

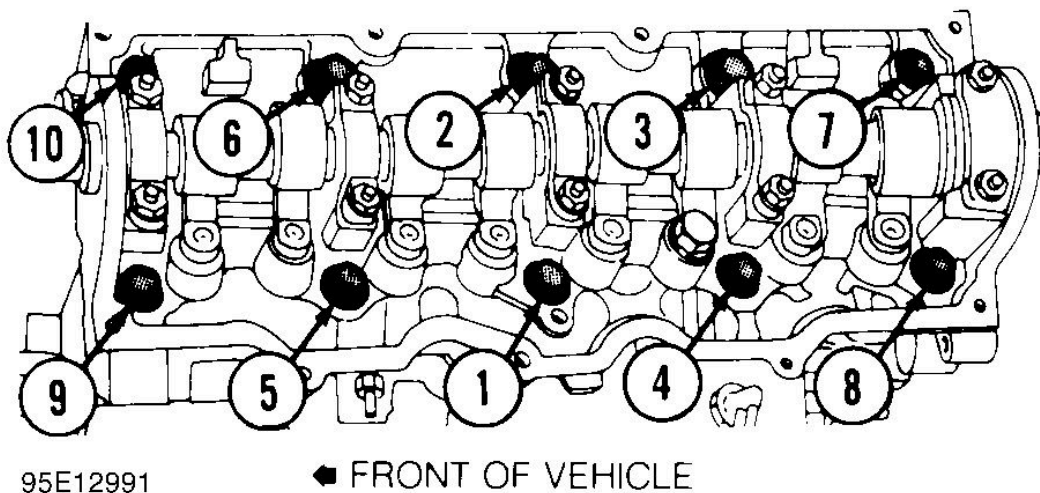
Ensure all surfaces and head bolts are clean. Check that head bolt holes of cylinder block are clean and dry to prevent block damage when bolts are tightened. Clean threads with tap to ensure accurate bolt torque.

Install head gasket on cylinder block. Some manufacturers may recommend sealant be applied to head gasket prior to installation. Note that all holes are aligned. Some gasket applications may be marked so that certain area faces upward. Install cylinder head using care not to damage head gasket. Ensure cylinder head is fully seated on cylinder block.

Some applications require head bolts be coated with sealant prior to installation. This is done if head bolts are exposed to coolant passages. Some applications require head bolts be coated with light coat of engine oil.

Install head bolts. Head bolts should be tightened in proper steps and sequence to specification. See **Fig. 1**. Install remaining components. Tighten all bolts to specification. Adjust valves if required. See VALVE ADJUSTMENT.

**NOTE:** Some manufacturers require that head bolts be retightened after specified amount of operation. This must be done to prevent head gasket failure.



**Fig. 1: Typical Cylinder Head Tightening or Loosening Sequence**

## VALVE ADJUSTMENT

**NOTE:** Examples used in this article are general in nature and do not necessarily relate to a specific engine or system. Illustrations and procedures have been chosen to guide mechanic through engine overhaul process. Descriptions of processes of cleaning, inspection, assembly and machine shop practice are included.

Always refer to appropriate engine overhaul article, if available, in the **ENGINES**

**section for complete overhaul procedures and specifications for the vehicle being repaired.**

Engine specifications will indicate valve train clearance and temperature at which adjustment is to be made on most models. In most cases, adjustment will be made with a cold engine. In some cases, both a cold and a hot clearance will be given for maintenance convenience.

On some models, adjustment is not required. Rocker arms are tightened to specification and valve lash is automatically set. On some models with push rod actuated valve train, adjustment is made at push rod end of rocker arm while other models do not require adjustment.

Clearance will be checked between tip of rocker arm and tip of valve stem in proper sequence using a feeler gauge. Adjustment is made by rotating adjusting screw until proper clearance is obtained. Lock nut is then tightened. Engine will be rotated to obtain all valve adjustments to manufacturer's specifications.

Some models require hydraulic lifter to be bled down and clearance measured. Push rods of different length can be used to obtain proper clearance. Clearance will be checked between tip of rocker arm and tip of valve stem in proper sequence using a feeler gauge.

Overhead cam engines designed without rocker arms actuate valves directly on a cam follower. A hardened, removable disc is installed between the cam lobe and lifter. Clearance will be checked between cam heel and adjusting disc in proper sequence using a feeler gauge. Engine will be rotated to obtain all valve adjustments.

On overhead cam engines designed with rocker arms, adjustment is made at valve end of rocker arm. Ensure valve to be adjusted is riding on heel of cam on all engines. Clearance will be checked between tip of rocker arm and tip of valve stem in proper sequence using a feeler gauge. Adjustment is made by rotating adjusting screw until proper clearance is obtained. Lock nut is then tightened. Engine will be rotated to obtain all valve adjustments to manufacturer's specifications.

**CYLINDER HEAD OVERHAUL**

**\* PLEASE READ THIS FIRST \***

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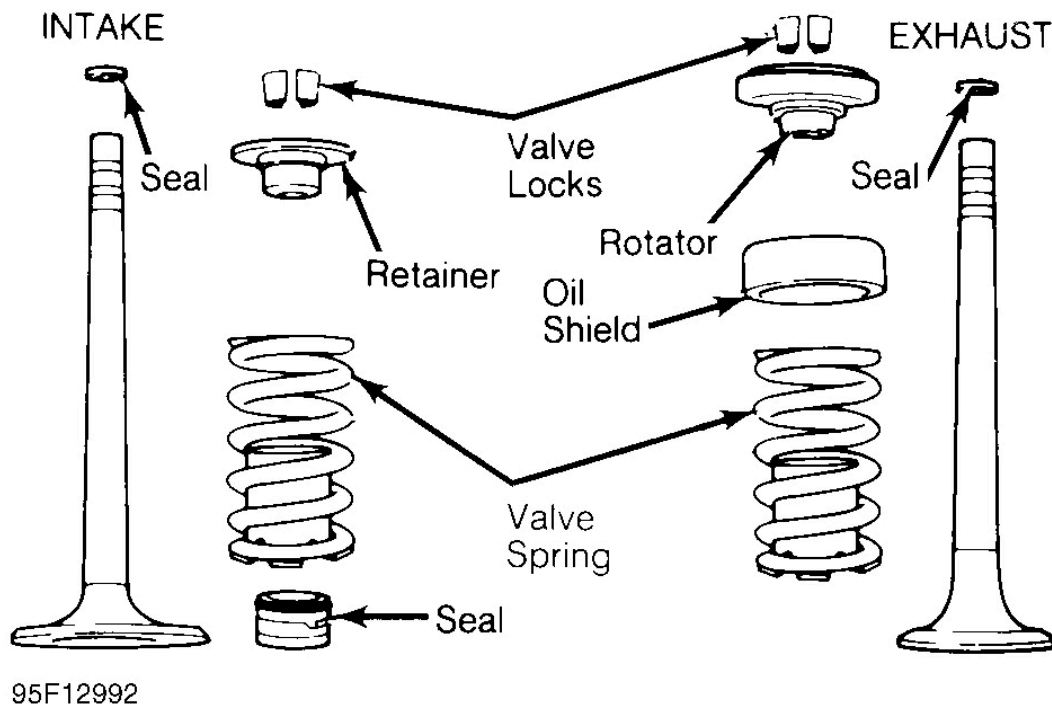
**CYLINDER HEAD DISASSEMBLY**

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Mark valves for location. Using valve spring compressor, compress valve springs. Remove valve locks. Carefully release spring compressor. Remove retainer or rotator, valve spring, spring seat and valve. See **Fig. 2**.



**Fig. 2: Exploded View of Valve Assemblies**

## CYLINDER HEAD CLEANING & INSPECTION

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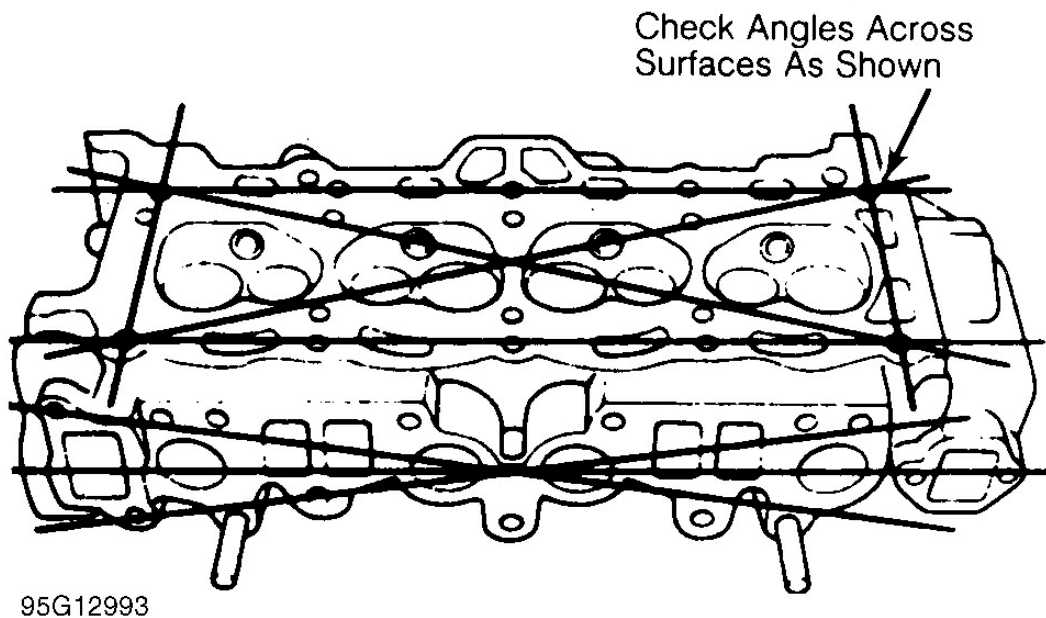
**being repaired.**

Clean cylinder head and valve components using approved cleaning methods. Inspect cylinder head for cracks, damage or warped gasket surface. Place straightedge across gasket surface. Determine clearance at center of straightedge. Measure across both diagonals, longitudinal center line and across cylinder head at several points. See **Fig. 3**.

On cast iron cylinder heads, if warpage exceeds .003" (.08 mm) in a 6" span, or .006" (.15 mm) over total length, cylinder head must be resurfaced. On most aluminum cylinder heads, if warpage exceeds .002" (.05 mm) in any area, cylinder head must be resurfaced. Warpage specification may vary by manufacturer. If warpage exceeds specification on some cylinder heads, cylinder head must be replaced.

Cylinder head thickness should be measured to determine amount of material which can be removed before replacement is required. Cylinder head thickness must not be less than the manufacturer's specification.

If cylinder head required resurfacing, it may not align properly with intake manifold. On "V" type engines, misalignment is corrected by machining intake manifold surface that contacts cylinder head. Cylinder head may be machined on surface that contacts intake manifold. Using oil stone, remove burrs or scratches from all sealing surfaces.



**Fig. 3: Checking Cylinder Head for Warpage**

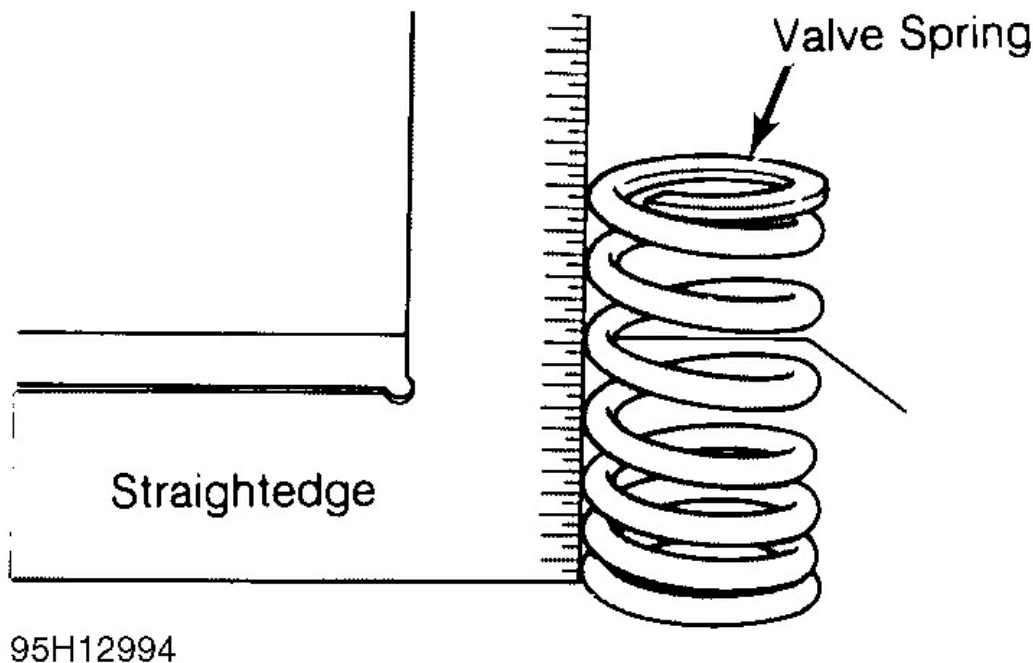
## VALVE SPRINGS

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Inspect valve springs for corroded or pitted valve spring surfaces which may lead to breakage. Polished spring ends caused by a rotating spring indicate that spring surge has occurred. Replace springs showing evidence of these conditions.

Inspect valve springs for squareness using a 90-degree straightedge. See **Fig. 4**. Replace valve spring if out-of-square exceeds manufacturer's specification.

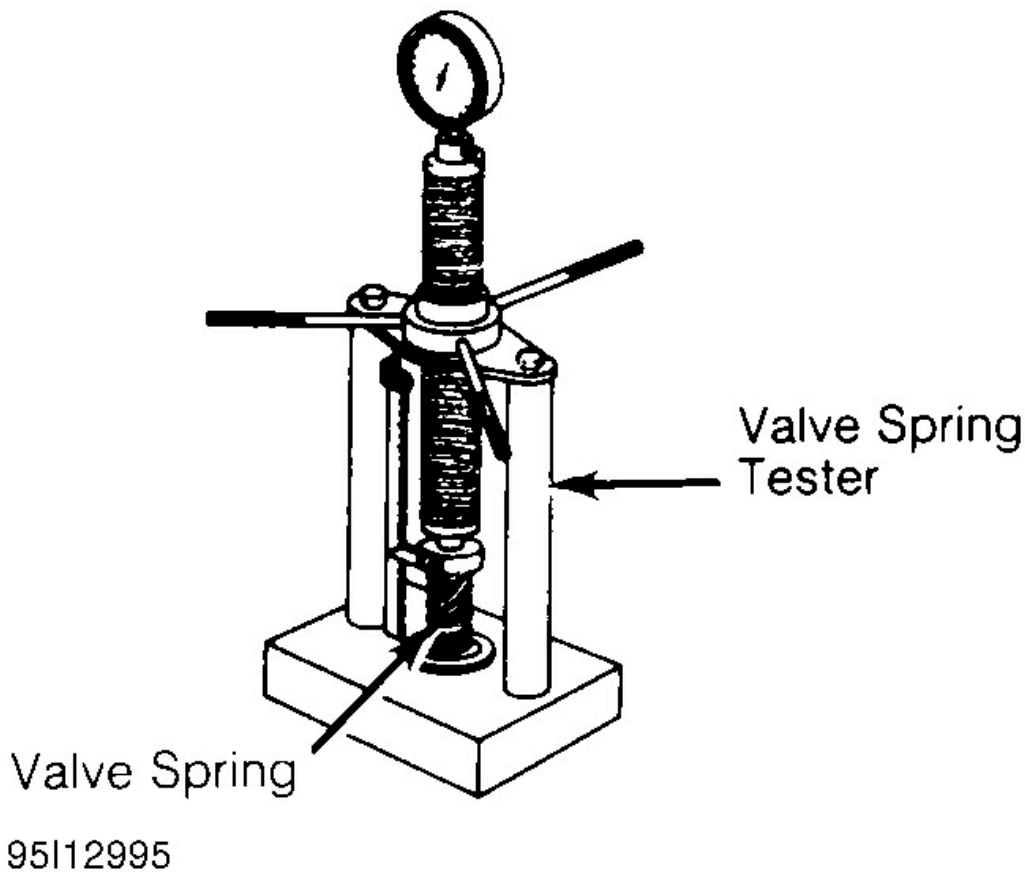


**Fig. 4: Checking Valve Spring Squareness**

Using vernier caliper, measure free length of all valve springs. Replace springs if not within specification. Using valve spring tester, test valve spring pressure at installed and compressed heights. See **Fig. 5**.

Usually compressed height is installed height minus valve lift. Replace valve spring if not within specification.

It is recommended to replace all valve springs when overhauling cylinder head. Valve springs may need to be installed with color coded end or small coils at specified area according to manufacturer.



**Fig. 5: Checking Valve Spring Pressure**

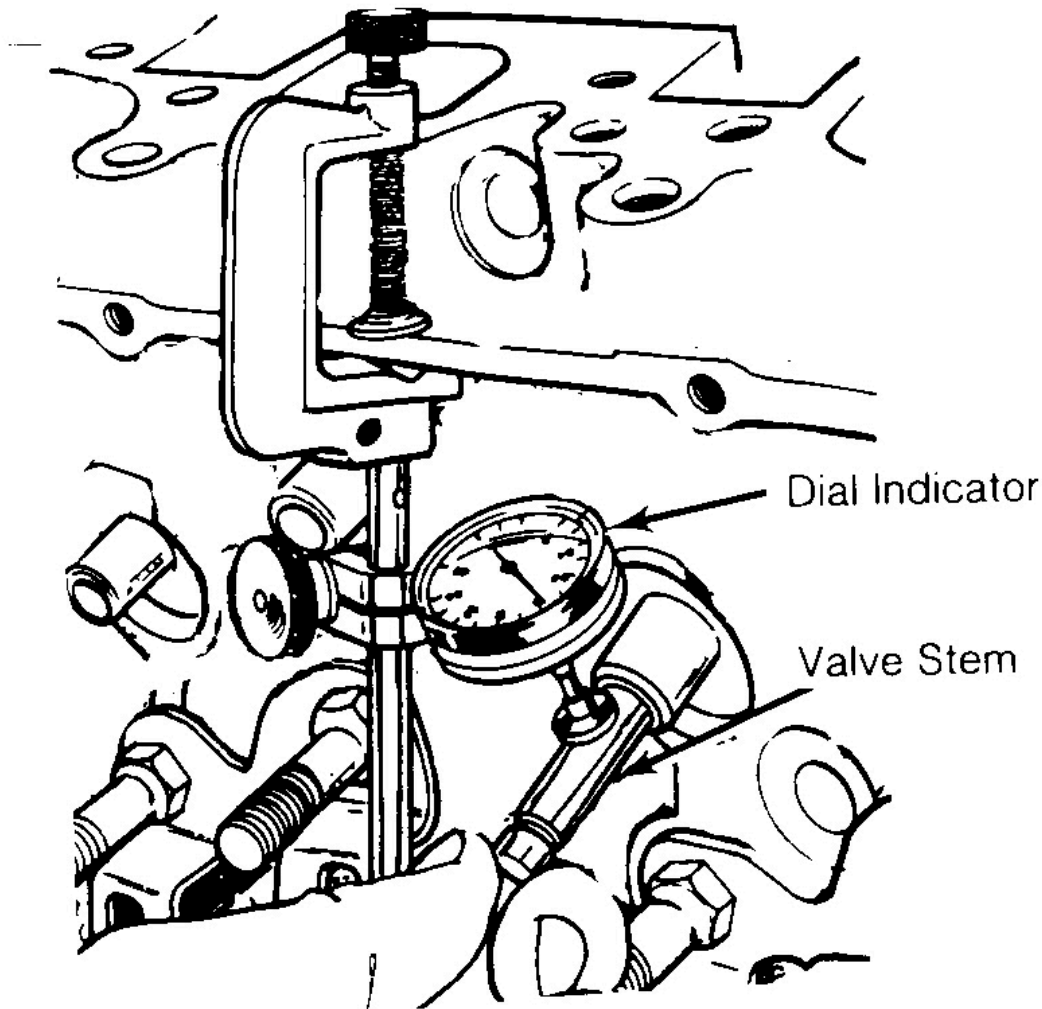
#### **VALVE GUIDE**

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### Measuring Valve Guide Clearance

Check valve stem-to-guide clearance. Ensure valve stem diameter is within specification. Install valve in valve guide. Install dial indicator assembly on cylinder head with tip resting against valve stem just above valve guide. See **Fig. 6**.



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**Fig. 6: Measuring Valve Stem-to-Guide Clearance**

Lower valve approximately 1/16" below valve seat. Push valve stem against valve guide as far as possible. Adjust dial indicator to zero. Push valve stem in opposite direction and note reading. Clearance must be within specification.