

INSPECTION AND REPAIR

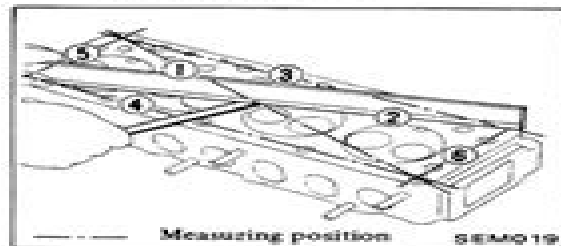
Clean all removed parts in cleaning oil, eliminating obstacles or dust/dirt from passages or holes. Also check these parts to make sure they are free from cracks or flaws.

CYLINDER HEAD AND VALVE

CHECKING CYLINDER HEAD MATING FACE

Measure the surface of cylinder head (on cylinder block side) for warpage.

Warpage of surface:
Less than
0.2 mm (0.008 in)



If beyond the specified limit, correct with a surface grinder.

Cylinder head height should be greater than 89.7 mm (3.531 in) after surface has been ground.

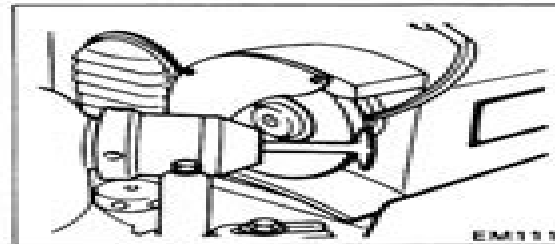
VALVE

1. Check each of the intake and exhaust valve for worn, damaged or deformed valve stems. Correct or replace the valve that is faulty.

For standard size of valve, refer to S.D.S.

2. Valve face or valve stem end surface should be refaced by using a valve grinder.

Valve face angle:
45° - 45°30'



VALVE LIFTER AND PUSH ROD

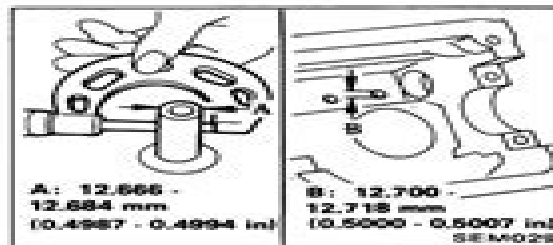
Valve lifter

1. Check valve lifters for excessive wear on the face.
2. Replace with new ones if worn beyond repair.

- a. Valve lifter end should be smooth.
- b. Valve lifter to lifter hole clearance:

Standard
0.016 - 0.052 mm
(0.0006 - 0.0020 in)

Limit
Less than
0.10 mm (0.0039 in)



Push rod

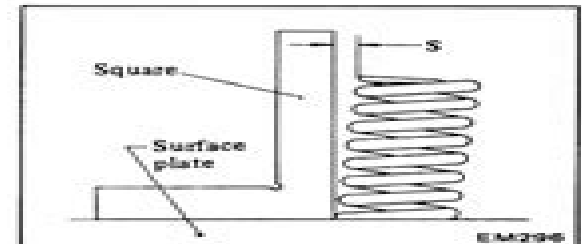
1. Inspect push rod for excessive wear on the face.
2. Replace if worn or damaged beyond repair.
3. Check push rod for bend using a dial gauge.

Maximum allowable bend:
Less than
0.5 mm
(0.020 in)

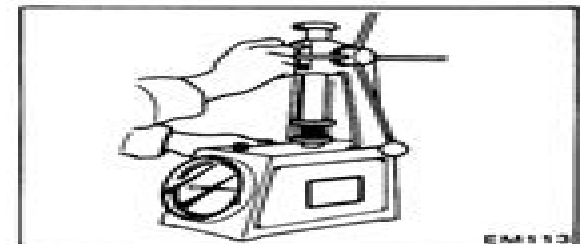
VALVE SPRING

1. Check valve spring for squareness using a steel square and surface plate. If spring is out of square "S" more than specified limit, replace with new ones.

Out of square ("S"):
Less than
1.3 mm (0.051 in)



2. Measure free length and tension of spring. If measured value exceeds specified limit, replace spring. Refer to S.D.S.



VALVE ROCKER ASSEMBLY

1. Check valve rockers, brackets and rocker shafts for scoring, wear or distortion. Replace if necessary.

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RD Boyd



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Engine Service Manual ,1986 **Engine Service Manual** Nissan Diesel Motor Co Ltd,1988 **Nissan Diesel Engine Repair Manual Model UD63** ,1976* *Service Manual* ,1982 Detroit Diesel Engines Highway Vehicle Series 53 General Motors Corporation. Detroit Diesel Allison Division,1973 *Small Diesel Engine Service Manual* Intertec Publishing Corp,1982 Small Diesel Engine Service Manual Ed 3 Penton Staff,2000-05-24 Air cooled and liquid cooled diesel engines up to 160 cu In 2600cc More than 200 models covered *Detroit Diesel Engines, In-line 71* General Motors Corporation. Detroit Diesel Engine Division,1966 *Detroit Diesel Engines* General Motors Corporation. Detroit Diesel Engine Division,1967 **Service Manual Model L23 Engine** Motor Co. Ltd Nissan,1975 **Detroit Diesel Engines Series 53** General Motors Corporation. Detroit Diesel Allison Division,1975 **Service manual** General Motors Corporation,

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