



- Unscrew screws (arrow), remove cylinder head (1) and gasket.
- Clean sealing surfaces on cylinder head and crankcase.



#### Determine cylinder head gasket



##### Note

- The piston overlap must be measured on all pistons to determine the cylinder head gasket.
- The cylinder head gasket must be selected according to the greatest measured piston overlap.



#### Determine piston U/T

- Turn crankshaft until the piston comes flush with the crankcase.



##### Note

- Turn crankshaft in direction of rotation of engine.



- Mount shim (1) and measuring bridge (2) on crankcase.
- Insert meter in measuring bridge and position the stylus with pre-tension on the piston base (arrow).
- Turn the crankshaft at evenly until the reversal point of the pointer on the meter is reached. The piston is now in U/T.



#### Determine piston overlap

- Mount measuring bridge and shim.
- Place the stylus of the meter under pre-tension on the sealing surface of the crankcase (arrow).
- Adjust meter to "0".



- Read measuring points.



##### Note

- Schematic representation for measuring the piston overlap at the points "1" and "2".



# Deutz Service Manual F3l 1011f

**Judd E. Hollander**



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