

Land Rover Series IIA 1961-1971 Workshop Manual



Fig. A-13—Assembly of components to first piston

Cylinder bores and walls, to refit

Operation A.196

1. Remove the sealing ring grooves in the crankcase end of cylinder block bores, and the bore sealing rings, with Shimor M54 Compound, then fit a ring in the upper and lower grooves of each bore.

A small hole is drilled through the block into the middle groove to provide evidence of instant leakage past the ring.



Fig. A-15—Checking cylinder bore extension

2. Press the bores into their respective bores to first and stop the marks made while the inserting.
3. Clamp each bore in turn in the manner described and tighten the securing bolts to 95 lbf ft (12.8 N.m). Mount a dial test indicator and check that the outer edge of the cylinder bore is from .002 to .004 in (0.050 to 0.10 mm) above the cylinder bore seat face. See Fig. A-16. Adjust if necessary by increasing bore and adding a suitable shim washer under the flange. Clamp and re-check bore as described above. Shim washers are available .002 in (0.05 mm) and .004 in (0.10 mm) thick.

Pistons and rings, to refit Operation A.198

1. When fitting pistons, the clearance in bore hole should be as recommended with the dimensions laid down in the Data Section. In the absence of exactly accurate measuring instruments, a long feeler, .004 in (0.10 mm) wide thick, may be inserted in the lower side of the bore hole, as illustrated in Fig. A-17, and the piston forced across diameter and the feeler pin in line with the centre line of cylinder block. The piston should become a tight fit when the feeler is about across the bore.
2. Check the piston ring gaps in the lower bores, using an old piston as illustrated in Fig. A-14, to keep the rings square in the bore.



Fig. A-14—Checking piston rings

A—Piston ring B—Piston C—Lower bore

3. The second and third compression rings are forced edge and must be fitted with the side marked "T" uppermost; the top chrome-plated compression and the oil scraper ring has a square friction edge and may be fitted either way. Fit the piston rings and check the clearance in ring grooves. See Data Section.

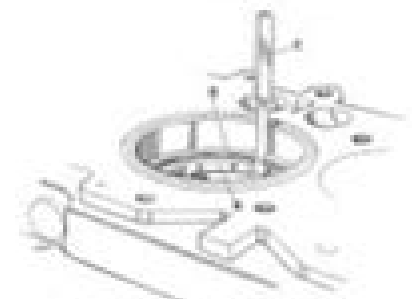


Fig. A-16—Checking piston ring and bore

A—Piston ring B—Bore ring C—Piston ring

It will be seen that provision is made for the fitting of two oil scraper rings. The second groove is for service purposes only.

Connecting rod checks Operation A.200

1. Check that the connecting rods and caps have not been filed, in the following manner.
2. Select the correct cap for each connecting rod, as dictated by the number stamped near the seat face. This number also indicates the washers to which it must be fitted.

Assemble the connecting rods, low dust bearings, with corresponding washers together.

Workshop Manual 1963 Land Rover

Chao Zhang



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