

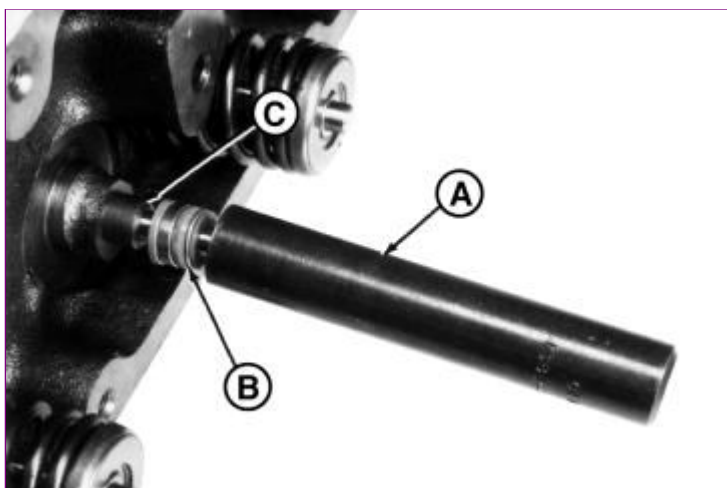
CTM125 - PowerTech™ 2.9 LDiesel Engines Install Valves

Install Valves

1. Apply engine oil to valve stems and guides.
2. Insert valves in head (in same location as found during removal).

NOTE:

Valves must move freely and seat properly.

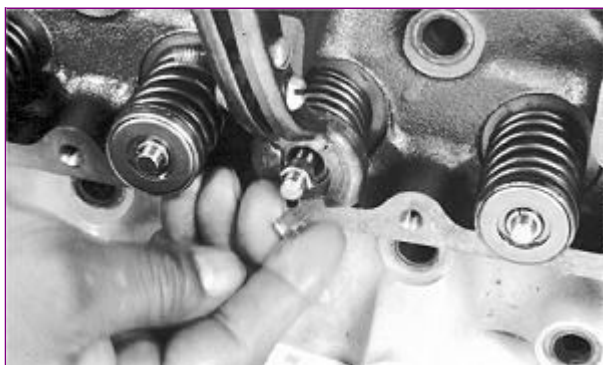


3. RG5654-UN: Slide Seal onto Valve Guide Tower

LEGEND:

- A - JDG678 Valve Stem Seal Installer
- B - Stem seal
- C - Valve guide tower

Using JDG678 Valve Stem Seal Installer (A), slide seal (B) over valve stem and onto valve guide tower (C).



4. RG5655-UN: Install Valve Springs and Rotators

Install valve springs and rotators.

5. Compress valve springs using JDE138 Valve Spring Compressor and install new keepers on valves.



CD30233-UN: Compress Valve Springs

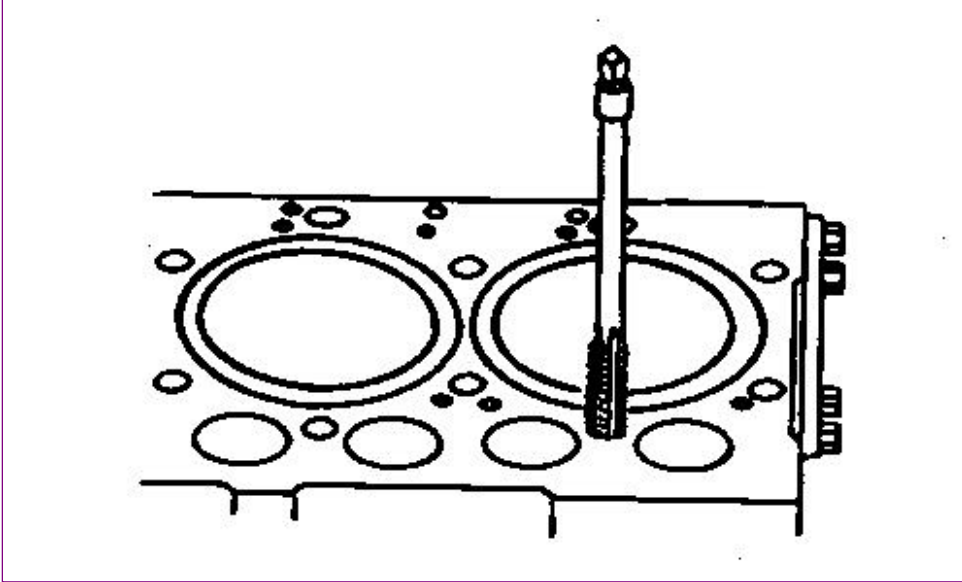
NOTE:

After having installed the valves, strike end of each valve three times with a soft mallet to ensure proper positioning of the keepers.

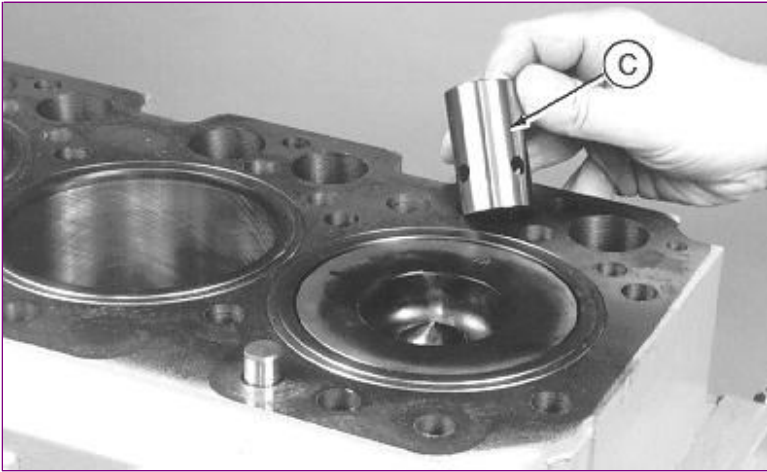
CTM125 - PowerTech™ 2.9 LDiesel Engines

Install Cylinder Head

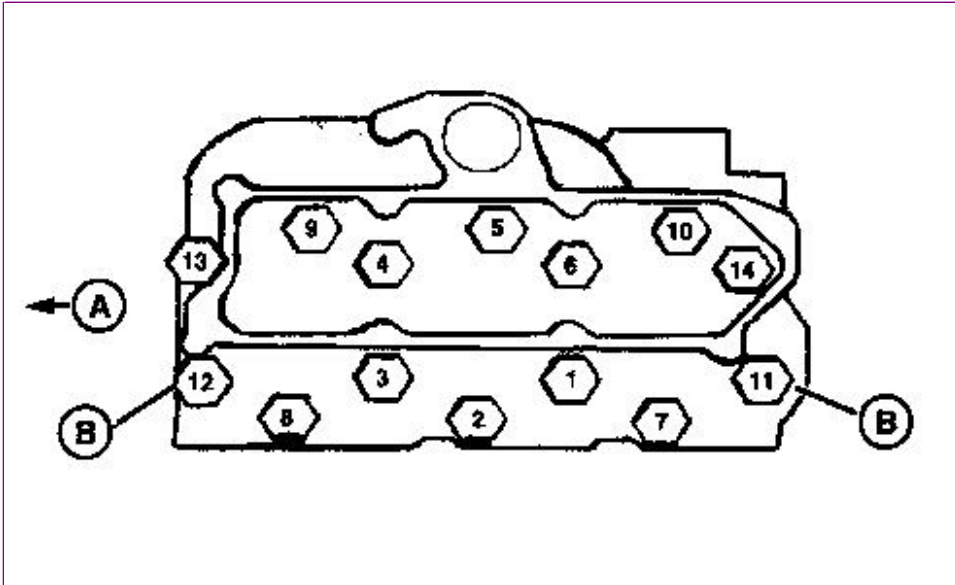
Install Cylinder Head



RG4718-UN: Install Cylinder Head



CD30693-UN: Cam Follower



CD30543-UN: Locating Holes

LEGEND:

- A - Front of engine
- B - Guide stud locations
- C - Cam follower

1. Clean tapped holes in cylinder block using JDG680 Tap (or any 1/2-13 UNC-2A tap). Use compressed air to remove debris or any fluids from cap screw holes.

2. **IMPORTANT:**

Insure that cam followers (C) are present before cylinder head installation.

Install new cylinder head gasket dry (without sealant)

3. **IMPORTANT:**

Without guide studs, the Viton O-ring attached to cylinder head gasket (at rocker arm lube oil passage) could be damaged when repositioning cylinder head on engine block to align cap screw holes.

Install two guide studs in cylinder block at locating holes (B).

4. Position cylinder head over guide studs and lower into place on cylinder block.

5. **NOTE:**

Always use new cap screws to install cylinder head.

Dip new cap screws entirely in clean engine oil.

6. Remove guide studs and install cap screws in all open bores.

7. Tighten cap screws in sequence to the torque specified, beginning with No. 1, then **torque turn** to specified angle. Use JD-307 Torque Wrench Adapter if necessary.

Item	Measurement	Specification
Cylinder head bolts		
1st step	Torque	100 N·m (75 lb-ft)

2nd step	Torque	150 N·m (110 lb-ft)
Recheck after 5 minutes	Torque	150 N·m (110 lb-ft)
Final step	Torque Turn	60° ± 10°

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