

Op. 10 101

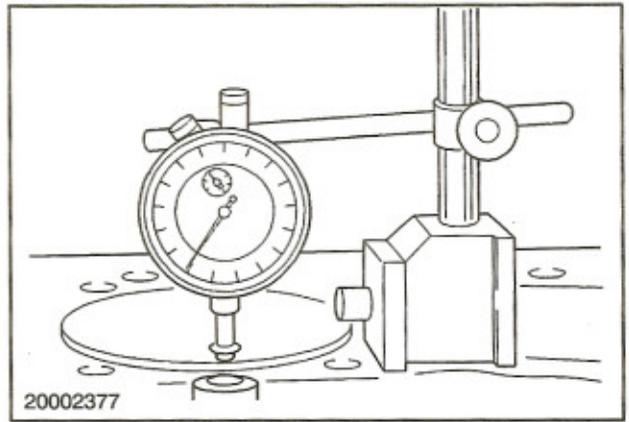
HEAD GASKET SELECTION

During assembly, the ultimate engine compression ratio is established by the thickness of the head gasket used. For service replacement, head gaskets of different thickness are available. The correct head gasket must be selected based upon the amount the piston protrudes above the face of the block when at top dead center. The correct head gasket usage is determined as follows:

1. Position each of the pistons at top dead center and, using a dial indicator, determine the distance each piston projects above the face of the block.

NOTE: Measure each of the pistons while holding a slight down pressure on the piston. Use the dimension taken from the cylinder which has the greatest projection and select a head gasket as indicated in the following chart.

NOTE: The variation in the amount of protrusion among all pistons must be within 0.1 mm (0.004 in.).



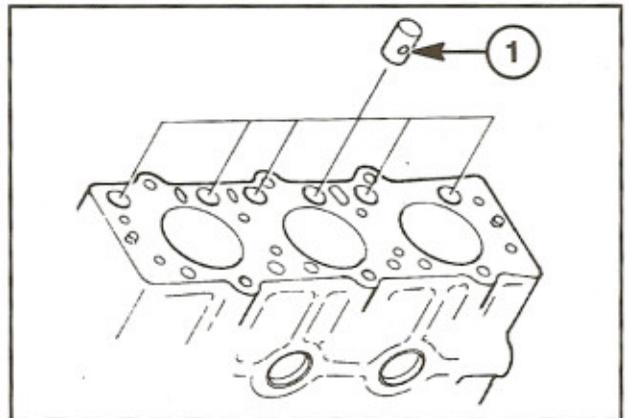
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HEAD GASKET SELECTION CHART

Model	Measurement Value	Head Gasket Part No.	Installed Thickness
N843L (TC35)	0.0177 - 0.024 in. (0.45 - 0.6 mm)	111147490	0.0512 in. (1.3 mm)
	0.024 - 0.028 in. (0.6 - 0.7 mm)	111147500	0.0551 in. (1.4 mm)
N844 (TC40)	0.0197 - 0.0236 in. (0.5 - 0.6 mm)	111147510	0.0472 in. (1.2 mm)
	0.0236 - 0.02756 in. (0.6 - 0.7 mm)	111147520	0.0512 in. (1.3 mm)
N844L (TC45)	-0.0118~ - 0.0177 in. (-0.3~-0.45 mm)	111147450	0.0157 in. (0.4 mm)
	-0.00787~ - 0.0188 in. (-0.2~-0.3 mm)	111147460	0.0197 in. (0.5 mm)

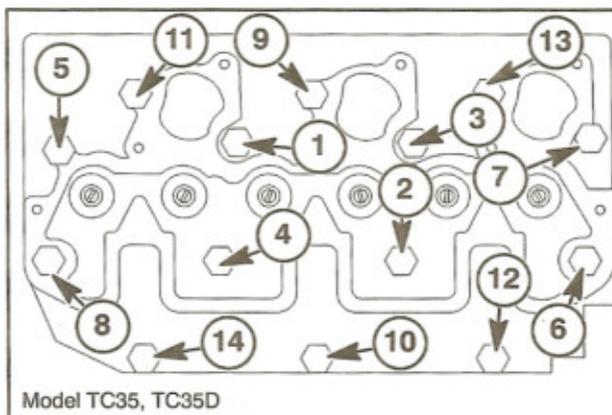
CYLINDER HEAD ASSEMBLY

1. Install the valve tappets, 1.

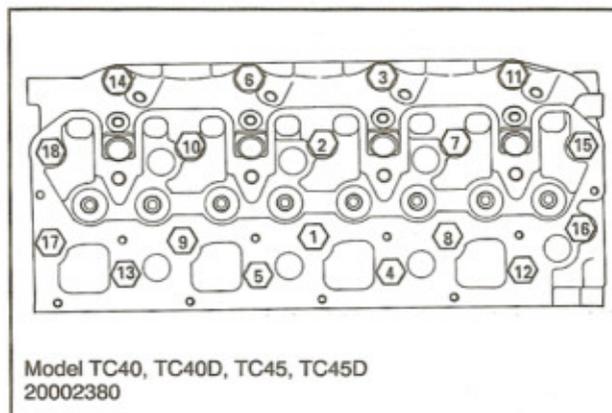


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2. Select the proper head gasket and place it on the block with the side marked with the last four digits of the part code no. up.
3. Tighten the head bolts in the sequence as shown. Tighten first to half torque value, then to the final torque specification of 98 - 103 N·m (72.3 - 76 ft.-lbs.).
4. Replace the push rods and valve stem caps in their original location.
5. Install the rocker shaft support assembly onto the head and tighten the bolts to 27 - 39 N·m (20 - 29 ft.-lbs.).



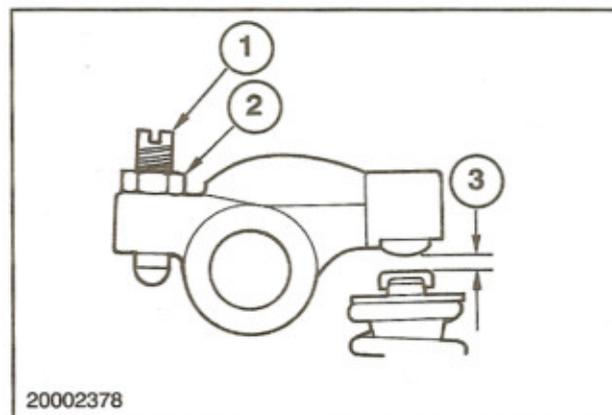
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Op. 10 106**VALVE CLEARANCE ADJUSTMENT**

1. Adjust the rocker arm to valve clearance. Be sure the tappet is in its lowest position before making the adjustment. To be sure the tappet is in its lowest position, bring the piston to top dead center on the compression stroke (both valves closed).
2. Loosen the nut and adjust the clearance of both the intake and exhaust valves to 0.2 mm (0.008") with the adjusting screw.



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1. Adjusting Screw
2. Locknut
3. Valve Clearance 0.2 mm (0.008")