

XD2-XD2C-XD2S DIESEL ENGINES ENGINE OVERHAUL CYLINDER HEAD REINSTALLATION

1980 →	
FED	X
CAL	X



- Run an 11 X 150 tap through the block holes
- Carefully clean the gasket mating faces of the block and the head as well as the bearing point of the head bolts on the head.
- Install the head guides **8.0114** in bolt holes 21 and 22
- Install the head gasket dry
- Install the head

II

- Brush clean the bolts
- Lubricate the bolt threads and the bolt heads contact face with :
 - yellow bolts class 10.9
engine oil
 - black bolts class 12.9
Molykote G Rapid P.N. **9730.08**, or equivalent
- Install new washers P.N. **0205.14** with the domed side up and position the bolts according to their size.
 - 8 bolts KC
 - 7 bolts KL
 - 7 bolts KSL
- Remove head guides **8.0114**

Note : If bolts need replacement, use same class steel as originally fitted.

II CYLINDER HEAD TIGHTENING

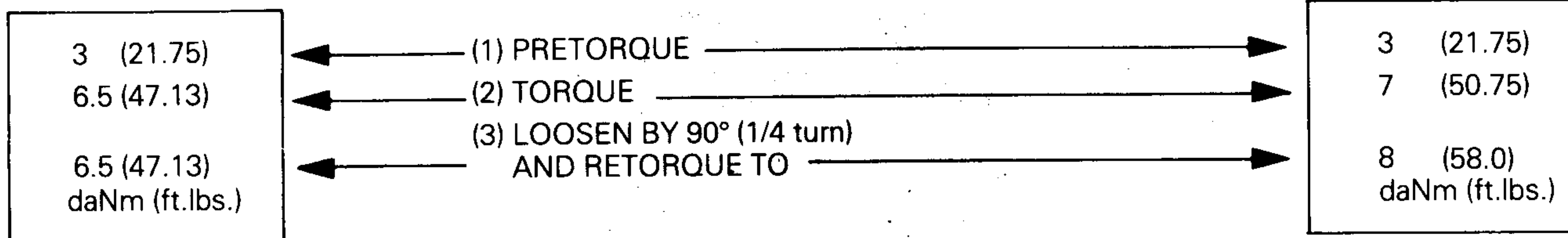
CASE A

Yellow head bolts, steel class 10.9
without shoulder

CASE B

Black head bolts, steel class 12.9
with shoulder

Bolt by bolt and in sequence



REMINDER: The cylinder head will have to be retorqued after the engine has been reinstalled in the vehicle and statically run at 3 000 rpm for 10 minutes and cooled down for 3 1/2 hours. Engines in the CASE A category will also require a re-torque after 1 000/1 500 miles.

IV

- Install the push rods
- Install the rocker shaft assembly and oil feed union **with its seal** and washer
- Progressively tighten the rocker shaft bearing blocks allowing 0,1 mm (0,004") play at the two end rocker arms
- Intermediate supports (nuts) 4,7 daNm (34 ft.lbs.)
- End supports (bolts) 2 daNm (14.5 ft.lbs.)

V

- Adjust the valves in two steps with the engine cold :

	XD2-XD2C	XD 2S
● Intake	0,25 mm + 0,05 + 0 (0,010" + 0,002") + 0	0,15 mm + 0,05 + 0 (0,006" + 0,002") + 0
⊗ Exhaust	0,25 mm + 0,05 + 0 (0,010" + 0,002") + 0	0,25 mm + 0,05 + 0 (0,010" + 0,002") + 0

Place in rocking position	● 4 ⊗ 4	● 1 ⊗ 1
To Adjust	● 1 ⊗ 1 ● 2 ⊗ 3	● 4 ⊗ 4 ● 3 ⊗ 2