

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.

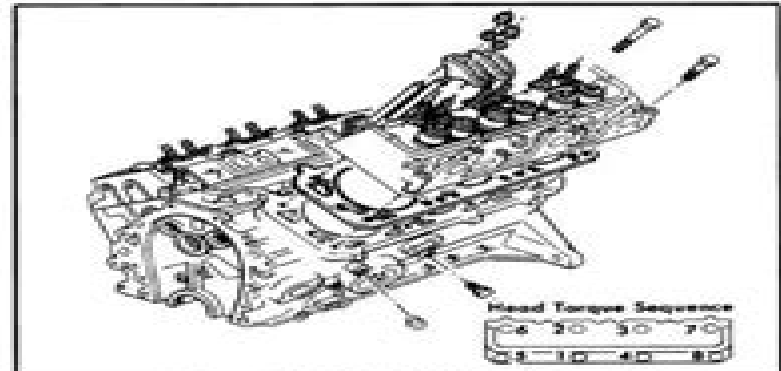


Figure 16 Cylinder Head Installation

**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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Hussin A.Rothana



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 - The Rise of Digital Reading Pontiac Fiero Gm Service Manual 1987
 - Advantages of eBooks Over Traditional Books
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 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Pontiac Fiero Gm Service Manual 1987
 - User-Friendly Interface
4. Exploring eBook Recommendations from Pontiac Fiero Gm Service Manual 1987
 - Personalized Recommendations
 - Pontiac Fiero Gm Service Manual 1987 User Reviews and Ratings
 - Pontiac Fiero Gm Service Manual 1987 and Bestseller Lists
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- ePub, PDF, MOBI, and More
 - Pontiac Fiero Gm Service Manual 1987 Compatibility with Devices
 - Pontiac Fiero Gm Service Manual 1987 Enhanced eBook Features
7. Enhancing Your Reading Experience
- Adjustable Fonts and Text Sizes of Pontiac Fiero Gm Service Manual 1987
 - Highlighting and Note-Taking Pontiac Fiero Gm Service Manual 1987
 - Interactive Elements Pontiac Fiero Gm Service Manual 1987
8. Staying Engaged with Pontiac Fiero Gm Service Manual 1987
- Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Pontiac Fiero Gm Service Manual 1987
9. Balancing eBooks and Physical Books Pontiac Fiero Gm Service Manual 1987
- Benefits of a Digital Library
 - Creating a Diverse Reading Collection Pontiac Fiero Gm Service Manual 1987
10. Overcoming Reading Challenges
- Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Pontiac Fiero Gm Service Manual 1987
- Setting Reading Goals Pontiac Fiero Gm Service Manual 1987
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Pontiac Fiero Gm Service Manual 1987
- Fact-Checking eBook Content of Pontiac Fiero Gm Service Manual 1987
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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