

QTY

CLEAN BLOCK NOT ASSEMBLE CLEAN 1.00

Keep all parts

REMOVE LINERS 1

REMOVE HEAD STUDS 1

SODA BLAST COMPONENT 1

Soda blast crankcases & components

WELDING REPAIR TO CRANKCASE 1

crack in crankcase & corrosion-Prep & weld crankcase,dress welds

MACHINE COUNTER BORES&SURFACE 1

use 0.027" shims.

BORE AND HONE WET SLEEVE 4

Piston Oversize - .020"

Nominal Bore Size - 2.854"

Piston Clearance - .0025"

Finish Bore Size - 2.8785"

LINE BORE BLOCK MAIN TUNNELS 1

machine c/cases,remove dowels,fit up & tension,

Line bore to 2.395"

tension: 75ftlbs

CHECK BEARING CLEARANCES 1

Fit Bearings to Rod & Main bearing tunnels;

Main bearing clearance : .0015"

B/E bearing clearance : .0018"-.002"

MOCK ASSEMBLE 1

fit up crankshaft & rods check rotating assembly,grind sleeve bottoms for conrod

clearance.Recheck clearance all ok

C/TEST CONROD PETROL 4 ONLY 1

conrods crack tests ok -nil indications

CONROD ALIGNMENT 4

Replacement conrods

check conrod alignment--all ok

CONROD RESIZE,CHECK S/E 1

replacement conrods:fit new conrod bolts.

resized to:2.146"

tension: 35 ftlb

SUPPLY & FIT HELICOILS-HEAD BOLTS 8

head bolt threads-- 3/8 BSF

CRACK TEST CRANKSHAFT CAR 1

crankshaft crack tests ok-nil indications

GRIND C/SHAFT JOURNALS & FINAL FINISH 1

replacement crank:

Grind mains: .040" -journal size; 2.105"

Grind B/E: .030" -journal size: 1.7711"

LINE BORE CAM TUNNELS 1

check if cam tunnels need L/B ??

Line bore cam tunnels-1.502",clearance .0025"

LINE BORE THRUST WIDTH IN BLOCK 1

machine thrust locating bolt holes in thrust of block,drill & tap m3

MOD ROD CHAMFER & TANG RODS 1

MODIFY BEARINGS	1
narrow & chamfer B/E & Main bearings.	
FIT G/BUSH,PIN BORE	1
REMOVE & FIT FLYWHEEL RING GEAR	1
BALANCE FULL ENGINE 4 CYL	1
correct conrod imbalance 25 grams variance	
HEAD QUOTE	1
Check thickness: 3.120"	
Check straightness: straight	
Check hardness:n/a	
Check all threads:ok	
Check valves -stem wear-bend-pitting-margin:valve stems worn,thin margins,pitted	
radius-replace valves	
Check valve heights:inl 1.600",exh 1.620"	
Check guides -wear -cracks clearance:in & exh worn	
Check valve spring pressures: 7077-lb @ 1.470"	
Check inserts --inlet - exhaust:pitted replace inlet & exh seats	
Work in valves,collets & retainers to suit-	
Check retainers & collets for wear:ok	
HEAD DISMANTLE - ACID CLEAN	1
HEAD C/TEST PETROL 4 CYL	1
SODA BLAST COMPONENT	1
Soda clean ports & chambers	
REMOVE TIN PLATES FROM HEADS	1
FIT VALVE SEAT INSERT C/IR HEAD	8
machine valve seat recess for inserts & fit inserts	
MACHINE VALVE GUIDES TO SUIT	1
FIT VALVE GUIDES	8
HONE GUIDES	8
MACHINE VALVE SPRING SEAT	8
CUT SEATS AND SYNCRO	1
POCKET PORTS & BLEND INSERTS TO PORTS	1
HEAD SURFACE	1
HEAD FINAL CLEAN AND ASSEMBLE	1
VALVE STEM SEAL -HONDA EL/EG 8.00 3.20 25.60	8
JOWETT PISTON & RING ASSY +.020	4
DIAMOND VALVE SEAT	4
DIAMOND VALVE SEAT	4
S/E BUSH	4
M3X12 CSK SOC SCREW 6.00	
to retain thrust washers	
S/H CYL HEAD 4XC1-GEMINI	1
C/I VALVE GUIDE	8
CAM GRIND STD JOWETT JAVELIN	1
GALLERY PLUG 1/4"NPT	4
REMOVE BLOCK GALLERY PLUGS 1.00	1
tap for 1/4 npt plugs	
DRILL & MOD OIL GALLERYS	1
DETAIL:	1
Gather all parts,clean parts,soda & buff parts make sure all operations	

are completed and box up put in rack.