

CYLINDER BLOCK DATA

	2½ Litre	3½ Litre
Material	Chromium Iron	
Cylinder Bores. Nominal Machined	2.875" (73.025 mm.) 2.875" +.0005" —.00025" (73.025 mm. +.013 mm. —006 mm.)	3.2283" (82 mm.) 3.2283" +.0005" —.00025" (82 mm. +.013 mm. —006 mm.)
Bore size for fitting liners	3.030" to 3.031" (76.96 mm. to 76.99 mm.)	3.347" to 3.348" (85.01 mm. to 85.04 mm.)
Cylinder Liners (when fitted) Overall length	6.880" to 6.865" (174.75 mm. to 174.37 mm.)	7.270" to 7.255" (184.66 mm. to 184.28 mm.)
Outside diameter	3.034" to 3.033" (77.06 mm. to 77.04 mm.)	3.381" to 3.350" (85.88 mm. to 85.09 mm.)
Interference fit	.002" —.004" (.051 mm. —.102 mm.)	3.346" (84.99 mm.)
Outside diameter of lead in	3.030" (76.96 mm.)	3.2283" +.0005" —.00025"
Size of bore honed after assembly into block	2.875" +.0005" —.00025" (73.025 mm. +.013 mm. —006 mm.)	(82 mm. +.013 mm. —006 mm.)

CYLINDER HEAD.

Examine for any flaws or cracks in the casting and check the bottom face of the cylinder head for truth. Remove the core plug from either end of the induction passage passing through the head and withdraw the venturi tube which is a press fit in the centre of the passage. New core plugs must be fitted on assembly.

Remove all traces of carbon from the combustion chambers and deposits from the carburettor ports, exhaust ports and induction passage. Remove any pitting in valve seats using valve seat grinding equipment. Refit the venturi tube, noting that the cylinder head centre stud passes through the tube. Thoroughly clean the water passages and paint the well on the top of the head with heat and oil resisting paint.

See Plates B.21 and B.22 for sequence of tightening cylinder head nuts.

CYLINDER HEAD TIGHTENING TORQUE DATA

Model	Stud Size	Max. Tightening Torque
2½ litre	1" B.S.F.	1,100 lbs. ins.
	1" B.S.F.	750 lbs. ins.
3½ litre	Waisted studs 1½" B.S.F.	750 lbs. ins.

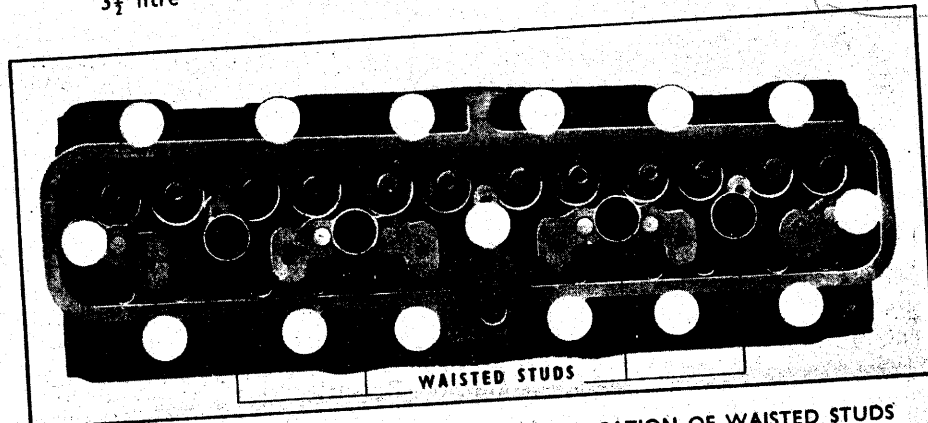


PLATE B.31. CYLINDER HEAD. 2½ LITRE. LOCATION OF WAISTED STUDS

SECTION B

- 1 IB = 945 kg.

MK2: 650 IB. ins
= 54 IB. ft.
= 7.5 kg/m