REMOVAL

 Drain cooling system and disconnect battery ground cable.

(2) Remove alternator, throttle body, air cleaner and fuel line.

(3) Disconnect accelerator linkage.

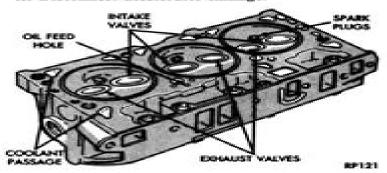


Fig. 4 Cylinder Head Assembly

(4) Remove distributor cap and wires.

(5) Disconnect coil wires, heat indicator sending unit wire, heater hoses and bypass hose.

(6) Remove closed ventilation system, evaporation control system and cylinder head covers.

(7) Remove intake manifold, and throttle body as an assembly.

(8) Remove exhaust manifolds.

(9) Remove rocker arm and shaft assemblies. Remove push rods and identify to ensure installation in original locations.

(10) Remove the 8 head bolts from each cylinder head and remove cylinder heads.

(11) Place cylinder heads in holding fixture Tool C-3626. Remove spark plugs.

INSTALLATION

 Clean all surfaces of cylinder block and cylinder heads.

(2) Inspect all surfaces with a straightedge if there is any reason to suspect leakage. If out of flatness exceeds 0.00075 mm/mm (0.00075 inch/inch) times the span length in inches in any direction, either replace head or lightly machine the head surface.

FOR EXAMPLE—If a 305 mm (12 inch) span is 0.102 mm (0.004 inch) out of flat, allowable is 305 X 0.00075 (12 X 0.00075) equals 0.23 mm (0.009 inch). This amount of out of flat is acceptable.

(3) The cylinder head surface finish should be 1.78-4.57 microns (70-180 microinches).

(4) Install new gaskets on cylinder block.

(5) Remove cylinder heads from holding fixtures and place heads on engine.

(6) On 6 cylinder engines bolt thread sealer is not required. Starting at top center, tighten all cylinder head bolts to 68 N·m (50 ft. lbs.) torque in sequence (Fig. 5). Repeat procedure, tighten all cylinder head bolts to 143 N·m (105 ft. lbs.) torque. Repeat procedure to confirm that all bolts are at 143 N·m (105 ft. lbs.) torque.

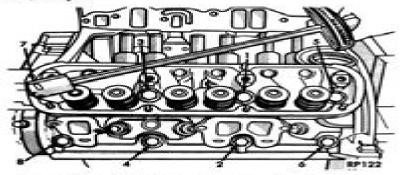


Fig. 5 Cylinder Head Bolt Tightening Sequence

(7) Inspect push rods and replace worn or bent rods.

(8) Install push rods, rocker arm and shaft assemblies with the NOTCH on the end of rocker shaft pointing to centerline of engine and toward front (left bank) and to the rear (right bank). The notch is always to left as facing cylinder head. Make sure to install the long stamped steel retainers in the number two and four positions. Tighten the bolts to 23 N·m (200 in. lbs.) torque (Fig. 3).

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R Barnett

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