

Valve lifters

Check the valve lifters for wear. The bearing surface against the cylinder block must not be scratched or porous. The contact surface against the camshaft must not be rugged or unevenly worn. Change valve lifters if necessary.

Rocker arm mechanism

1. Remove the lock rings on the rocker arm shaft and remove rocker arms from the shaft.

NB The rocker arms are different from each other. Mark them to make sure they are correctly fitted.

2. Clean the various parts. Make sure to clean the oil channels of the rocker arm shaft and the oil holes and the rocker arms.

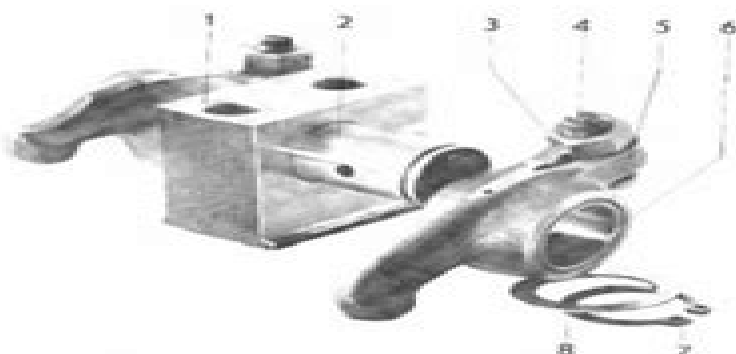


Fig. 13. Rocker arm mechanism

- | | |
|---------------------|---------------|
| 1. Bearing bracket | 5. Rocker arm |
| 2. Rocker arm shaft | 6. Bushing |
| 3. Locknut | 7. Lockring |
| 4. Adjusting screw | 8. Washer |

3. Check for rocker arm shaft wear. Check also the spherical part of the adjusting screw for deformation or wear. The threads must be undamaged on the screw and locknut. The spherical surface of the rocker arm contact surface against the valve stem must not be worn or pitted. Adjustment can be carried out in the grinding machine in case of slight wear.
4. Oval-worn rocker arm bushings must be replaced. Use a drift to press them out and in. When the bushing is pressed in, the oil hole must be located as shown on fig. no. 14. After pressing in, ream the bushing to a close running fit on the shaft. Remove all metallic fragments.

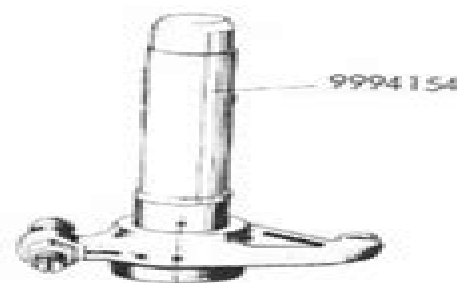


Fig. 14. Replacing a rocker arm bushing

Assembling the cylinder head

1. Oil in the new seal rings for the inlet valves. Place the pin of tool no. 884497 in the valve guide hole. Push the seal ring over the pin and knock carefully down the sealring, using the sleeve (see fig. no. 15). When the pin bottoms in the sleeve the sealring is in its right position.
2. Oil in the valve stems and put some grease in the slots for the valve keys on the inlet valves. Place the valves in respective guides. NB Push in very carefully the inlet valves in order not to damage the sealrings.
3. Fit valve springs and washers. The valve springs are fitted with the tightly wound end against the cylinder head. Fit the wear hats.
4. Fit the injectors but do not tighten them.

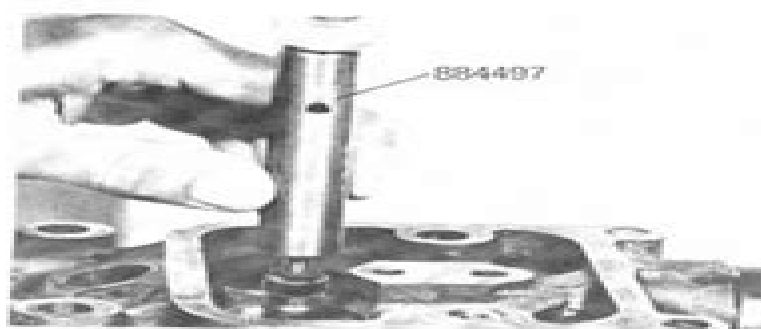


Fig. 15. Fitting of sealring for inlet valve

Fitting the cylinder head

If the cylinderhead has been replaced or if the cylinder block has been disassembled, the fitting must be done according to separate instructions (See "Adjusting the compression ratio").

Penta B18 Workshop Manual

Wenbin Ji



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