

Fig. 27. Clearance rocker - rocker shaft

## Fitting of cylinder head

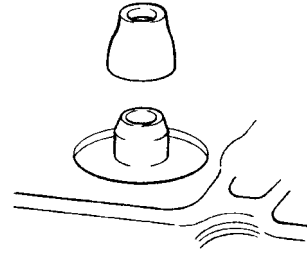


Fig. 28. Fitting of valve stem seals

5. Check that the rocker bearing surfaces are not out-of-round worn.

Calculate the clearance between the rocker and shaft. The clearance must not exceed 0.2 mm (.0078 in).

Check that the ball pin's spherical part is not deformed or worn. The threads should be undamaged on the pin and lock nut. The locknut should be in good condition.

The mating sphere of the rockers (against the valve) must not be unevenly worn or concave. Adjustment for minor wear can be made in a grinding machine.

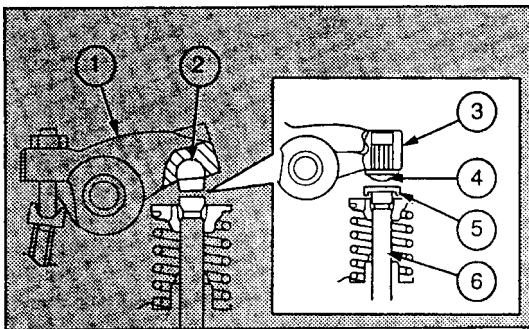
Note: MD2010-2030. A new type of rocker (including valve cap) has been introduced as from engine number:

MD2010: 5101202984

MD2020: 5101308898

M D2030: 5101465653

Only the new type of rocker is available as a spare part. If one or several of the older type of rocker need to be replaced, all the rockers must be replaced at once, and valve caps installed on the valve stems.



Comparison between new and old rockers

1. Earlier rocker
  2. Earlier rocker tip
  3. The new rocker
  4. The new rocker tip
  5. Valve cap
  6. Valve
6. Oil in the rocker mechanism and fit the different parts.

1. Press down new valve stem seals on the valve guides.

**Note:** MD2030 and MD2040 have different seals for the guides for the inlet and outlet valves.

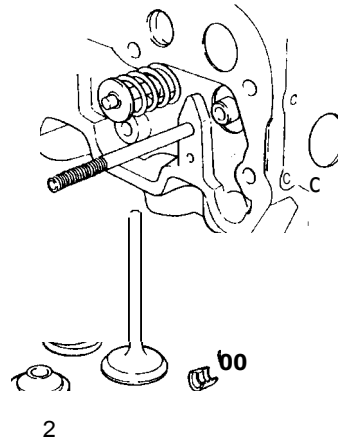


Fig. 29. Fitting of valves

1. Valve lock
2. Valve spring retainer
3. Valve spring
4. Valve
5. Valve cap\*

\*MD2040 and later versions of MD2010, 2020, 2030

2. The valves should be fitted in the correct order. Oil in the valve spindles and fit the valve in its guide. Place the valve spring and retainer in position and press the spring together with a valve spring tensioner. Fit the valve lock.

**Note:** Observe care when fitting the valves and compressing the springs so that the valve stem seals are not damaged.

3. Fit the valve caps when all valves are fitted. (Applies to MD2040 and later versions of MD2010, MD2020, MD2030 (Please refer to the note below item 5)).
4. Fit new plugs if these have been removed.