

Repair instructions

Cylinder block and flywheel housing (Op no 211)

1. Cylinder block and cylinder liners

A. Measuring cylinder liner wear

Note! Cylinder liner wear can be measured when the engine is attached to the tractor. Remove only the cylinder head and crank the engine so that the piston is in the lower position.

1. Using a micrometer set the dial gauge to zero using a new cylinder liner indicating the initial dimension of the bore: 108,00 mm.

2. Clean the inner surface of the cylinder liner thoroughly before measurement.



3. Perform the measurement crosswise at the liner top end, lower end and middle.

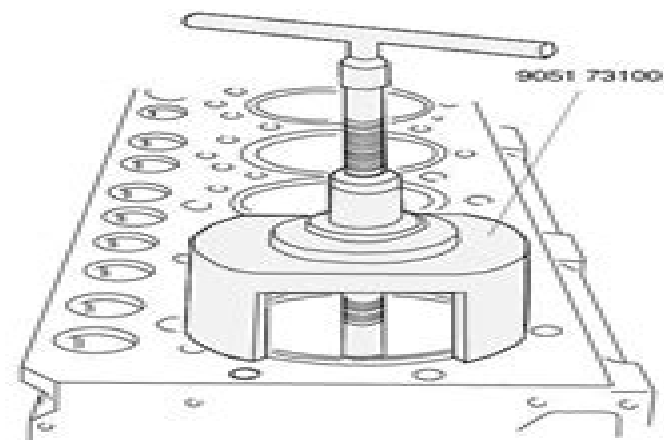
4. Check the gauge reading for maximum wear and ovalness (compare with rating on page 210/4).

B. Removing cylinder liner

Note! See also page 219/1 for working order.

1. If the cylinder liners are to be used again they should be marked so that they can be fitted in the same position.

2. Remove the cylinder liners using cylinder liner puller 9051 73100.



C. Checking cylinder block

1. Clean the cylinder block and all oilways.

2. Check the cooling channels and remove the scale and sediment to ensure engine cooling.

3. Check the tightness of the cup plugs and threaded plugs in the cylinder block as well as the condition of the cylinder block and sealing faces.

4. Measure the wear of the camshaft bearing points (compare with rating on page 210/4).

Note! If it is necessary to machine the upper face of the cylinder block, the pistons must be shortened by the same dimension. Observe the valve disc spaces on the piston upper face.

D. Changing camshaft bushing

1. Extract the bushing with an internal puller, for example Sykes 854. If the camshaft rear end plug is removed the bushing can be forced out with a long drift.

2. Clean the bushing location.

Valmet 6service Manual

Michal Rosen-Zvi



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