



11.41 Tighten and hold in the gasket (previously, which indicates the gasket's thickness



11.42 Using a feeler blade to measure the gasket protrusion



11.43 Locate the new cylinder head gasket over the downer correctly

fit of the new face as the old one. Measure the required gasket, and proceed to step 20.

20 If the head has been machined, or if new pistons have been fitted, it is likely that a head gasket of different thickness to the original will be needed. Gasket selection is made on the basis of the measured piston protrusion above the cylinder head gasket surface the protrusion that fit within the range specified at the start of this chapter.

21 To measure the piston protrusion, insert a dial test indicator (DTI) in the top face cylinder head gasket mating face of the cylinder block, and use the gauge on the gasket mating face (see illustration).

22 Test the gauge probe above the 1<sup>st</sup> cylinder, and turn the graduated scale to read with the piston reaching TDC (its maximum height). Measure and record the maximum piston protrusion as TDC.

23 Repeat the measurement for the remaining pistons, and record the results.  
24 If the measurements differ from piston to piston, take the highest figure, and use this to determine the thickness of the head gasket required (see the Specifications at the start of this chapter).

### Preparation for refitting

25 The mating faces of the cylinder head and cylinder block must be perfectly clean before refitting the head. Use a heat gun or power sander to remove all traces of gasket and carbon, and cover the piston crowns.  
**Note:** The new head gasket has rubber coated surfaces, which could be damaged from steel scrap or debris left in a water channel.

26 Test pistons (and other) ensuring the piston crowns, or the soft aluminium alloy, is easily damaged.

27 Make sure that the carbon is not allowed

to enter the oil and water passages – this is particularly important for the lubrication system, as carbon could block the oil supply to the engine's components. Using adhesive tape with scrap, seal the water, oil and fuel holes in the cylinder block.

28 To prevent carbon entering the gas passages the pistons and rods, allow a little grease in the gas. After covering each piston, use a small brush to remove all traces of grease and carbon from the gas. Then wipe away the remainder with a clean rag (clean at the pistons in the same way).

29 Check the mating surfaces of the cylinder block and the cylinder head for holes, deep scratches and other damage, refer to the text in paragraph 10. If signs of this may be removed carefully with a file, but if necessary, machining may be the only alternative to be taken.

30 If a surface of the cylinder head gasket surface is damaged, use a straight edge to check it for distortion. Refer to Part 2, at the Chapter 2 chapters.

31 Ensure that the cylinder head bolt holes in the intermediate are clean and free of oil. Springs in both sides of oil in the bolt holes. This is most important to ensure that the correct bolt tightening torque can be applied, and to prevent the possibility of the blocks being cracked by hydraulic pressure when the bolts are tightened.

### Refitting

32 Wipe away the timing oil with a 500-1000 gsm flannel or 2. This will remove any oil of carbon residue surface on the cylinder head is refitted.

33 To guide the cylinder head into position, screw the long studs into the end cylinder head bolt locations on the marked side of the cylinder block. As an alternative to the studs, use old cylinder head bolts with their heads cut off, and screw in to the ends to enable the bolts to be unscrewed.

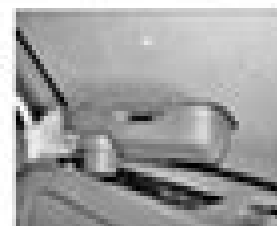
34 Ensure that the cylinder head mounting flanges are in place in the cylinder block, then fit the new cylinder head gasket over the downer (see illustration). The gasket can only be fitted one way, with the bolt to determine the gasket thickness at the front (see illustration 11.43). Then use to avoid damaging the gasket's rubber coating.



11.44 Remove the wiring



11.45 ... and disconnect the wiring connector from the opposite lighter



11.46 Lift out the storage tray from the top of the block



11.47 Under the four bolts (previously) securing the head, insert the mounting bracket in the block



11.48 Release the retaining clip, and remove the head from the top of the conditioned only further from the mounting bracket



11.49 ... then remove the bracket

35 Working through the storage tray (previously) under the four bolts securing the head, insert the mounting bracket in the block (see illustration).

36 Release the retaining clip and detach the head from the top of the condenser tray, then from the mounting bracket. Then remove the bracket (see illustration).

37 Disconnect the wiring connector from the power point.

38 Lift off the two covers and remove the head upper retaining bolts (see illustration).

39 Under the six bolts securing the head, insert support brackets to the bottom (see illustration).

40 Release the retaining clip and remove the head upper from the block on both sides (see illustration).

41 Using a small screwdriver, release the

both covers from the face on both sides (see illustration).



11.46a Lift off the two covers

42 Under the four outer mounting bolts from the face on both sides (see illustration).



11.46b ... and remove the four upper retaining bolts



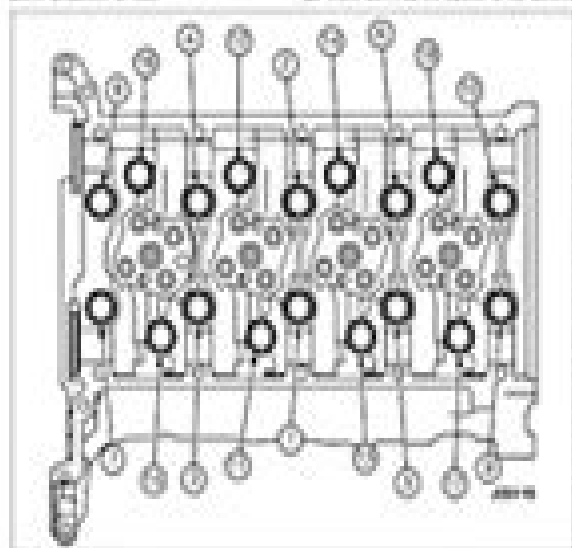
11.46c Under the six bolts (previously) securing the head, insert support brackets to the bottom



11.46d Release the retaining clip and remove the head upper from the face on both sides



11.46e Using a small screwdriver, release the bolt covers from the face on both sides



11.41 Tightening sequence for the cylinder head bolts

# Transit Mk6 Repair Manual

**Mark Storey**



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