

Figure 15 Oversize Lifter Marking

If the lifters are removed, they must be reinstalled in their original location. If replacement is necessary use lifters with a narrow flat ground along the lower 3/4 of lifter. These flats provide additional oil to the cam lobe and lifter surfaces.

**Remove or Disconnect**

1. Drain coolant.
2. Intake manifold.
3. Valve mechanism.
4. Valve lifter.

**Inspect**

- For inspection and overhaul procedures refer to Section 6A, General Engine Mechanical

**Install or Connect**

Whenever new valve lifters are being installed, coat foot of valve lifters with "Molykote" or equivalent.

1. Valve lifter.
2. Valve mechanism
3. Intake manifold.
4. Engine coolant

**Adjust**

- Valve lash

CYLINDER HEAD**Left****Remove or Disconnect**

1. Raise vehicle.
2. Drain coolant from block.
3. Lower vehicle.
4. Intake manifold
5. Exhaust crossover pipe.
6. Generator bracket
7. Oil level indicator tube.
8. Loosen rocker arms until able to remove push rods.
9. Cylinder head bolts.
10. Cylinder head.

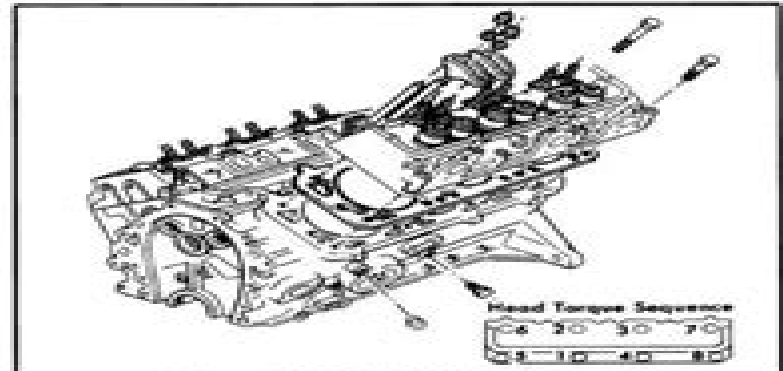


Figure 16 Cylinder Head Installation

**Clean**

- Gasket surfaces on the head, cylinder block and intake manifold.
- Cylinder block bolt threads
- Cylinder head bolts

**Inspect**

- For cylinder head overhaul procedures, refer to Section 6A, General Engine Mechanical

**Install or Connect**

1. Place the gasket in position over the dowel pins, with the note "This Side Up" showing.
2. Cylinder head.
3. Coat cylinder head bolt threads with GM 1052080 Sealer, or equivalent, and install bolts.

**Tighten**

- Bolts in sequence - 90 N·m (66 lb.ft.) (Figure 16).
4. Push rods and loosely retain with rocker arms.

**Important**

- Make sure lower ends of push rods are in lifter seats.

**Adjust**

- Valve lash.
5. Intake manifold and gaskets.
 6. Oil level indicator tube bracket to head.
 7. Heat stove pipe and air supply pipe.
 8. Attach alternator bracket and stud.
 9. Exhaust pipe.
 10. Exhaust Crossover Pipe.

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