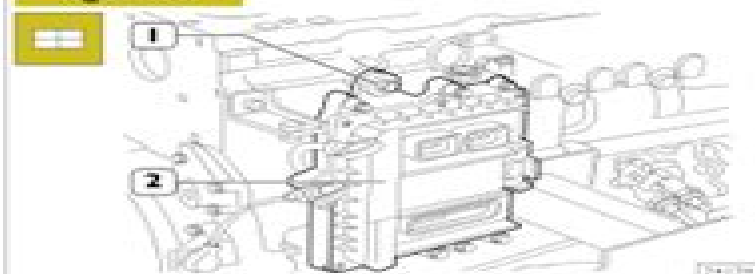


Figure 169



Assemble the electronic gearbox (2) equipped with the exchanger to the engine, fixing it with the screws (1). In case the rubber buffers are cracked or excessively deformed, provide replacing them.

Figure 170



Check cleanliness of cylinder head and engine block coupling surface.

There are two types of head gasket:

- Type A - 1.25 mm thick
- Type B - 1.15 mm thick

Check the average protrusion  $S$  of the pistons as indicated on page 33.

If  $S > 0.40$  mm use gasket type A.

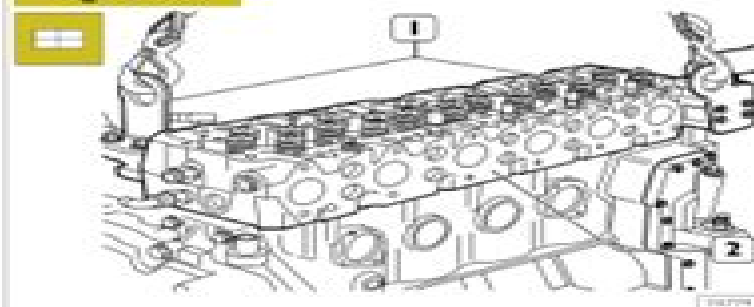
If  $S \leq 0.40$  mm use gasket type B.

Do not get the cylinder head gasket dirty.

Place the gasket (1) in position with the marking "TOP" (1) facing the head.

The arrow shows the point where the gasket thickness is given.

Figure 171



Direct the output shaft (4) and the camshaft (2) so that when fitting the driven gear (1) on the camshaft the marks on the gears (1 and 3) are coinciding.

**NOTE** Before reusing the fastening screws (1), perform two diameter measurements as shown in figure, registering diameters D1 and D2:  
if  $D1 - D2 < 0.1$  mm the screw may be reused  
if  $D1 - D2 > 0.1$  mm the screw must be replaced

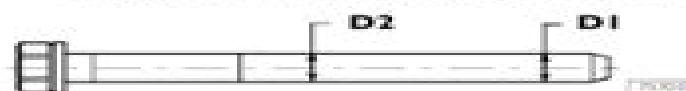
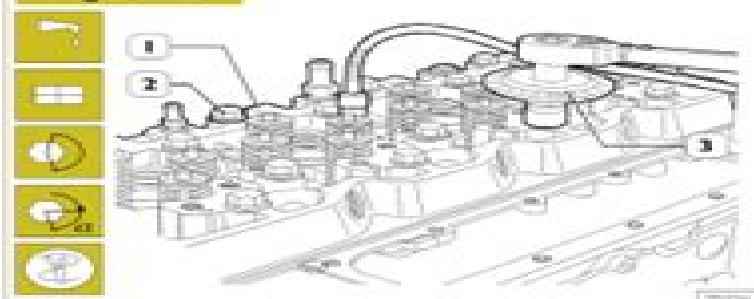


Figure 172



Assemble cylinder head (1). Tighten the screws (2) in three following steps, following order and mode shown in the figure below.

**NOTE** The angle tightening is carried out through tool 99395216 (3).

**NOTE** Before any assembly operation always verify that the hole and screw threads have no evidence of wear or dirt.

# Operation Manual Of Iveco Engine

**Marcel A. Müller**



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