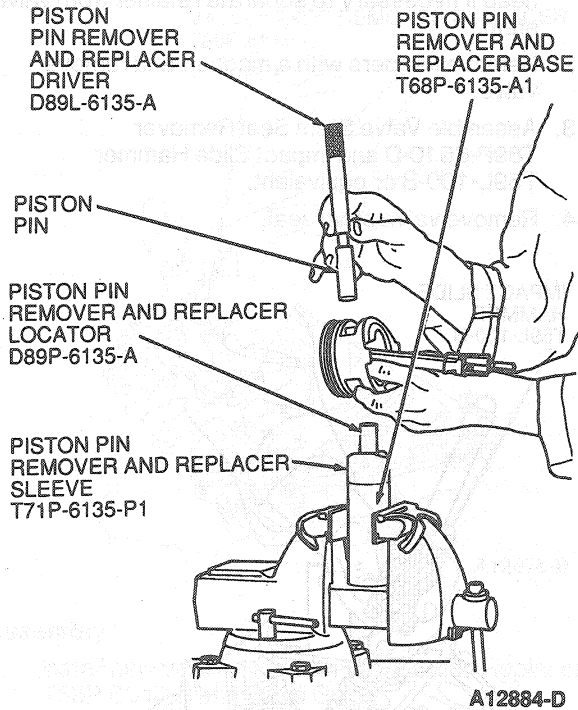


DISASSEMBLY AND ASSEMBLY (Continued)

5. Install the other snap ring in groove of piston pin hole.



6. Install piston rings and check the end gap of all piston rings. Gap must be within specification. Follow the instructions contained on the piston ring package when installing the piston rings.
7. Check the ring side clearance of the compression rings with Feeler Gauge D81L-4201-A or equivalent, by inserting it between the ring and its lower land. The gauge should slide freely around the entire ring circumference without binding. Any wear that occurs will form a step at the inner portion of the lower land. If the lower lands have high steps, the pistons should be replaced.
8. Ensure the bearing inserts and the bearing bore in the connecting rod and cap are clean. Foreign material under the inserts will distort the bearing and cause a failure. Install the bearing inserts in the connecting rod and cap with the tangs fitting in the slots provided.

Cylinder Head**Tools Required:**

- Impact Slide Hammer T59L-100-B
- Pivot Bar and Stand T87C-6565-A
- Valve Guide Remover / Replacer T89P-6510-A
- Valve Guide Replacer T89P-6510-B
- Valve Stem Seal Replacer T89P-6510-C

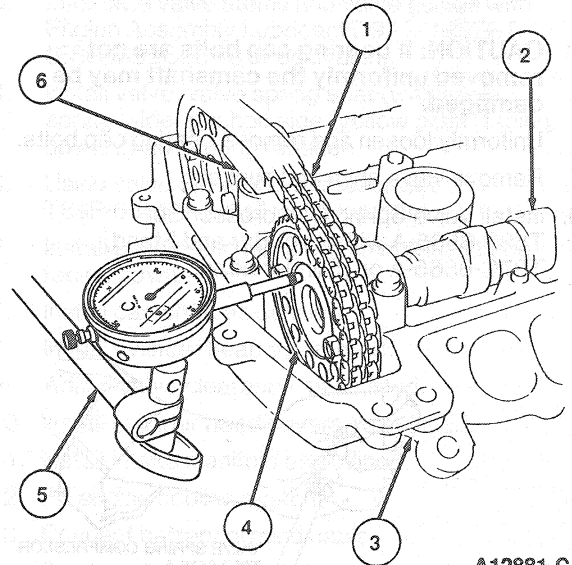
- Valve Stem Seal Remover T89P-6510-D
- Valve Spring Compressor Set T89P-6565-A
- Rotunda Dial Indicator with Bracketry 014-00262

Disassembly

1. Disconnect battery ground cable.
2. Drain coolant.
3. Remove intake manifold as outlined.
4. Remove cylinder head covers as outlined.
5. Remove cylinder heads as outlined.
6. Place cylinder head on holding fixture.

NOTE: Inspect camshaft end play before disassembly. If out of specification, determine if caused by excessive wear on crankshaft, block or both and replace as necessary. Using Rotunda Dial Indicator with Bracketry 014-00282 or equivalent, measure end play while moving camshaft back and forth.

Maximum play is 0.30mm (0.0118 inch).



Item	Part Number	Description
1	6268	Camshaft Timing Chain
2	6250	Camshaft
3	6049	Cylinder Head
4	6256	Camshaft Timing Chain Sprocket
5	014-00282	Rotunda Dial Indicator With Bracketry
6	6L266	Chain Tensioner

If end play is greater than maximum, replace camshaft and/or cylinder head.