

## ENGINE ASSEMBLY (Cont'd)

### Setting Valve-to-Tappet Clearance

The valve faces and seats must be lapped in before checking/setting valve-to-tappet clearance. (See Page 14-27 for lapping procedure.)

The piston must be at far dead center (FDC) of the compression stroke to measure valve-to-tappet clearance.

Rotate the crankshaft and push into the valve stems. The tappets will move in only one of the boxes.

Install valve into valve guides for the cylinder in which no measurements showing rock-valves firmly against seat and measure valve-to-tappet clearance with a feeler gauge (A).

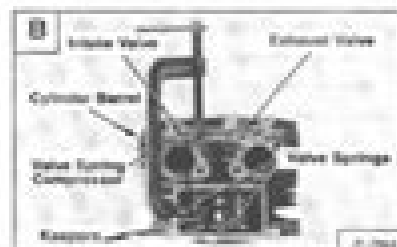
Intake Valves (Cold) ..... 0.003-0.008 inch  
 (0.076-0.190 mm)  
 Exhaust Valves (Cold) ..... 0.011-0.014 inch  
 (0.279-0.355 mm)

If the clearance is not correct, remove the valve and grind the stem until the clearance is correct. Make sure to grind the valve stem perfectly flat.

Valve stem seals can now be installed over the valve stem and into the valve guides. Make sure the lip on the seal is completely over the fractured area of the valve guide.

Install the upper spring retainers, spring circlip coils (towards cylinder heads), lower spring retainers and retainers on the valve stems.

Compress the valve spring with a valve spring compressor tool and install the keepers (B).



## ENGINE ASSEMBLY (Cont'd)

### Cylinder Head Installation

Install the cylinder head bolts into the cylinder heads.

Position the head gasket on the bolts.

Install the cylinder head and gasket on the cylinder block. Tighten the bolts in the correct sequence, to 10-20 ft.-lbs. (20-27 Nm) torque (A).

Install the breather assembly and the valve spring cover. (See Page 14-27.)

Install the fuel pump. (See Page 14-27.)

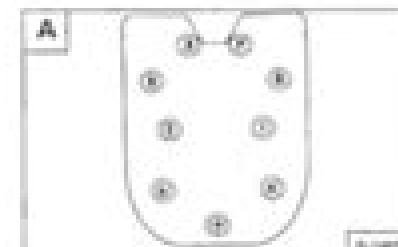
Install the starter. (See Page 5-1.)

Install the distributor and fanbelt. (See Page 14-22.)

Install the intake manifold. (See Page 14-22.)

Install the air shroud on the engine.

Install the engine. (See Page 14-16.)



# Gm 453 Deisel Service Manual

**Xiang Xie**



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