

Component Procedures: Cylinder Head Assembly

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Component Procedures: Cylinder Head Assembly

Parts and Labor (itype_189)

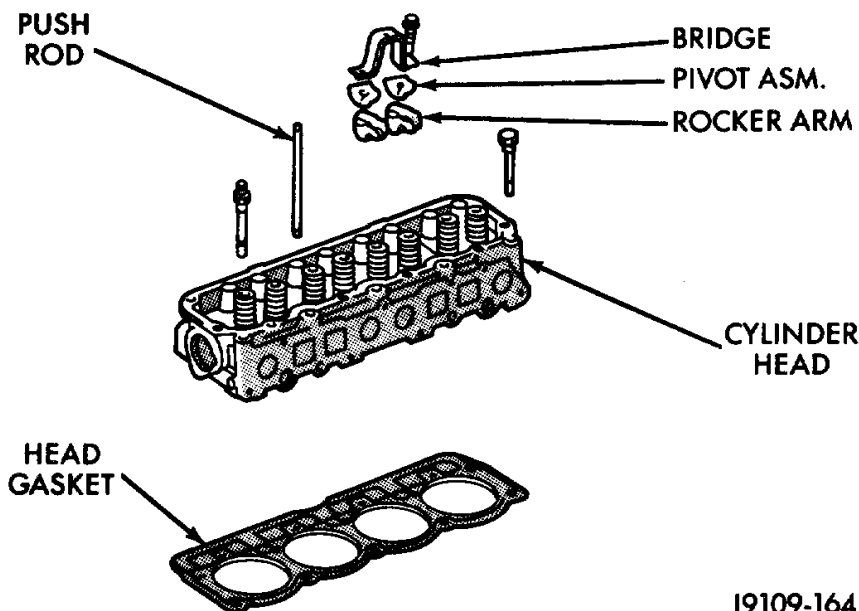
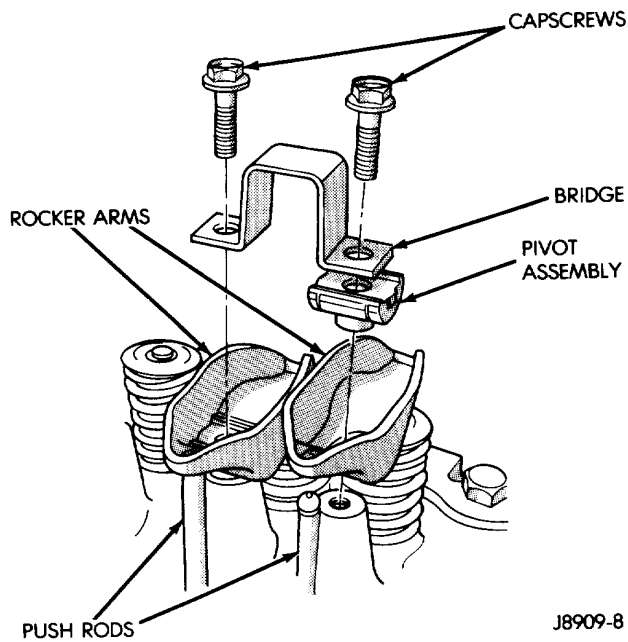
Parts

Qualifier	Part #	Name	Price	Note
Cylinder Head	33007115	1 - Cylinder Head	414.00	

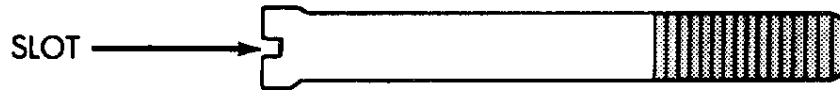
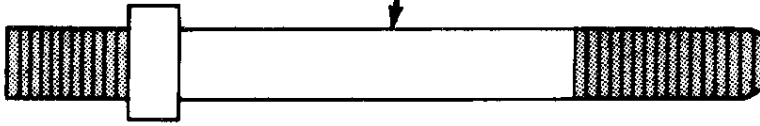
Labor

Operation	Qualifier Path	Skill	Std Hrs	Wty Hrs
Replace	Cylinder Head, R&R	B	5.9	4.1
Replace	Cylinder Head, R&R > NOTE > With AC, Add	B	1.0	0.8
Replace	Cylinder Head, R&R > NOTE > With PS, Add	B	0.7	0.4

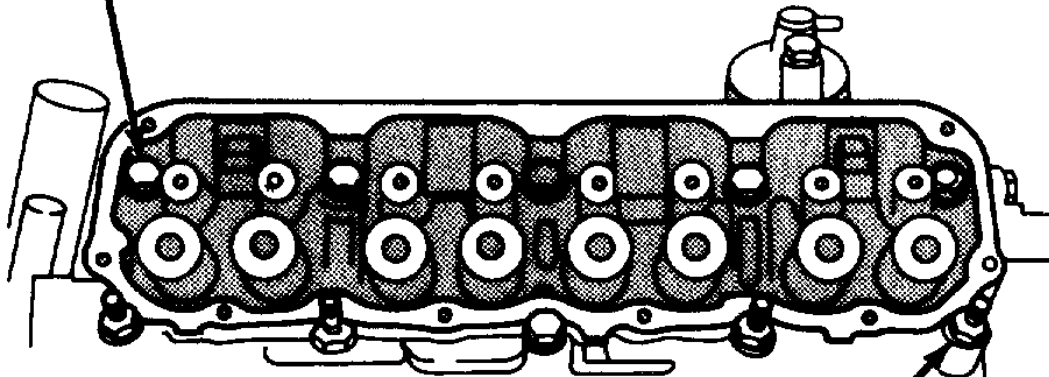
Removal and Installation (Article 2027994)



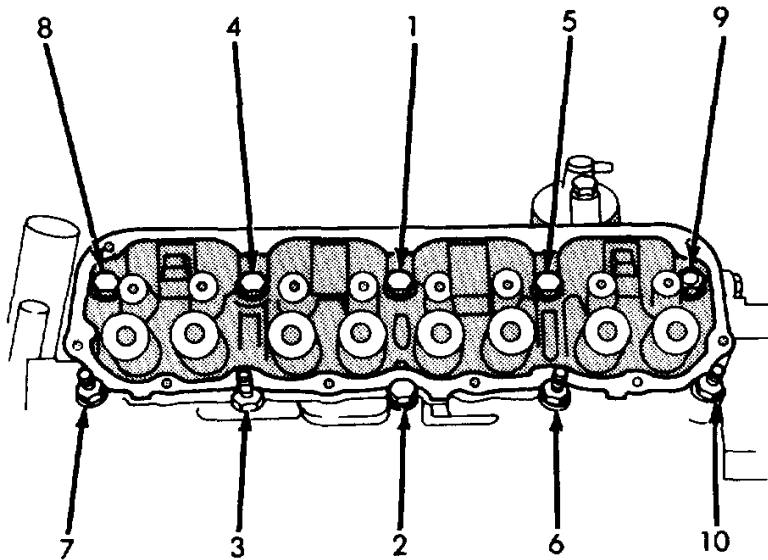
USED
CYLINDER
HEAD
BOLT



ALIGNMENT
DOWEL



ALIGNMENT DOWEL J9009-14



J9009-15

Disassembly and Assembly (Article 2071861)

DISASSEMBLY

1. Use Valve Spring Compressor Tool MD-998772A and compress each valve spring.
2. Remove the valve locks, retainers, springs and valve stem oil seals. Discard the oil seals.
3. Use an Arkansas smooth stone or a jewelers file to remove any burrs on the top of the valve stem, especially around the groove for the locks.
4. Remove the valves, and place them in a rack in the same order as removed.

ASSEMBLY

1. Thoroughly clean the valve stems and the valve guide bores.
2. Lightly lubricate the stem.
3. Install the valve in the original valve guide bore.
4. Install the replacement valve stem oil seals on the valve stems. If the 0.381 mm (0.015 inch) oversize valve stems are used, oversize oil seals are required.
5. Position the valve spring and retainer on the engine cylinder head and compress the valve spring with Valve Spring Compressor Tool MD-998772A.
6. Install the valve locks and release the tool.
7. Tap the valve spring from side to side with a hammer to ensure that the spring is properly seated at the engine cylinder head. Also tap the top of the retainer to seat the valve locks.

Cleaning and Inspection (Article 2071857)

CLEANING

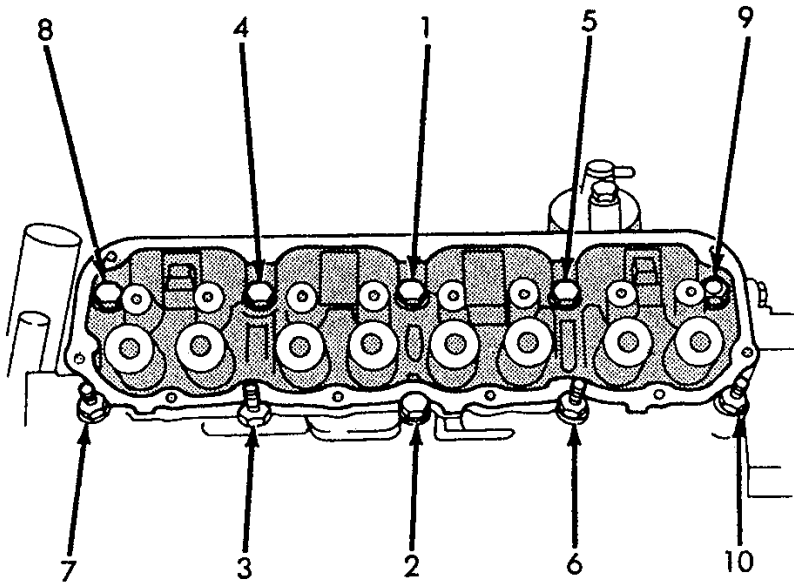
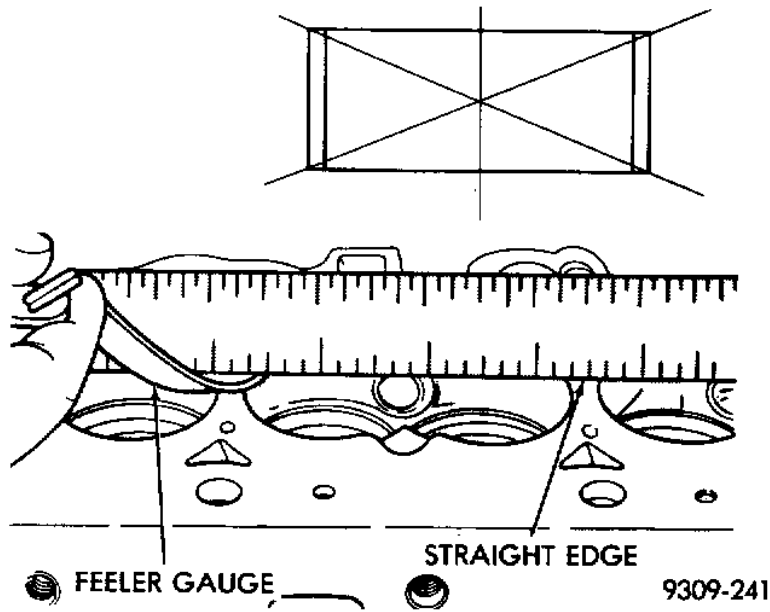
Thoroughly clean the engine cylinder head and cylinder block mating surfaces. Clean the intake and exhaust manifold and engine cylinder head mating surfaces. Remove all gasket material and carbon. Check to ensure that no coolant or foreign material has fallen into the tappet bore area.

Remove the carbon deposits from the combustion chambers and top of the pistons.

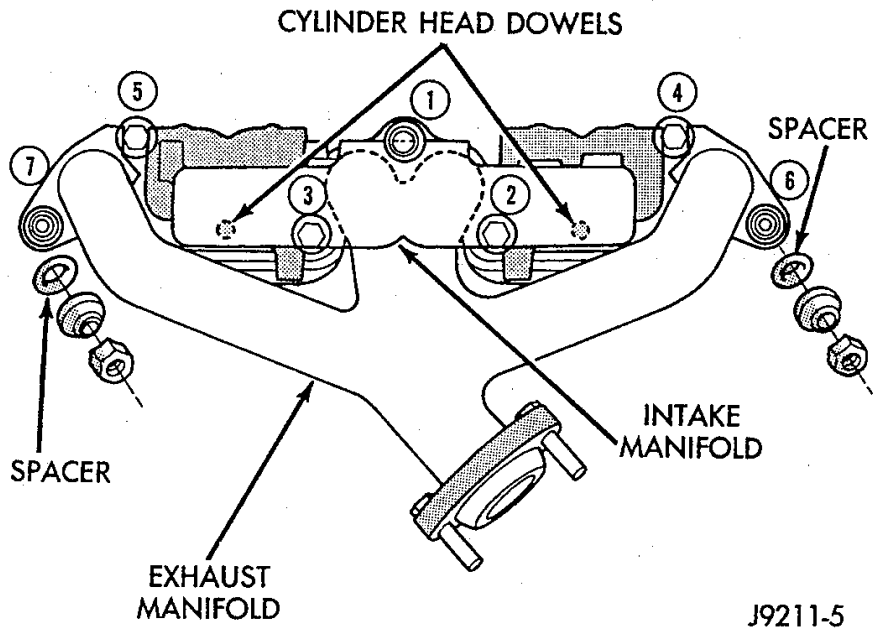
INSPECTION

Use a straightedge and feeler gauge to check the flatness of the engine cylinder head and block mating surfaces.

Mechanical (including Torque) (itype_28)



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