

## OVERHAUL (Continued)

Check all machined gasket surfaces for burrs, nicks, scratches and scores. Remove minor imperfections with an oil stone.

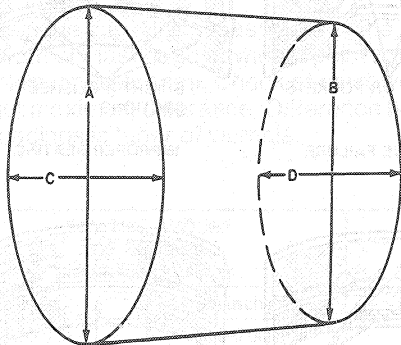
Check the cylinder bore for flatness of the cylinder head gasket surface following the procedure and specifications recommended for the cylinder head. The cylinder block can be machined to bring the cylinder head gasket surface within the flatness specifications listed in Section 03-01A (3.0L), 03-01B (3.0L/3.2L SHO) or 03-01C (3.8L), but **not to exceed 0.254mm (0.010 inch) stock removal from the original gasket surface.**

Replace all plugs that show evidence of leakage. Inspect the cylinder walls for scoring, roughness or other signs of wear. Check the cylinder bore for out-of-round and taper. Measure the bore with an accurate bore gauge following the instructions of the manufacturer. Measure the diameter of each cylinder bore at the top, middle and bottom with the gauge placed at right angles and parallel to the centerline of the engine. **Use only measurements obtained at 90 degrees to the engine centerline when calculating the piston-to-cylinder bore clearance.**

Inspect the main and connecting rod journals for cracks, scratches, grooves, scores or rough finish. Inspect the crankshaft oil seal surface for nicks, sharp edges, or burrs that might damage the oil seal during installation or cause premature seal wear.

A VS B = VERTICAL TAPER  
C VS D = HORIZONTAL TAPER  
A VS C AND B VS D = OUT OF ROUND

CHECK FOR OUT-OF-ROUND AT EACH END OF JOURNAL



A7267-B

## Core Plugs

## Removal and Installation

## Tools Required:

- Impact Slide Hammer T59L-100-B or T50T-100-A

To remove a large core plug, drill a 12.70mm (1/2 inch) hole in the center of the plug and remove with a Universal Impact Slide Hammer T59L-100-B, or T50T-100-A, or pry it out with a large drift punch. Clean and inspect the plug bore.

Prior to installing a core plug, the plug bore should be inspected for any damage that would interfere with the proper sealing of the plug. If the bore is damaged, it will be necessary to true-up the surface by boring for the next specified oversize plug.

Oversize (OS) plugs are identified by the "OS" stamped in the flat located on the cup side of the plug.

Coat the plug and/or bore lightly with an oil resistant (oil galley) Stud and Bearing Mount E0AZ-19554-BA (WSK-M2G349-A1) or Threadlock 262 E2FZ-19554-B (WSK-M2G351-A6), or equivalent, and install it following the procedure for cup-type or expansion-type below:

## Cup-Type

Cup-type core plugs are installed with the flanged edge outward. The maximum diameter of this plug is located at the outer edge of the flange. The flange on cup-type plugs flares outward with the largest diameter at the outer (sealing) edge.

## Expansion-Type

Expansion-type core plugs are installed with the flanged edge inward. The maximum diameter of this plug is located at the base of the flange with the flange flaring inward.

**CAUTION: It is imperative to push or drive the plug into the machined bore by using a properly designed tool. Under no circumstances is the plug to be driven using a tool that contacts the crowned portion of the plug. This method will expand the plug prior to installation and may damage the plug and/or plug bore.**

When installed, the trailing (maximum) diameter must be below the chamfered edge of the bore to effectively seal the plugged bore.