

- b. Remove the lifter cover (2) and gasket (3). Discard gasket.

2. Remove lifters.

- a. Remove screw (4) securing anti-rotation device (5).
- b. Remove anti-rotation device.
- c. Remove the lifters (6) and place in clean plastic bags to prevent contamination.

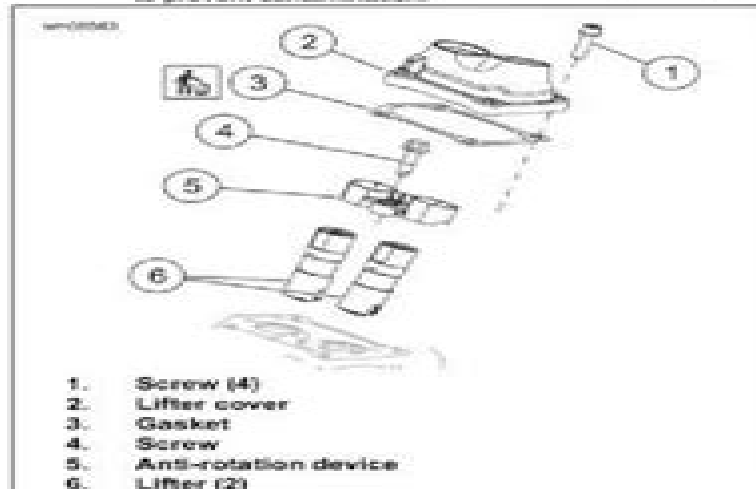


Figure 4-25. Lifter Cover

CLEAN AND INSPECT

1. Except for the hydraulic lifters, clean all parts in a non-volatile cleaning solution or solvent.

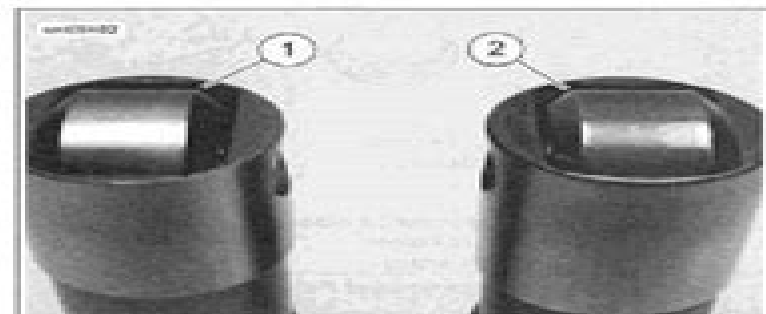
A WARNING

Compressed air can pierce the skin and flying debris from compressed air could cause serious eye injury. Wear safety glasses when working with compressed air. Never use your hand to check for air leaks or to determine air flow rates. (00061a)

2. Dry parts with low-pressure, compressed air.
3. Verify that O-ring seats and contact surfaces of pushrod covers are completely clean.
4. Verify that all oil holes are clean and open.
5. Replace any pushrods that are bent, dented, damaged, discolored, or have excessively worn or damaged ends.
6. Cover all parts to protect them from dust and dirt.

INSPECT LIFTERS

1. Measure lifter outer diameter. Record measurement.
2. Measure lifter bore. Subtract this measurement from recorded lifter measurement to determine clearance.
 - a. Clearance when new.
 0. 0009-0.0026 in (0.023-0.066 mm)
 - b. Install **new** lifters and/or replace crankcases if clearance exceeds service wear limit.
 0. 006 in (0.152 mm)
3. Check lifter roller end clearance.
 - a. Allowable end clearance.
 0. 008-0.022 in (0.203-0.559 mm)
 - b. Replace lifters if end clearance exceeds service wear limit.
 0. 022 in (0.559 mm)
4. Soak lifters in clean engine oil. Keep covered until assembly.
5. Examine lifter rollers. If damaged, examine the associated cam lobe.
 - a. Verify hydraulic lifter rollers turn freely.
 - b. Check for flat spots, scuff marks and pitting.
 - c. See Figure 4-26. A dull lifter roller surface is called frosting (2). Frosting is a cosmetic condition and does not affect function.
6. Inspect lifter for signs of wear.
 - a. Verify plunger is fully extended against C-clip.
 - b. Pump plunger to verify operation.



1. Normal roller
2. Frosted roller
Figure 4-26. Roller Inspection

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PT Brinkman



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