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FITTING INSTRUCTIONS 4 CYLINDER OHV PETROL CYLINDER HEADS

These notes are to be used in conjunction with the workshop manual.
Please observe safety precautions.

- Cylinder heads are supplied complete and ready to fit, use the gasket set provided.
- Automotive Component Remanufacturing Limited does not recommend the use of copper gaskets.
- The block face must be completely clean and all traces of old gasket removed.
- Trial fit the head without a gasket. Ensure no fouling occurs between the water pump and the thermostat housing. Relieve the pump by filing if required.
- Make sure head gasket is the correct way up.
- Torque the head down in stages to 65Ft.lb using a calibrated torque wrench.
- Check push rods have seated correctly, using a torch to look down the push rod tubes. Standard valve clearance 0.010" (cold) Power Plus camshaft 0.006" intake 0.008" exhaust (cold)
- Run engine until fully warm. Allow to cool then retorque cylinder head bolts and re-set valve clearances.
- Re-set valve clearances after 500 miles
- Anti-freeze / corrosion inhibitor must be used at all times.

It is essential that the following is checked:

1. Ignition timing is set to 6° BTDC. at 650RPM vac disconnected.
2. The distributor advance curve is correct and that maximum advance at 4250RPM is 35-38° BTDC. vac disconnected.

LPG Engine Notes

1. Do not allow the fuel / air mixture to become weak under load e.g. incorrect settings or driving vehicle with a near empty tank. This is vital to avoid excessively high combustion temperatures and consequent damage with this fuel.
2. Re-check valve clearances at 1000 and 3000 miles with LPG fuel.