

## 7A-24 INSTALLATION OF CYLINDER BLOCKS

1. Install the cylinder blocks and fasten each with six nuts (Fig. 7A-28).
2. Tighten nuts to 40 to 50 ft.-lbs. (54-68 Nm) torque.

## 7A-25 INSTALLATION OF PISTON RINGS

1. Put the open end of the piston ring on first and spread to fit in groove (Fig. 7A-29).
2. There are four rings to each piston. The 4<sup>th</sup> (bottom) ring is the oil ring, the 3<sup>rd</sup> is the scraper ring, the 2<sup>nd</sup> ring is the compression ring and the 1<sup>st</sup> ring is the compression ring (See Fig. 7A-30).
3. Install the scraper ring with the scraper edge down (Fig. 7A-30).

## 7A-26 INSTALLATION OF VALVES AND SEAT INSERTS

1. Inspect all valve inserts and install new inserts when necessary.
2. Install each valve into the same guide from which each was removed.
3. Install the seat and spring and fasten with the valve locks (Fig. 7A-31).
4. Make adjustment of the valve tappet clearance (See Section 8 "Technical Data" for valve tappet clearance).
5. Install the inspection plate for the valve tappets.

## 7A-27 INSTALLATION OF PISTONS AND CONNECTING RODS

**NOTE:** Identical numbers are stamped on the side of each connecting rod and its cap. These numbers must all be on the same side of the connecting rods when installed in the engine. Be sure that the hole in the cap is facing toward the oil spray nozzle (Fig. 7A-32). Install new nuts on the connecting rod bolts and tighten them to 20-28 ft.-lbs. (27-38 Nm) torque.

1. Install the piston and connecting rod assembly in the same bore as when removed.

**NOTE:** Put oil on the pistons, rings, piston pins, rod bearings and cylinder walls before assembly.

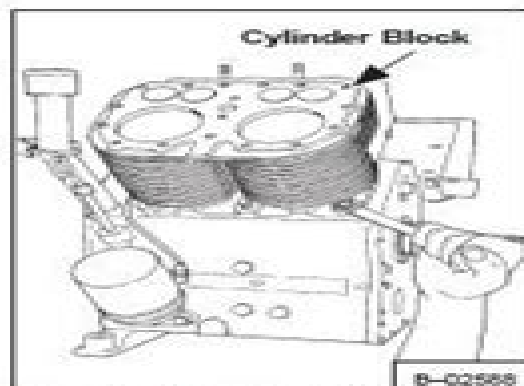


Fig. 7A-28 Install Cylinder Block

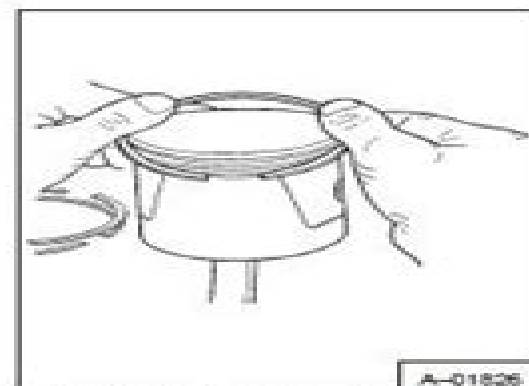


Fig. 7A-29 Install Piston Rings

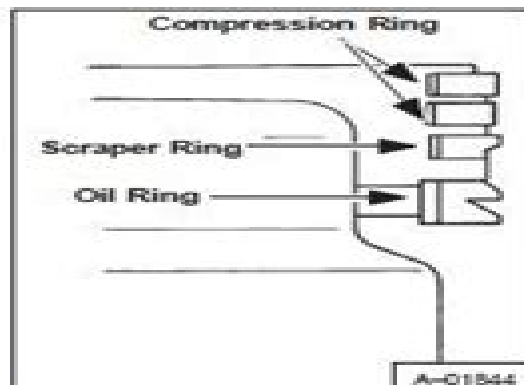


Fig. 7A-30 Piston Ring Sequence

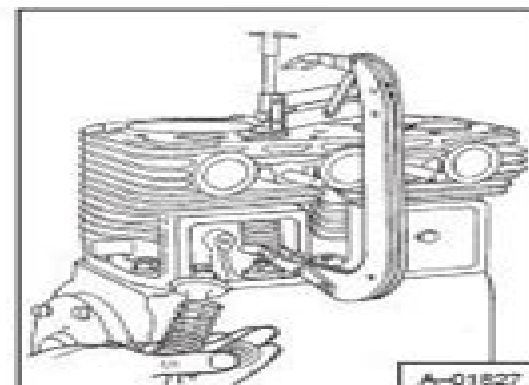


Fig. 7A-31 Install Valves

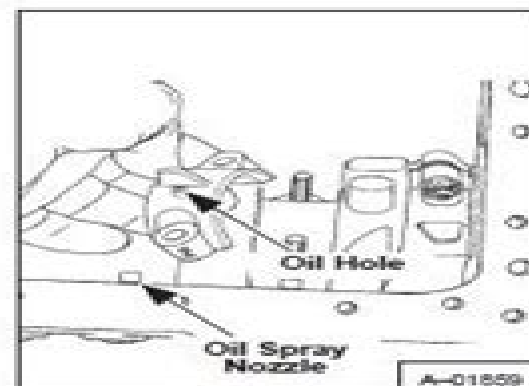


Fig. 7A-32 Install Rod Caps

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