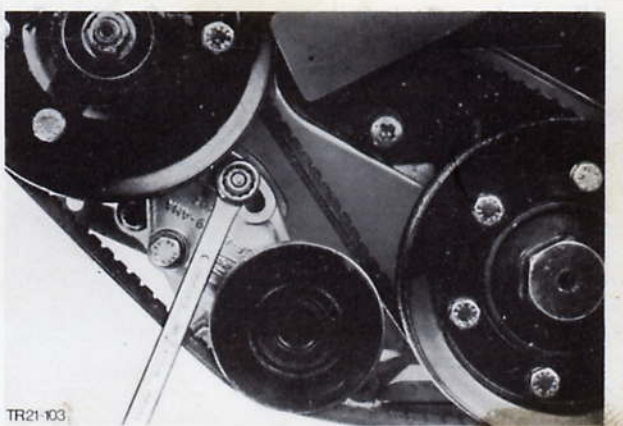



Fig. 129. Slacken vacuum pump V-belt tensioner

6. Remove fan with pulley (4 bolts).
7. Remove toothed belt cover (5 bolts).
8. Rotate engine until crankshaft, camshaft and injection pump gear markings are aligned on timing cover mark, Fig. 130.

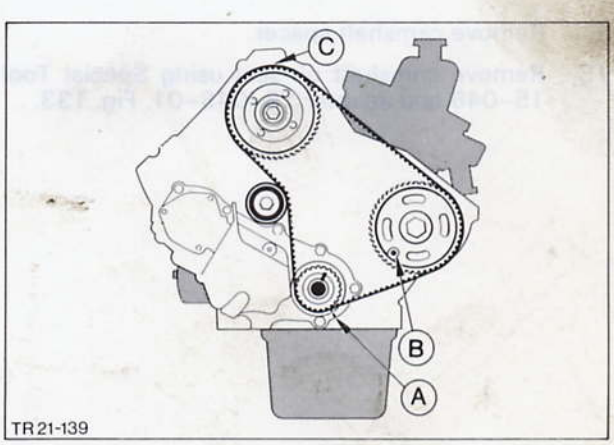



Fig. 130. Toothed belt pulley markings
A – Crankshaft
B – Camshaft
C – Fuel injection pump

## 21 288 (cont'd)

9. Slacken toothed belt tensioner, Fig. 131, reduce tension using screwdriver and remove toothed belt.

   **Do not crank engine after toothed belt removal as this would cause damage to pistons and valves.**

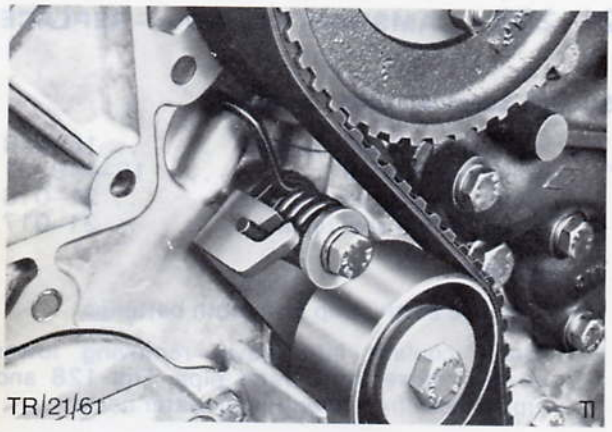



Fig. 131. Slacken toothed belt tensioner

10. Lock camshaft gear using Special Tool 21–016, Fig. 132, remove bolt and press off gear by means of two levers.

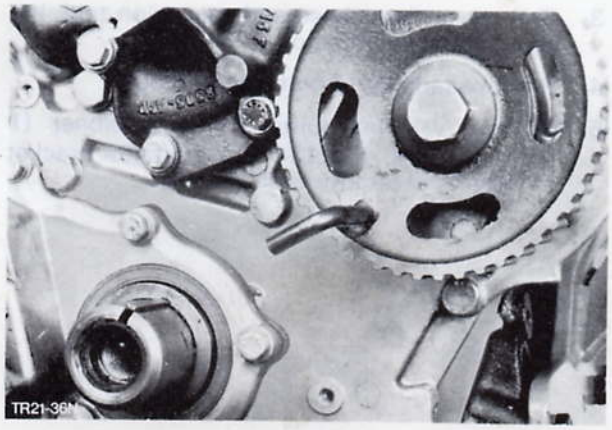



Fig. 132. Lock camshaft gear using Special Tool 21–016

11. Remove camshaft spacer.
12. Remove camshaft oil seal using Special Tool 15–048 and adaptor 15–048–01, Fig. 133.

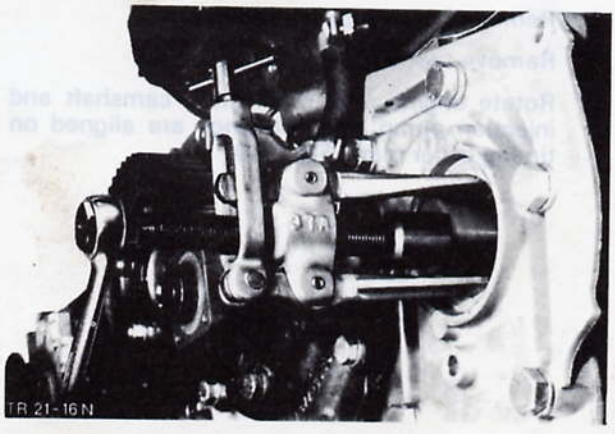



Fig. 133. Remove camshaft oil seal using Special Tool 15–048/048–01

**To Install**

13. Lubricate camshaft oil seal lip and using Special Tool 21–017 with bolt carefully press fully home, Fig. 134 ensuring camshaft alignment is not disturbed. Then again remove bolt.
14. Lubricate spacer rear surface, slide spacer on to camshaft and apply sealer to front.
15. Fit camshaft gear, lock with Special Tool 21–016 and torque as specified in Technical Data, applying sealer to bolt head inside. Remove timing peg.

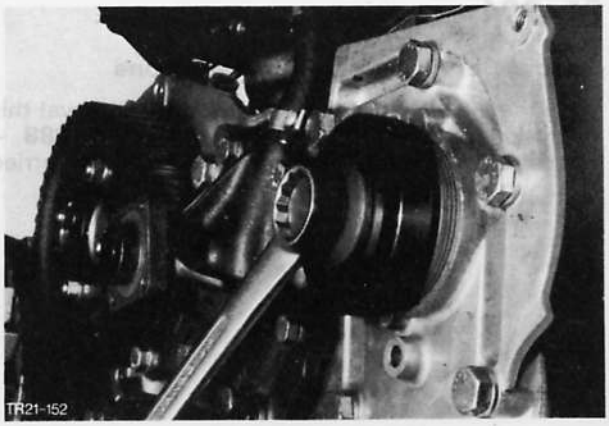



Fig. 134. Fit camshaft oil seal using Special Tool 21–017

16. Check crankshaft, camshaft and injection pump markings. Slacken toothed belt tensioner and position toothed belt, Fig. 135.
17. Press tensioner against toothed belt, crank engine twice in direction of rotation and secure tensioner.
18. Fit toothed belt cover.
19. Fit fan and pulley.

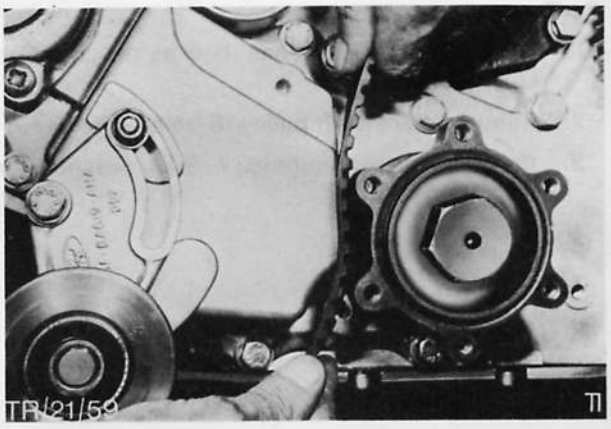



Fig. 135. Position toothed belt

20. Position alternator and vacuum pump V-belts and adjust tension in such a manner that free play at a point midway between pulleys is 13 mm (0,5 in), Fig. 136.
21. Insert and secure radiator. Fit and tighten expansion tank radiator hoses as well as upper and lower radiator hoses.
22. Top up coolant and check engine oil level.
23. Connect earth strap on both batteries, start engine and check for leaks.

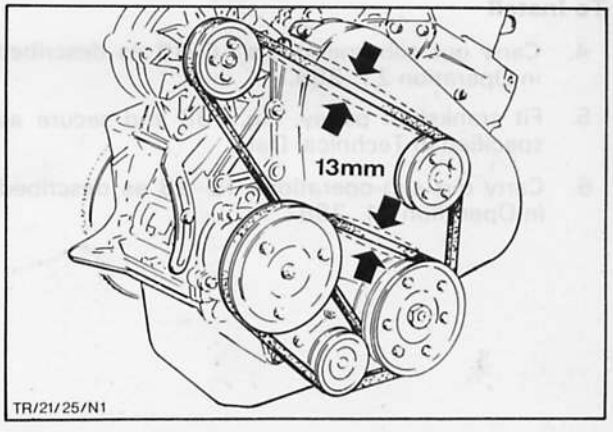



Fig. 136. Adjust alternator and vacuum V-belt tension

## 21 304 TIMING BELT – REPLACE

**Special Service Tools Required: None**

With the exception of crankshaft pulley removal this operation is contained in **Operation 21 288 – Camshaft oil seal – replace** and should be carried out as follows:

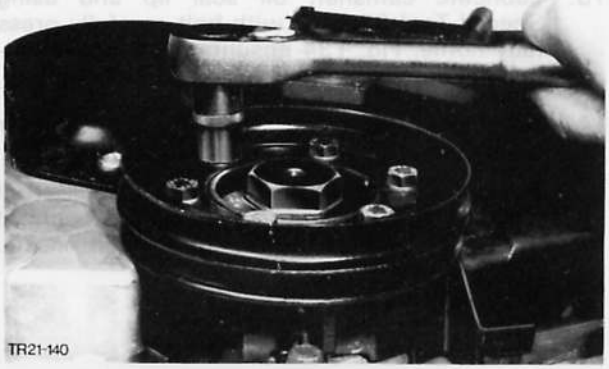



Fig. 137. Remove crankshaft pulley

**To Remove**

1. Carry out sub-operations 1–6 as described in Operation 21 288.
2. Remove crankshaft pulley (6 bolts) Fig. 137.
3. Carry out sub-operations 7–9 as described in Operation 21 288.

**To Install**

4. Carry out sub-operations 16–18 as described in Operation 21 288.
5. Fit crankshaft pulley, Fig. 138 and secure as specified in Technical Data.
6. Carry out sub-operations 19–23 as described in Operation 21 288.


Fig. 138. Fit crankshaft pulley

## 21 467 SEAL – CRANKSHAFT FRONT – REPLACE

**Special Service Tools Required:**

Camshaft gear timing peg ..... 21–016
Crankshaft flange holding wrench .. 21–018
Crankshaft flange bolt remover/replacer ..... 21–019
Crankshaft front oil seal aligner .... 21–025

**To Remove**

1. Remove earth strap from both batteries.
2. Drain coolant into tray, slackening and removing lower radiator hose from water pipe, Fig. 139 and upper hose from thermostat water neck.

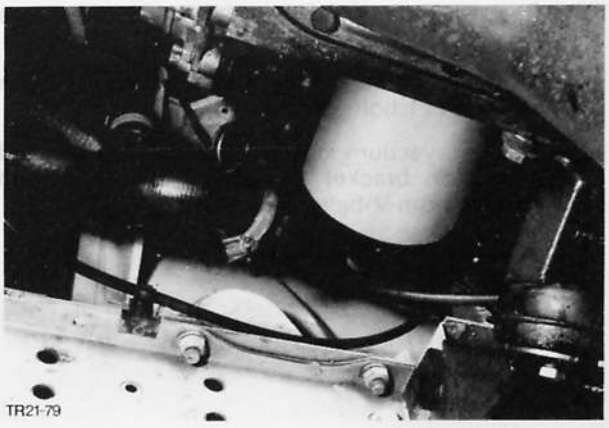



Fig. 139. Drain coolant

3. Remove radiator hose and expansion tank bypass hose from radiator.
4. Remove radiator at bottom location (2 bolts) from crossmember mountings, Fig. 140.

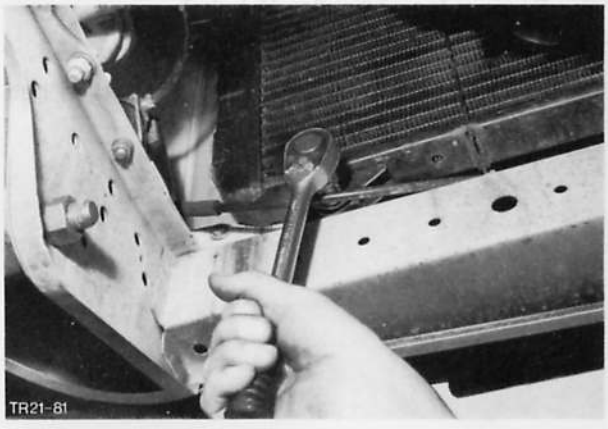



Fig. 140. Unscrew radiator at bottom location

5. Unhook hood cable at catch, Fig. 141 and unscrew from radiator grille panel.

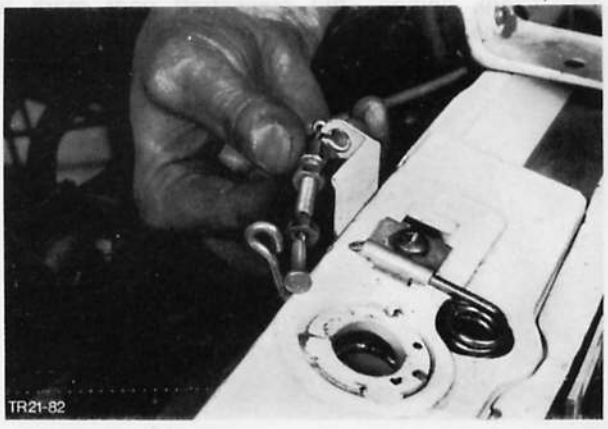



Fig. 141. Unhook hood cable

## 21 467 (cont'd)

6. Remove right-hand and left-hand headlamp surround (1 bolt each).
7. Remove radiator grille panel complete with radiator (11 bolts).
8. Slacken vacuum pump (1 bolt, 1 nut) and alternator bracket tensioner (4 bolts) and remove both V-belts, Fig. 142.

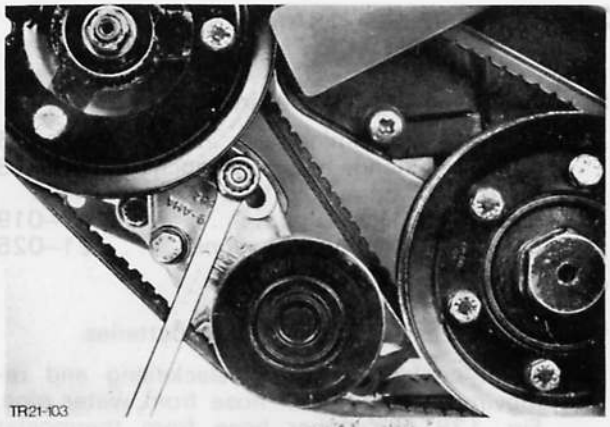



Fig. 142. Slacken vacuum pump V-belt tensioner

9. Remove fan and pulley (4 bolts).
10. Remove crankshaft pulley (6 bolts), Fig. 143.
11. Remove upper (5) and lower (2) toothed belt cover bolts and remove covers.

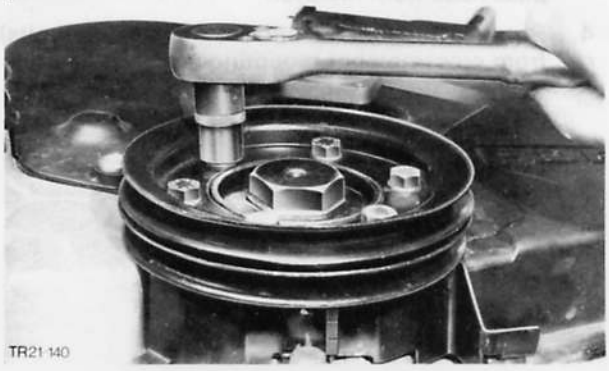



Fig. 143. Remove crankshaft pulley

12. Crank engine until crankshaft gear mark is aligned on timing cover mark, Fig. 144.

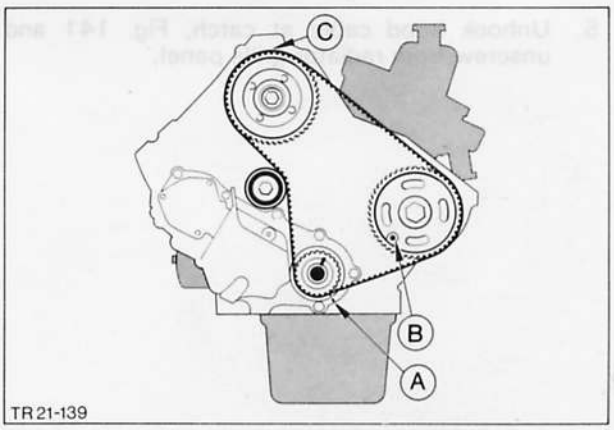



Fig. 144. Toothed belt pulley markings
A – Crankshaft
B – Camshaft
C – Fuel injection pump

13. Slacken toothed belt tensioner, Fig. 145 using screwdriver and remove toothed belt.

    **Do not crank engine after toothed belt removal as this will cause damage to pistons and valves.**

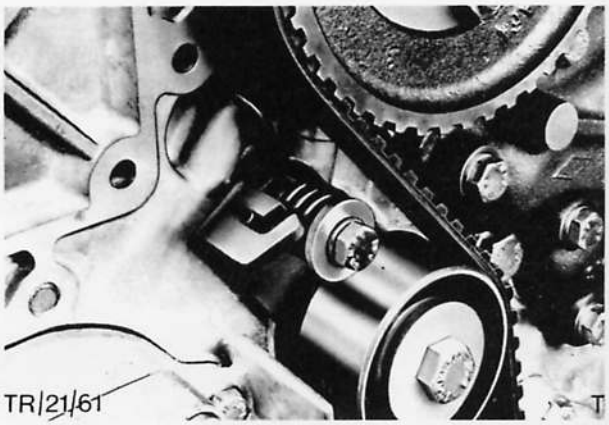



Fig. 145. Slacken toothed belt tensioner

14. Slacken crankshaft hub centre bolt using Special Tool 21–018/19, Fig. 146 and remove bolt.
15. Remove crankshaft hub using standard remover and remove toothed belt thrust washer.
16. Remove vacuum pump pulley (3 bolts).

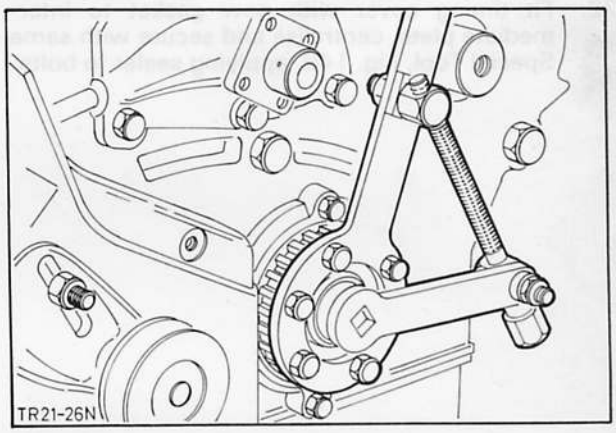



Fig. 146. Slacken crankshaft hub centre bolt using Special Tool 21–018/019

17. Remove vacuum pump hub (1 nut) using standard remover, Fig. 147.
18. Remove timing cover from intermediate plate (10 bolts).
19. Press off crankshaft spacer and remove.
20. Using hammer and mandrel, drive crankshaft oil seal to rear out of timing cover.

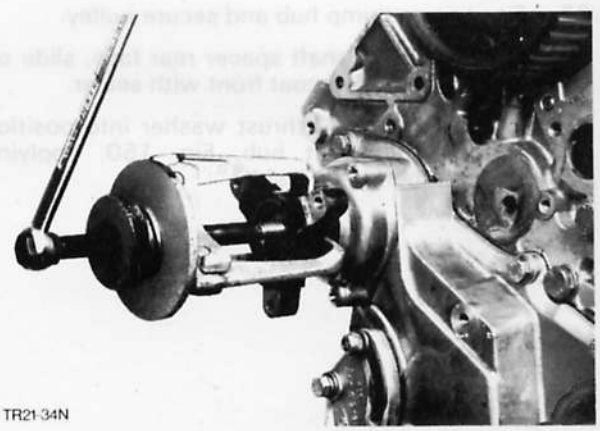



Fig. 147. Remove vacuum pump hub

## 21 467 (cont'd)

**To Install**

21. Lubricate crankshaft oil seal lip and insert oil seal into timing cover from rear up to stop, using Special Tool 21–025, Fig. 148.


Fig. 148. Fit crankshaft oil seal using Special Tool 21–025

22. Fit timing cover with new gasket to intermediate plate, centralise and secure with same Special Tool, Fig. 149, applying sealer to bolts.

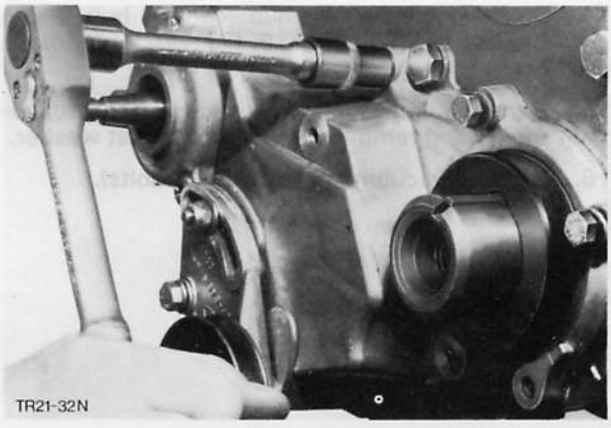



Fig. 149. Centralise timing cover using Special Tool 21–025

23. Fit vacuum pump hub and secure pulley.
24. Lubricate crankshaft spacer rear face, slide on to crankshaft and coat front with sealer.
25. Slide toothed belt thrust washer into position and fit crankshaft hub, Fig. 150, applying sealer to bolt head inside.

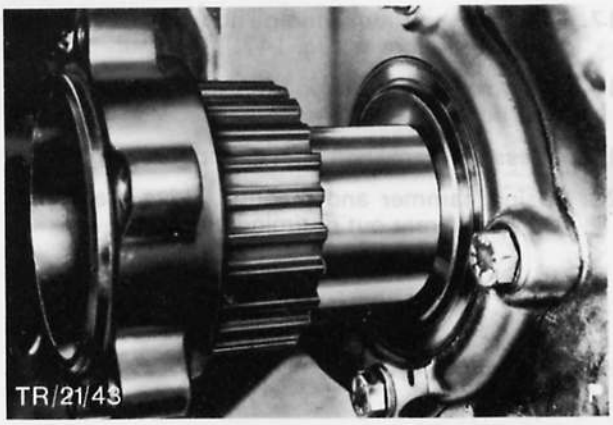



Fig. 150. Fit crankshaft hub

26. Fit crankshaft hub centre bolt hand-tight and torque as specified in Technical Data using Special Tool 21–018/019, Fig. 151.

**10 spindle turns = 150 Nm (15 kgf m) (108 lbf ft).**

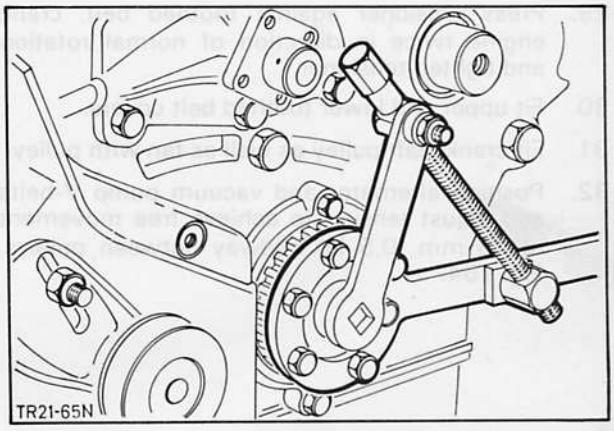



Fig. 151. Fit crankshaft hub centre bolt using Special Tool 21–018/019

27. Check markings on crankshaft, camsnaft and injection pump, Fig. 152, using timing peg 21–016.

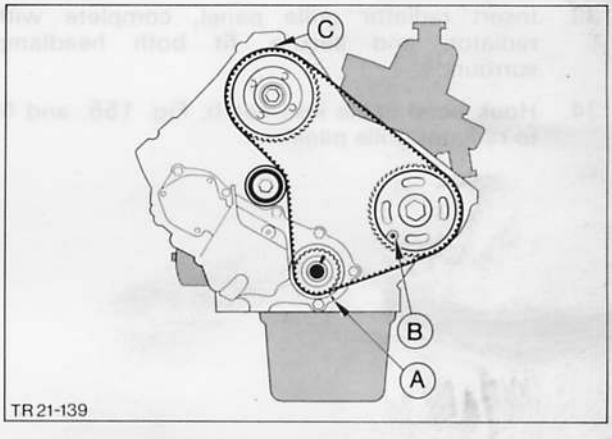



Fig. 152. Toothed belt pulley markings
A – Crankshaft
B – Camshaft
C – Fuel injection pump

28. Slacken toothed belt tensioner and position toothed belt, Fig. 153.

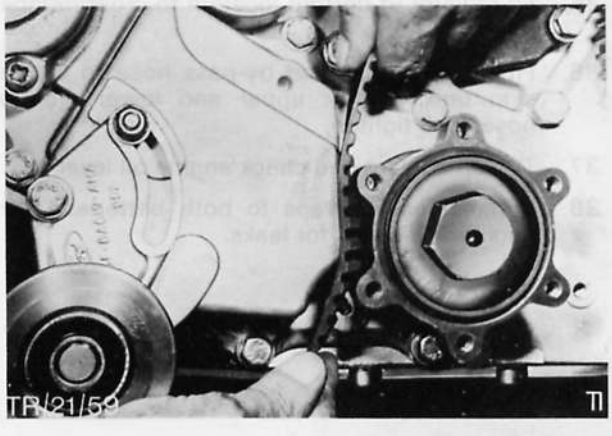



Fig. 153. Position toothed belt

29. Press tensioner against toothed belt, crank engine twice in direction of normal rotation and tighten tensioner.
30. Fit upper and lower toothed belt covers.
31. Fit crankshaft pulley as well as fan with pulley.
32. Position alternator and vacuum pump V-belts and adjust tension to achieve free movement of 13 mm (0,5 in) midway between pulleys, Fig. 154.

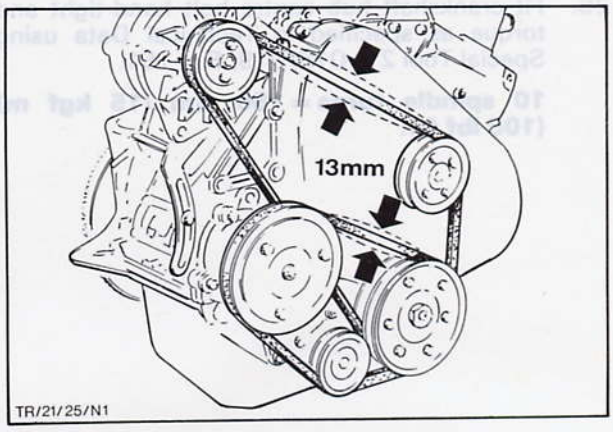



Fig. 154. Adjust alternator and vacuum pump V-belt tension

33. Insert radiator grille panel, complete with radiator, and secure, fit both headlamp surrounds.
34. Hook hood cable into catch, Fig. 155, and fit to radiator grille panel.

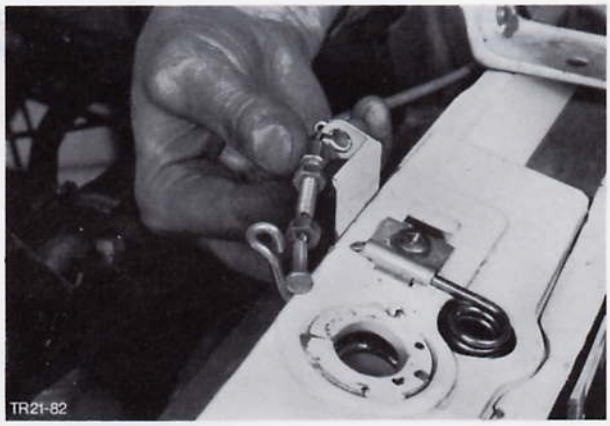



Fig. 155. Fit hood cable

35. Fit radiator at bottom location to crossmember mountings, Fig. 156.
36. Fit radiator hose and by-pass hose to expansion tank and fit upper and lower radiator hoses and tighten.
37. Top up coolant and check engine oil level.
38. Connect earth straps to both batteries, start engine and check for leaks.

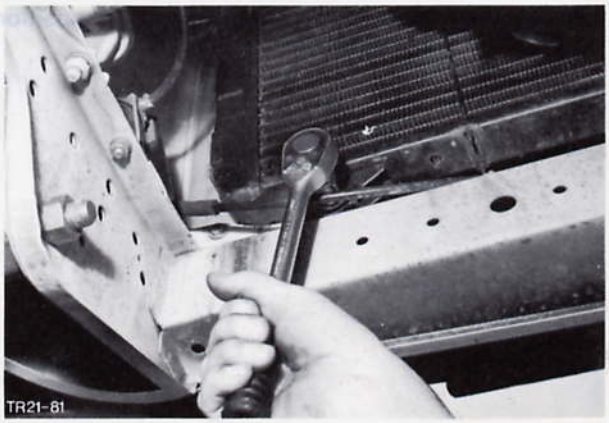



Fig. 156. Fit radiator at bottom location

## 21 468 4 OIL SEAL – CRANKSHAFT – REAR – REPLACE (engine or gearbox removed)

**Special Service Tools Required:**

Crankshaft rear oil seal remover . . 21–010
Crankshaft rear oil seal installer . .21–011–A
Clutch disc locator . . . . . 21–044

**To Remove**

1. Remove clutch pressure plate and clutch disc (6 bolts).
2. Remove flywheel (8 bolts).
3. Remove crankshaft oil seal using Special Tool 21–010, Fig. 157.

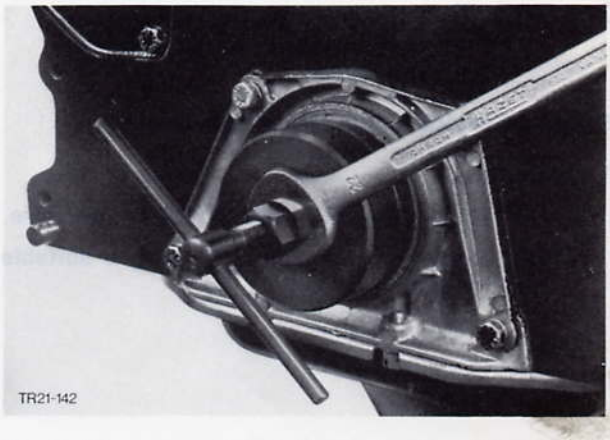



Fig. 157. Remove crankshaft oil seal using Special Tool 21–010

**To Install**

4. Lubricate crankshaft oil sealing lip and drive in up to stop, using Special Tool 21–011–A, Fig. 158.

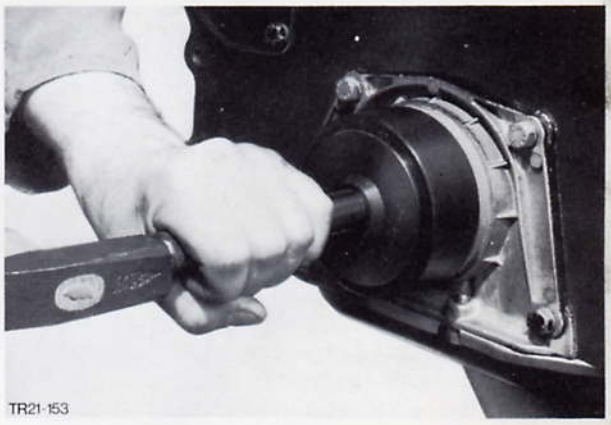



Fig. 158. Drive in oil seal with Special Tool 21–011–A

5. Fit flywheel and secure as specified in Technical Data.

   **Flywheel bolt holes are offset and flywheel may therefore be installed in one position only.**

6. Centralise clutch pressure plate and clutch disc using Special Tool 21–044, Fig. 159 and torque as specified in Technical Data.

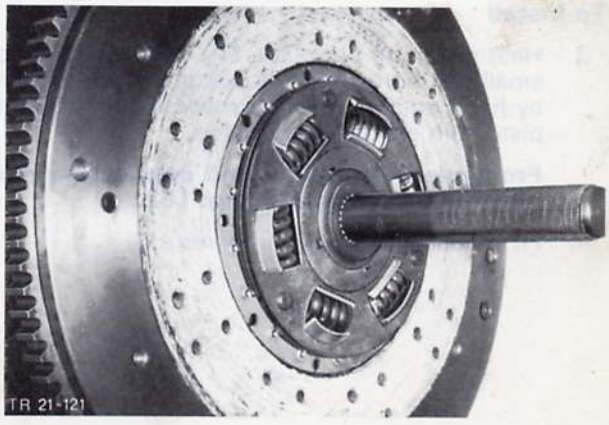



Fig. 159. Centralise clutch disc using Special Tool 21–044

## 21 505 5 PISTON – REPLACE (piston and connecting rod assembly removed)

**Special Service Tools Required: None**

**To Remove**

1. Remove circlips, Fig. 160 from piston pin bore.
2. Tap piston pin out of piston using a suitable hammer and drift.


Fig. 160. Remove circlips

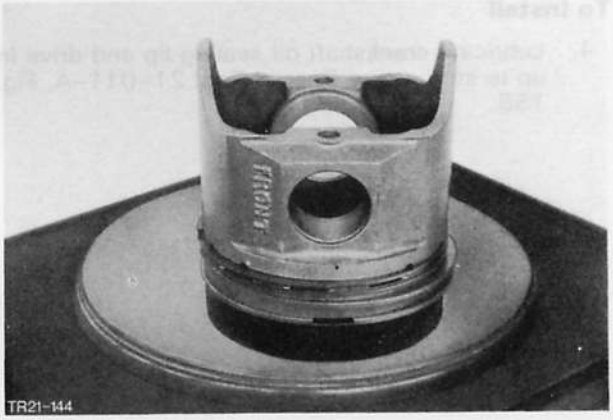



Fig. 161. Heat piston on heater plate

**To Install**

3. Heat piston on hot plate, Fig. 161, apply oil to small end bore and slide piston pin into piston by hand until pin becomes located, then insert piston pin centrally into piston.

   **Front mark on piston and connecting rod must be on same side, Fig. 162.**

4. Fit circlips into piston pin bores.

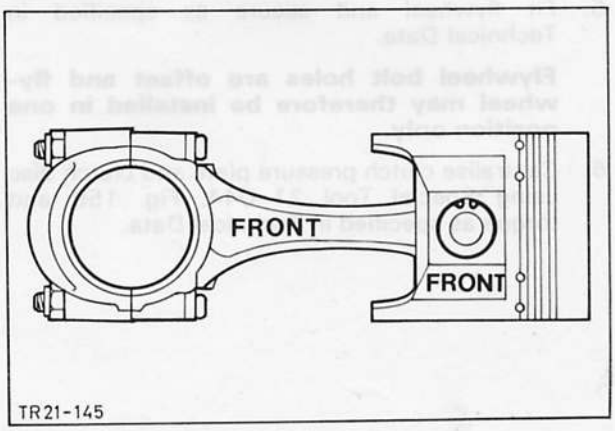



Fig. 162. Piston and connecting rod 'FRONT' mark

## 21 584 5 RING GEAR – FLYWHEEL – REPLACE (flywheel removed)

**Special Service Tools Required: None**

**To Remove:**

1. Centre punch ring gear and drill two holes approximately 7 or 8 mm (0,3 in) diameter offset as illustrated, Fig. 163.

   **Drill must only pass through ring gear and not flywheel.**


Fig. 163. Drill ring gear

2. Remove ring gear from flywheel by tapping with hammer, Fig. 164.
3. Place new ring gear on a plate some 2 to 3 mm (0,08 to 0,12 in) thick and heat up plate to 260° to 280 °C (500° to 540 °F) from below, in area of ring gear itself, using a welding torch to give uniform heating, Fig. 165. To monitor temperature, mark ring gear with a thermochromatic coloured pencil (Faber Castell 2815) before starting heating operation. On reaching temperature indicated on cover, colour marked on ring gear changes to colour on pencil cover.


Fig. 164. Remove ring from flywheel

**Example**

If coloured pencil is green and cover black, indicated temperature (260° to 280 °C (500° to 540 °F)) is reached when green coloured mark on ring gear goes black.

**To Install**

4. Slip ring gear over flywheel with tongs so that ring gear comes to rest on abutment rim. Allow to cool in this position.

   **Starter ring gear is induction-hardened and loses this hardness as soon as it is heated to over 290 °C (550 °F).**

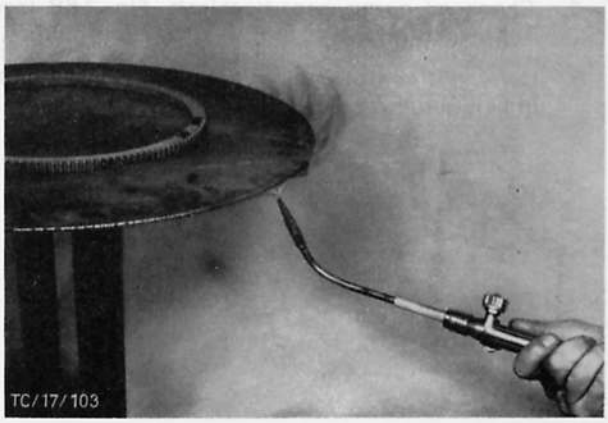



Fig. 165. Heat ring gear

## 21 714 OIL PUMP – REMOVE AND INSTALL

**Special Service Tools Required:**

| | |
|---|---|
| Camshaft gear timing peg | 21–016 |
| Crankshaft flange holding wrench | 21–018 |
| Crankshaft flange bolt remover/replacer | 21–019 |
| Crankshaft front oil seal aligner | 21–025 |

With the exception of removal and installation, as well as checking oil pump gear backlash this operation is contained in Operation **21 467 – Crankshaft front oil seal – replace** and should be carried out as follows:

**To Remove**

1. Carry out sub-operations 1–19 as described in Operation 21 467.
2. Remove oil pump complete with mounting from engine block (3 bolts), Fig. 166.

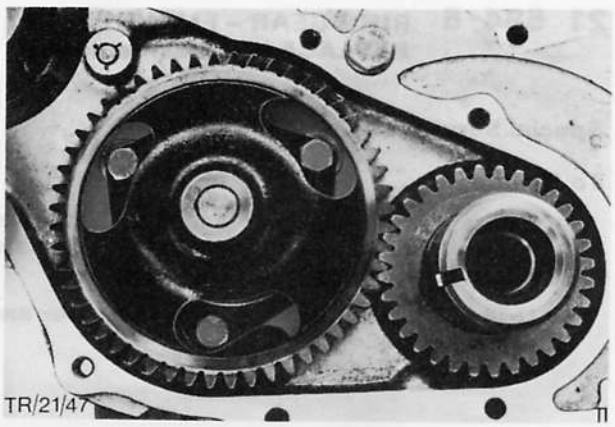



Fig. 166. Remove oil pump

**To Install**

3. Fit oil pump with new O-rings, Fig. 167 to mounting.

   **Before installation crank oil pump by hand and fill with engine oil.**

   Oil pump bores are offset and the pump may therefore be installed in one position only.

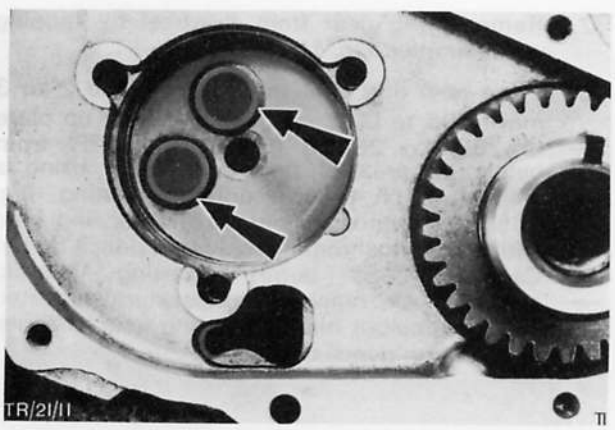



Fig. 167. Fit O-rings

4. Check oil pump gear backlash, Fig. 168 (see Technical Data) and fit new gears if required.
5. Carry out sub-operations 22–38 as described in Operation 21 467.


Fig. 168. Check backlash

## 21 714 8 OIL PUMP – OVERHAUL (oil pump removed)

**Special Service Tools Required: None**

**To Dismantle**

1. Remove oil pump cover (1 bolt).
2. Remove outer rotor by inverting pump.
3. Drive retaining pin out of gear and inner rotor and press out rotor, pump housing and retainer plate by means of suitable press.

**To Reassemble**

4. Assemble pump housing, retainer plate and inner rotor, sliding retainer plate recess behind housing lug, Fig. 169 and press gear on to shaft.

   **If existing shaft is to be re-used drill retaining pin bore at 90° to the existing bore.**

5. Drill **new** hole in rotor shaft. Secure rotor and gear with retaining pin.
6. Insert outer rotor with chamfered side into housing, Fig. 170.

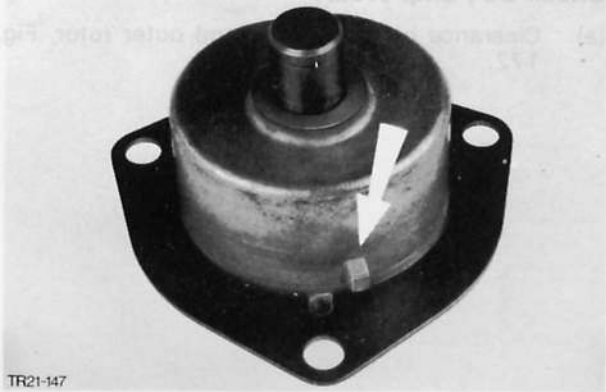



Fig. 169. Slide oil pump retainer plate behind pump housing lug


Fig. 170. Insert outer rotor with chamfered side into housing

7. Fit pump housing cover, ensuring bolt simultaneously engages in retainer plate recess, Fig. 171.


Fig. 171. Fit pump housing cover

## 21 714 8 (cont'd)

**Check Oil Pump Wear:**

(a) Clearance between inner and outer rotor, Fig. 172.

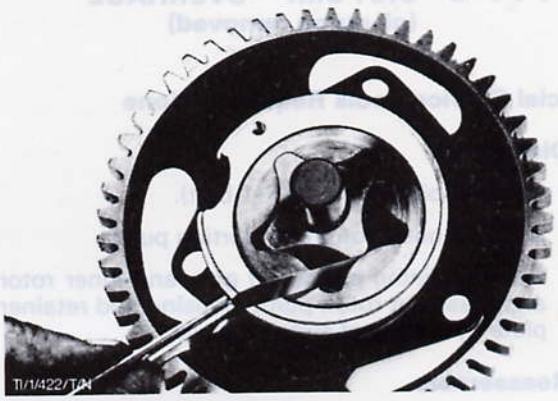



Fig. 172. Measure inner/outer rotor clearance

(b) Clearance between pump housing and outer rotor, Fig. 173.


Fig. 173. Measure clearance pump housing/outer rotor

(c) Clearance between rotors and pump housing joint face, Fig. 174.

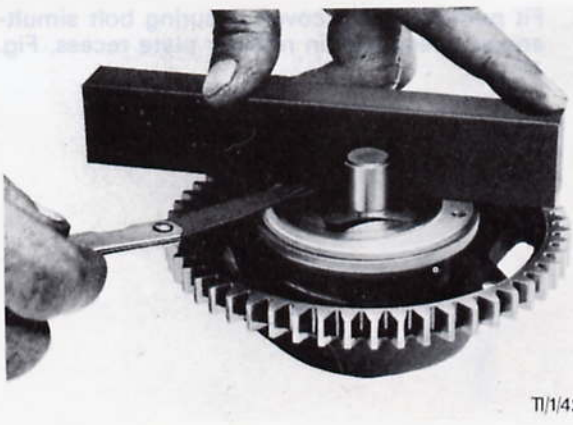



Fig. 174. Check axial play

## 21 875 ENGINE FRONT MOUNTING RUBBER INSULATOR – REPLACE

**Special Service Tools Required: None**

**To Remove**

1. Remove upper and lower engine mounting rubber insulator nuts, Fig. 175.
2. Raise engine with jack and suitable wooden block from underneath sump far enough to enable rubber insulator complete with plate and washer to be removed.


Fig. 175. Remove nuts from engine mounting rubber insulator

**To Install**

3. Fit rubber insulator with plate and washer, Fig. 176 and lower engine.
4. Secure upper and lower nut as specified in Technical Data.

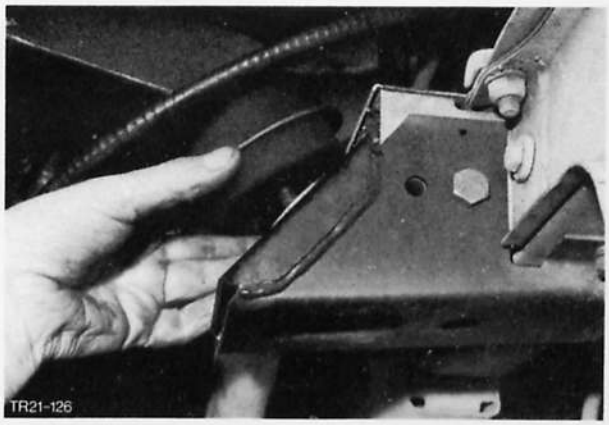



Fig. 176. Fit rubber insulator

## TECHNICAL DATA — 'G'-ENGINE (OHV/1–4)

### Engine

| | | | |
|---|---|---|---|
| Engine code | | | 4AA |
| Firing order | | | 1–2–4–3 |
| Bore | | mm (in) | 93,67 (3,69) |
| Stroke | | mm (in) | 85,60 (3,37) |
| Cubic capacity | | $cm^3$ | 2358 |
| Compression ratio | | | 21,5:1 |
| Compression pressure | bar ($kgf/cm^2$) ($lbf/in^2$) | | 28,0 (28,0) (406) |
| Cylinder pressure deviation approx. | bar ($kgf/cm^2$) ($lbf/in^2$) | | 8,0 (8,0) (116) |
| Output at 3600 rev/min | kw (hp) | | 46 (62) |
| Torque at 2750 rev/min | Nm (kgf m) (lbf ft) | | 130 (13,3) (96) |
| Idling speed rev/min | | | 750 |

### Cylinder Block

| | | | |
|---|---|---|---|
| Number of main bearings | | | 5 |
| Cylinder bore dia. (measured 90 mm below top face) | | | |
| | grade 1 | mm | 93,648–93,680 |
| | grade 2 | mm | 93,660–93,672 |
| | grade 3 | mm | 93,672–93,684 |
| | grade 4 | mm | 93,684–93,696 |
| Main bearing bore | rear | mm | 81,00–81,02 |
| | remainder | mm | 74,00–74,02 |
| Camshaft bearing bore | | mm | 61,000–61,046 |

### Crankshaft

| | | | |
|---|---|---|---|
| Main bearing crank pin dia. | rear | mm | 76,98–77,00 |
| | remainder | mm | 69,98–70,00 |
| Main bearing shell length | front | mm | 27,95–28,45 |
| | intermediate | mm | 34,04–34,30 |
| | centre | mm | 35,55–35,60 |
| | rear | mm | 30,10–30,85 |
| Main bearing shell thickness | standard red | mm | 1,970–1,979 |
| | blue | mm | 1,980–1,989 |
| | undersize | mm | 0,25/0,50/0,75 |
| | oversize | mm | 0,40 |
| Main bearing clearance | | mm | 0,052–0,090 |
| Main bearing shell width | front and intermediate | mm | 22,87–23,13 |
| | centre | mm | 26,86–27,10 |
| | rear | mm | 21,87–22,13 |
| Thrust washer thickness | standard | mm | 2,31–2,36 |
| | oversize | mm | 0,06/0,12/0,18 |
| | | mm | 0,25/0,40/0,50 |
| Crankshaft end float | | mm | 0,05–0,25 |
| Permissible wear | | mm | 0,33 |
| Max. crankshaft cranking torque (without pistons) | Nm (kgf m) (lbf ft) | | 3 (0,3) (2,2) |
| Crankpin dia. | | mm | 59,98–60,00 |
| Crankpin length | | mm | 32,28–32,38 |
| Crankpin clearance | | mm | 0,036–0,088 |
| Crankpin shell thickness | standard | mm | 1,726–1,735 |
| | undersize | mm | 0,25/0,50/0,75/1,0 |
| Crankpin shell width | | mm | 25,87–26,13 |
| Number teeth crankshaft gear | | | 32 |

### Flywheel

| | | | |
|---|---|---|---|
| Permissible run-out (at 120 mm radius) (T.I.R.) | | mm (in) | 0,16 (0,006 in) |
| Number of teeth on ring gear | | | 108 |
| Flywheel bolts | | | M 10x1 |
| Flywheel ring gear fitting method (Interference shrink fit) | | mm | 0,30–0,53 |

## TECHNICAL DATA (cont'd)

### Cylinder Head

| | | | |
|---|---|---|---|
| Valve guide length | standard inlet and exhaust | mm | 61,50 |
| Valve guide inside dia. | production | mm | 8,982–9,013 |
| | service | mm | 8,988–9,008 |
| Valve guide outside dia. | standard | mm | 14,725–14,738 |
| Valve seat insert recess dia. | standard inlet | mm | 45,71–45,75 |
| | exhaust | mm | 37,96–38,00 |
| Valve seat insert recess depth | inlet | mm | 9,02–9,31 |
| | exhaust | mm | 9,02–9,31 |
| Valve seat inserts – oversize | inlet outside dia. | mm | 0,25 and 0,5 |
| | exhaust outside dia. | mm | 0,25 and 0,5 |
| Valve seat angle | inlet | from | 45° to 45°30′ |
| | exhaust | from | 30° to 30°30′ |
| Valve head depth cylinder head | inlet | mm | 0,66–1,18 |
| | exhaust | mm | 0,40–0,92 |

### Tappets/Push Rods

| | | | |
|---|---|---|---|
| Push rod length | | mm | 154,4–155,4 |
| Push rod dia. | | mm | 7,72–8,03 |
| Tappet dia. | | mm | 15,973–15,984 |
| Tappet length | | mm | 62,00 |

### Rocker Shaft/Rocker Arms

| | | | |
|---|---|---|---|
| Rocker shaft dia. | | mm | 18,87–18,90 |
| Number rocker arm springs | | | 4 |
| Spring length | at 1,8–2,3 kgf (4–5 lbf) | mm | 26,92 |
| Rocker arm bearing clearance | | mm | 0,02–0,08 |

### Valves

| | | | |
|---|---|---|---|
| Head dia. | inlet | mm | 44,20–44,40 |
| | exhaust | mm | 36,20–36,40 |
| Valve head seat angle | inlet | | 44°30′ to 45° |
| | exhaust | | 29°30′ to 30° |
| Valve stem clearance | inlet | mm | 0,016–0,072 |
| | exhaust | mm | 0,034–0,090 |
| Valve stem dia. | inlet | mm | 8,941–8,966 |
| | exhaust | mm | 8,923–8,948 |

### Valve Springs

| | | | |
|---|---|---|---|
| Number of coils | exhaust outside | | 6,5 |
| | exhaust inside | | 7,5 |
| | inlet | | 6,2 |
| Valve spring free length | exhaust outside | mm | 51,4 |
| | exhaust inside | mm | 47,1 |
| | inlet | mm | 44,45 |
| Spring pressure – valve open | exhaust outside | kgf (lbf) | 59,7–64,3 (132–142) |
| | exhaust inside | kgf (lbf) | 35,1–37,9 (77–83) |
| | inlet | kgf (lbf) | 103,5 (338) |

### Valve Timing/Clearance

| | | | |
|---|---|---|---|
| Valve timing at 0,534 mm (0,021 in) clearance | inlet valve opens | | 10 degrees B.T.D.C. |
| | closes | | 30 degress A.B.D.C. |
| | exhaust valve opens | | 54 degrees B.B.D.C. |
| | closes | | 10 degrees A.T.D.C. |
| Valve lift | inlet | mm | 9,75 |
| | exhaust | mm | 10,50 |
| Valve clearance cold, inlet and exhaust valve | | mm | 0,35 (0,014) |

### Camshaft

| | | | |
|---|---|---|---|
| Number of bearings | | | 5 |
| Drive | | | via toothed belt |
| Cam lift | inlet | mm | 6,5 |
| | exhaust | mm | 7,0 |
| Bearing – oversize – outside dia. | | mm | 0,508 |
| Journal dia. | | mm | 55,942–55,960 |
| Camshaft bearing clearance | | mm | 0,075–0,114 |
| Camshaft end float | | mm | 0,05–0,20 |

### Pistons

| | | | | |
|---|---|---|---|---|
| Ring groove width | compression ring | upper | mm | 2,258–2,278 |
| | | lower | mm | 2,426–2,451 |
| | oil scraper ring | | mm | 4,776–4,800 |
| Piston pin bore | | red | mm | 28,9925–28,9950 |
| | | yellow | mm | 28,9950–28,9975 |
| | | blue | mm | 28,9975–29,0000 |
| Piston clearance in bore | | | mm | 0,128–0,152 |
| Piston dia. | | grade 1 | mm | 93,508–93,520 |
| | | grade 2 | mm | 93,520–93,532 |
| | | grade 3 | mm | 93,532–93,544 |
| | | grade 4 | mm | 93,544–93,556 |
| Piston oversize | | | mm | 0,65/1,00 |
| Clearance between piston crown and block face at TDC | | | mm | 0,114–0,213 |

### Piston Ring

| | | | | |
|---|---|---|---|---|
| Compression ring | | upper | | chrome plated, barrel faced |
| | | lower | | chrome plated, stepped |
| Oil scraper ring | | | | chrome plated, expansion spring |
| Ring gap | compression ring, | upper | mm | 0,25–0,50 |
| | | lower | mm | 0,25–0,50 |
| | oil scraper ring | | mm | 0,25–0,58 |
| Ring width | compression ring, | upper | mm | 2,158–2,178 |
| | | lower | mm | 2,350–2,375 |
| | oil scraper ring | | mm | 4,724–4,737 |
| Ring to groove clearance | compression rings | | mm | 0,041–0,089 |
| | oil scraper ring | | mm | 0,039–0,076 |

### Piston Pin

| | | | |
|---|---|---|---|
| Type | | | floating in piston and connecting rod |
| Outside dia. | | mm | 28,990–28,998 |
| Clearance in piston at 20 °C (68 °F) | | mm | 0,000–0,005 |
| Retention method | | | circlips |

### Connecting Rods

| | | | |
|---|---|---|---|
| Length | | mm | 153,975–154,025 |
| Small end bore with bush | | mm | 29,010–29,022 |
| Clearance between small end bush and piston pin | | mm | 0,0125–0,032 |
| Big end bore | | mm | 63,506–63,520 |
| Big end journal clearance | | mm | 0,036–0,088 |
| Big end journal end float | | mm | 0,127–0,279 |

## TECHNICAL DATA (cont'd)

### Engine Lubrication

| | | | |
|---|---|---|---|
| System | | | pressure feed |
| Oil grade | | | HD multi-purpose oil |
| Oil specification | | | ESEE-M2C-1004A or SP-M2C-9104A |
| | Viscosity below +10 °C (50 °F) | | 5W/20 |
| | −20° to +10 °C (−4° to 50 °F) | | 5W/30 |
| | −10° to +32 °C (14° to 90 °F) | | 10W/30 |
| | −10° to +40 °C (14° to 104 °F) | | 10W/40 |
| | | | 10W/50 |
| | | | 20W/40 |
| | above +20 °C (68 °F) | | 20W/50 |
| Oil change | interval km (miles) | | 5000 (3000) |
| Oil capacity | without filter litre (pints) | | 5,2 (9,2) |
| | with filter litre (pints) | | 6,2 (10,9) |

### Oil Pump

| | | | |
|---|---|---|---|
| Type | | | twin rotor |
| Drive gear backlash | | mm | 0,051–0,338 |
| Capacity | at 2460 rev/min | litres/min | 56 |
| Pump housing bore dia. | | mm | 57,2262–57,3024 |
| Drive shaft dia. | | mm | 15,8242–15,8369 |
| Rotor end float | | mm | 0,017–0,098 |
| Inner to outer rotor clearance | max. | mm | 0,152 |
| Outer rotor to housing clearance | | mm | 0,1362–0,3132 |

### Tightening Torques

| | | Nm | kgf m | lbf ft |
|---|---|---|---|---|
| Main bearing bolts | 1) | 120–130 | 12,0–13,0 | 90 |
| | 2) | 130–140 | 13,0–14,0 | 96 |
| Connecting rod bolts | 1) | 48–62 | 4,8–6,2 | 40 |
| | 2) | 62–73 | 6,2–7,3 | 50 |
| Cylinder head (see tightening sequence) | | 142–152 | 14,2–15,2 | 105 |
| Flywheel | | 60–65 | 6,0–6,5 | 45 |
| Camshaft pulley | | 105–120 | 10,5–12,0 | 85 |
| Oil drain plug | | 21–28 | 2,1–2,8 | 17 |
| Rocker shaft | bolts M10 | 66–70 | 6,6–7,0 | 50 |
| | M8 | 16–20 | 1,6–2,0 | 14 |
| Cylinder block intermediate plate | bolts 1–9 | 27–33 | 2,7–3,3 | 21 |
| | bolts 10 | 20–25 | 2,0–2,5 | 11 |
| Oil pump cover intermediate plate | | 20–25 | 2,0–2,5 | 11 |
| Oil sump | | 17–20 | 1,7–2,0 | 12 |
| Inlet manifold | | 12–15 | 1,2–1,5 | 9 |
| Exhaust manifold | | 41–51 | 4,1–5,1 | 33 |
| Crankshaft centre bolt | | 318–346 | 31,8–34,6 | 240 |
| Cylinder block rear oil seal carrier | | 18–21 | 1,8–2,1 | 14 |
| Oil pump/cylinder block | | 17–20 | 1,7–2,0 | 14 |
| Intermediate plate injection pump | | 22–30 | 2,2–3,0 | 17 |
| Intermediate plate water pump | | 11–15 | 1,1–1,5 | 9 |
| Camshaft/cylinder block blanking plate | | 13–18 | 1,3–1,8 | 11 |
| Camshaft/cylinder block thrust plate | | 25–30 | 2,5–3,0 | 20 |
| Vacuum pump intermediate plate | | 32–40 | 3,2–4,0 | 26 |
| or blanking cover in lieu of vacuum pump | | 25–30 | 2,5–3,0 | 20 |
| Oil filter – cylinder block (full flow filter) | | 21–25 | 2,1–2,5 | 17 |
| Oil pump suction pipe | | 12–15 | 1,2–1,5 | 9 |
| Oil pressure relief valve bolt | | 55–60 | 5,5–6,0 | 41 |
| Toothed belt cover | | 5–9 | 0,5–0,9 | 5 |
| Alternator bracket | | 20–29 | 2,0–2,9 | 17 |
| Alternator to bracket | | 20–29 | 2,0–2,9 | 17 |