

### Inlet and Exhaust Manifolds — (Turbocharged Marine and Intercooled Engines) Fig. 2.

The inlet manifold is an aluminium casting, providing an unrestricted passage to the inlet ports. The inner pair of inlet ports are joined together. The water cooled exhaust manifold is cast iron and has removable covers to the water jacket, the rear end incorporates the mounting flange for the turbo-charger. Coolant connections are flange mounted on the top face of the water jacket housing, a drain cock is fitted on the lower face.

The manifolds are fitted with gaskets.

Where it is necessary to replace the exhaust manifold on 2704ET Marine engines, ensure only the latest type (Part No. 693F-9429-JAA), with drain cock (Part No. 723F-8115-JAA) is fitted.

### ROCKER COVER

The rocker cover is normally a steel pressing retained by screws around the flanged edge.

A breather tube and baffle are incorporated in the rocker cover and an oil filler cap is also fitted at the front of the steel cover.

### CYLINDER HEAD — Normally Aspirated Engines

The cylinder head is made of cast iron and incorporates replaceable valve guides and exhaust valve seat inserts. A composition type cylinder head gasket, with aluminium coated steel reinforcement around the cylinder bores is used, the head is retained by 9.525 mm. (3/8 in.) diameter bolts x 105.82 mm. (4 9/16 in.) long. These bolts have a letter X on the head for identification purposes. **BOLTS MARKED 100, AS USED ON 590E/592E ENGINES MUST NOT BE USED.**

From 1st May 1976, all turbocharged engines have been fitted with new type cylinder head bolts having integral washers. These new bolts are not interchangeable with the earlier types and can only be used on engines to which they were fitted as original equipment or on earlier cylinder heads modified as detailed in paragraph 24 on Page 17.

Note: Turbo Plus engines have two special cylinder head bolts for mounting the air charge cooler.

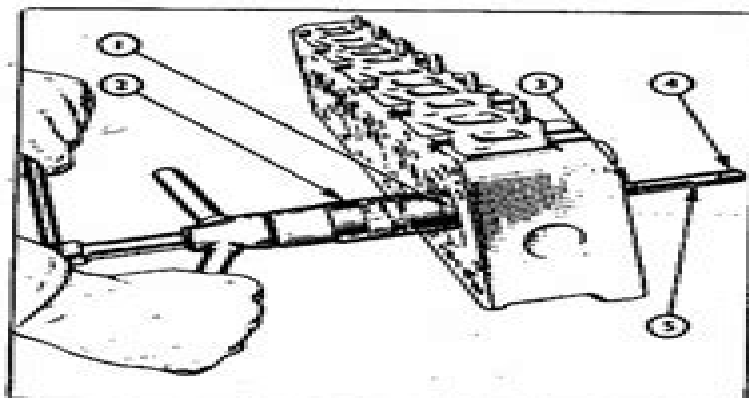


Fig. 3 — Valve Guide Removal

- 1 Conical Seat Detail "a"
- 2 Guide Remover and Replacer Tool No. CT.6073
- 3 Valve Guide
- 4 Nut Detail "d"
- 5 Spacer Detail "b"

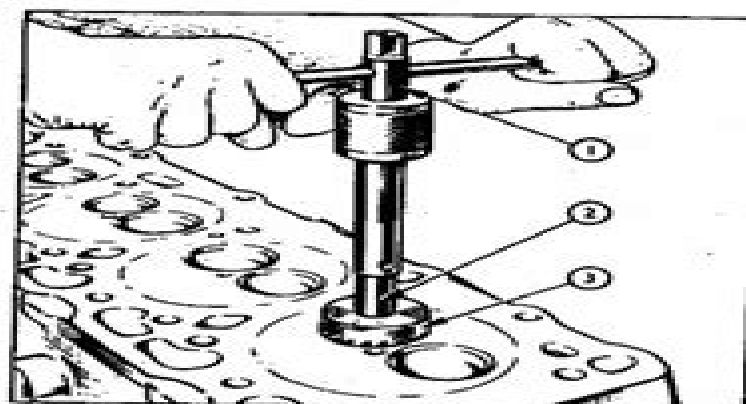


Fig. 4 — Recutting Valve Seats

- 1 Handle Tool No. 316X
- 2 Pilot Tool No. 316-12
- 3 Inlet Valve Seat Cutter Tool No. 317TT.30

JUNE 1979

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**Hussin A.Rothana**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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