

**Sequence III G Engine Oil Certification Test  
Engine Assembly Manual**

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**Revision 02**

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## **Section 0**

### **Hardware usage guidelines**

All materials used in this test must conform to acceptance guidelines as specified in the ASTM Sequence IIIG Test Procedure accompanied by the direction and information contained in this Assembly Manual.

Any changes in procedures or substitutions of qualified parts or materials, must be approved by the Sequence IIIF / G Surveillance Panel prior to their use in non-reference and reference oil tests.

Any parts or materials specified in this document that are found to be unacceptable for testing, both pre and post test, must be reported to the Test Sponsor, the appropriate Critical Parts Distributor, and the ASTM Test Monitoring Center.

Unless otherwise directed, all parts and materials required for testing should be stored and used on a first in – first out basis following the guidelines outlined in the ASTM Test Monitoring Center Sequence IID and IIIE Information Letter #60 June 21, 1991.

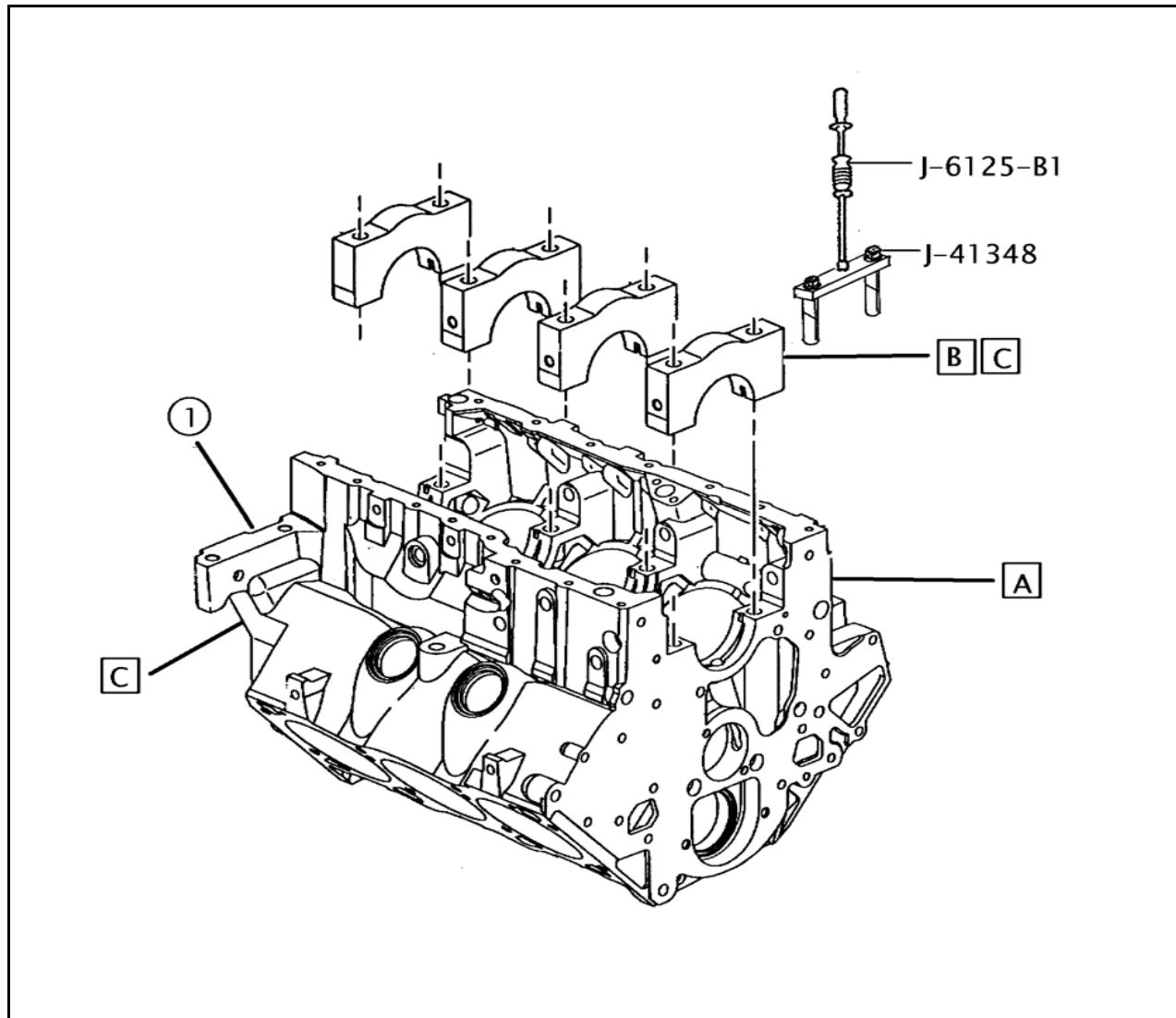
## **Section 01**

### **Revision Update Timeline**



## **Section 1**

### **Cleaning and Pre Hone Preparation**



Description of Operation	
A	Upon introduction of a new block into the system, check for any damage to machined surfaces which might have occurred during shipping or handling. Check main bore and camshaft tunnel alignment using appropriate manderals.
B	Remove main cap side & main bolts. Use Kent-Moore J-41348 main bearing cap puller (12Nm) & J-6125-1B slide hammer to remove main caps. <b><u>Note: Main bearing caps are press fit. Do not hammer caps back and forth during removal. Damage to the caps may result in damage to engine bearings during test.</u></b>
C	Record engine serial number and or assign a laboratory number and mark necessary identification on engine block and crankshaft main caps. <b><u>Note: Do not use stamped tool set for marking identification on main caps.</u></b>

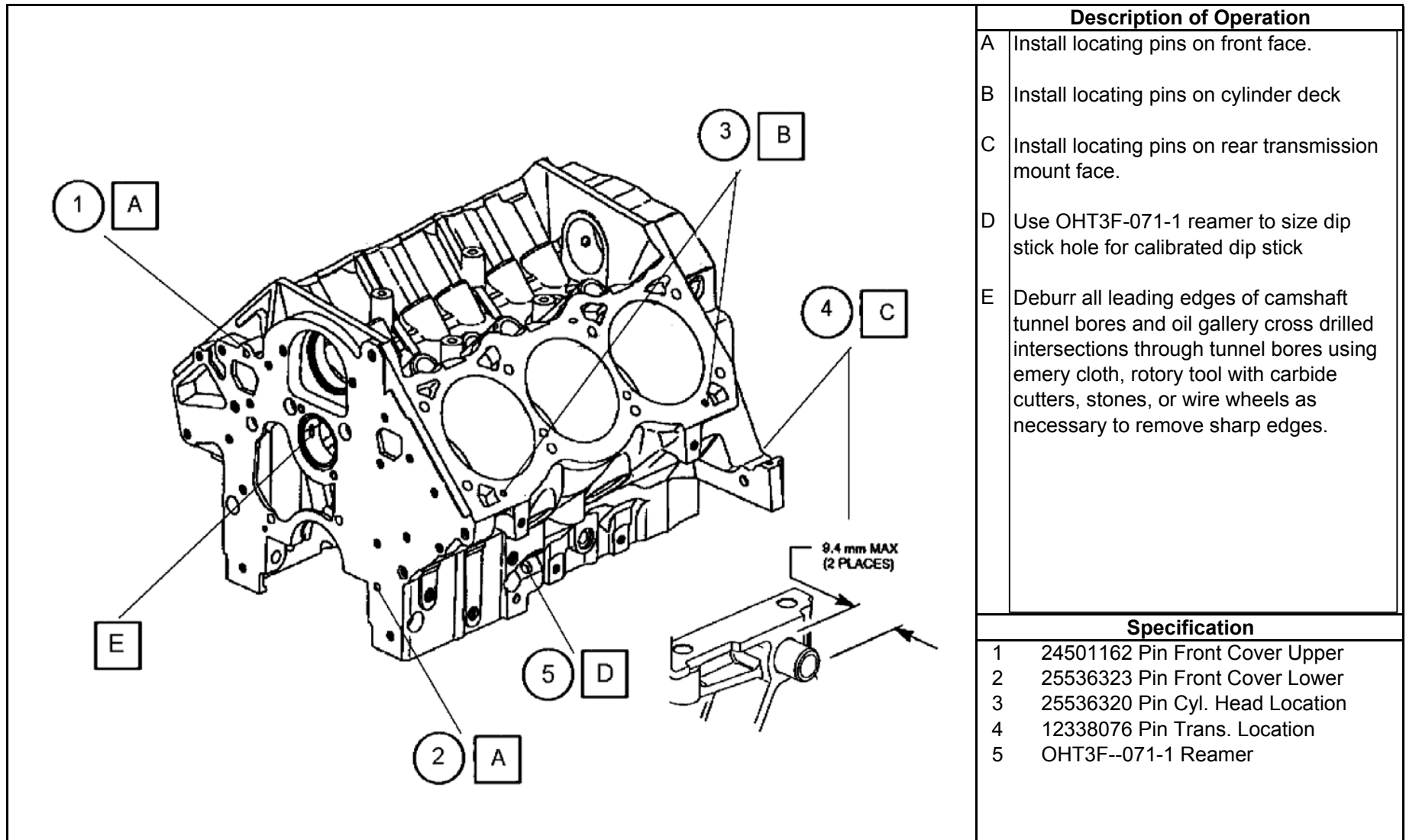
Specification	
1	24506028 Block Assembly

REV	Date	Revision History
1	12/31/97	Block-1

View	
<b>Engine Block</b>	
New block and pre-hone prep	
Serial Number Locations	

<b>New Block and Pre-Hone Prep</b>	<b>Sequence III G</b>
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Section	Sheet
1	1



Description of Operation	
A	Install locating pins on front face.
B	Install locating pins on cylinder deck
C	Install locating pins on rear transmission mount face.
D	Use OHT3F-071-1 reamer to size dip stick hole for calibrated dip stick
E	Deburr all leading edges of camshaft tunnel bores and oil gallery cross drilled intersections through tunnel bores using emery cloth, rotary tool with carbide cutters, stones, or wire wheels as necessary to remove sharp edges.

Specification	
1	24501162 Pin Front Cover Upper
2	25536323 Pin Front Cover Lower
3	25536320 Pin Cyl. Head Location
4	12338076 Pin Trans. Location
5	OHT3F--071-1 Reamer

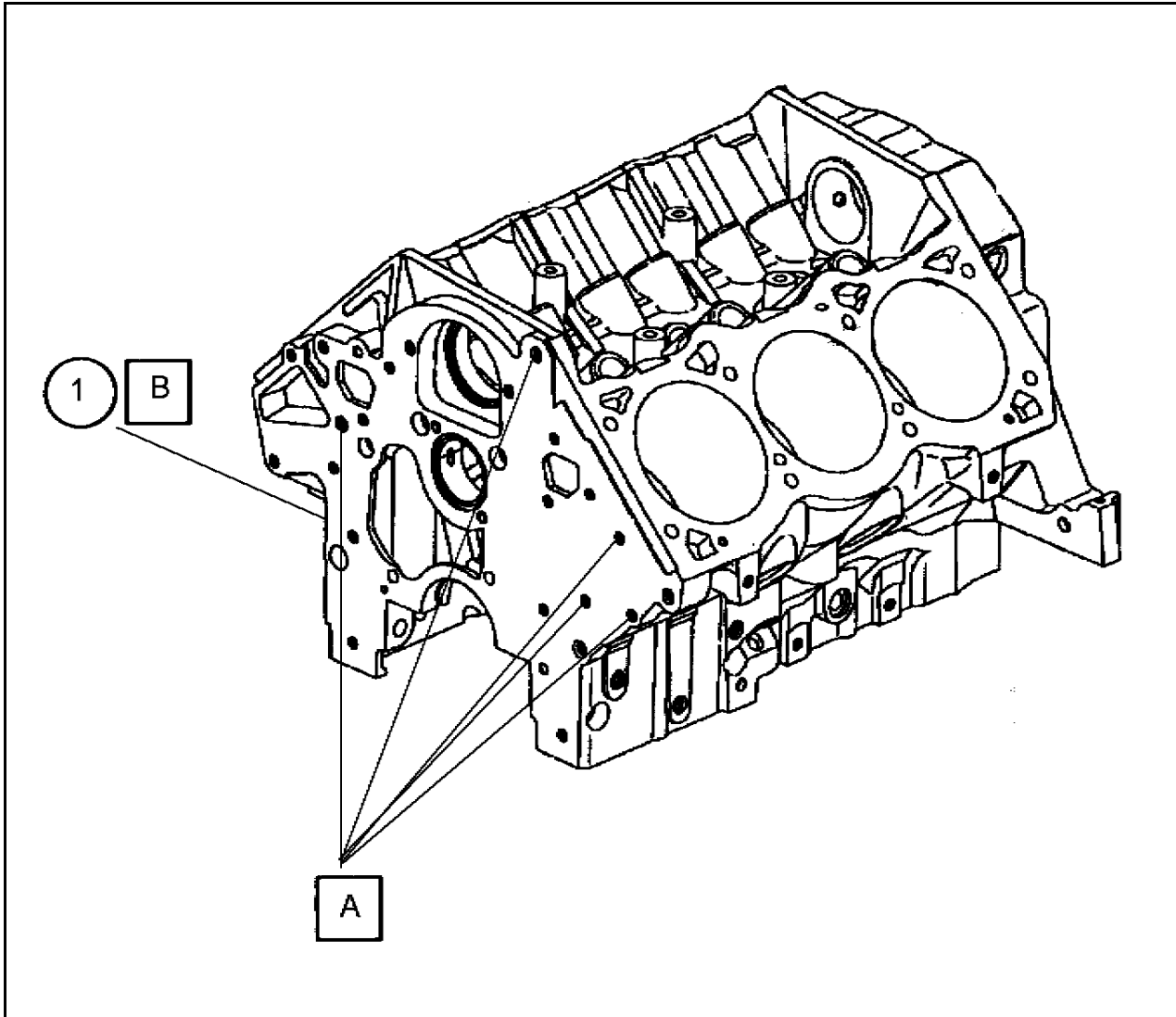
REV	Date	Revision History
1	12/31/97	Block-2

View	
Engine Block	
New block and pre-hone prep	
Locating pin installation	
Camshaft tunnel and dip stick prep	

<b>New Block and Pre-Hone Prep</b>	<b>Sequence III G</b>
------------------------------------	-----------------------

Section	Sheet
1	2





Description of Operation	
A	Install threaded fasteners with #2 Non-Hardening Permatex or Perfect Seal #4 in locations identified in view.
B	Install 1/4NPT plug in main oil gallery on the right front side of engine block.
	Note: This location is not to be used for temperature control or thermocoupled.

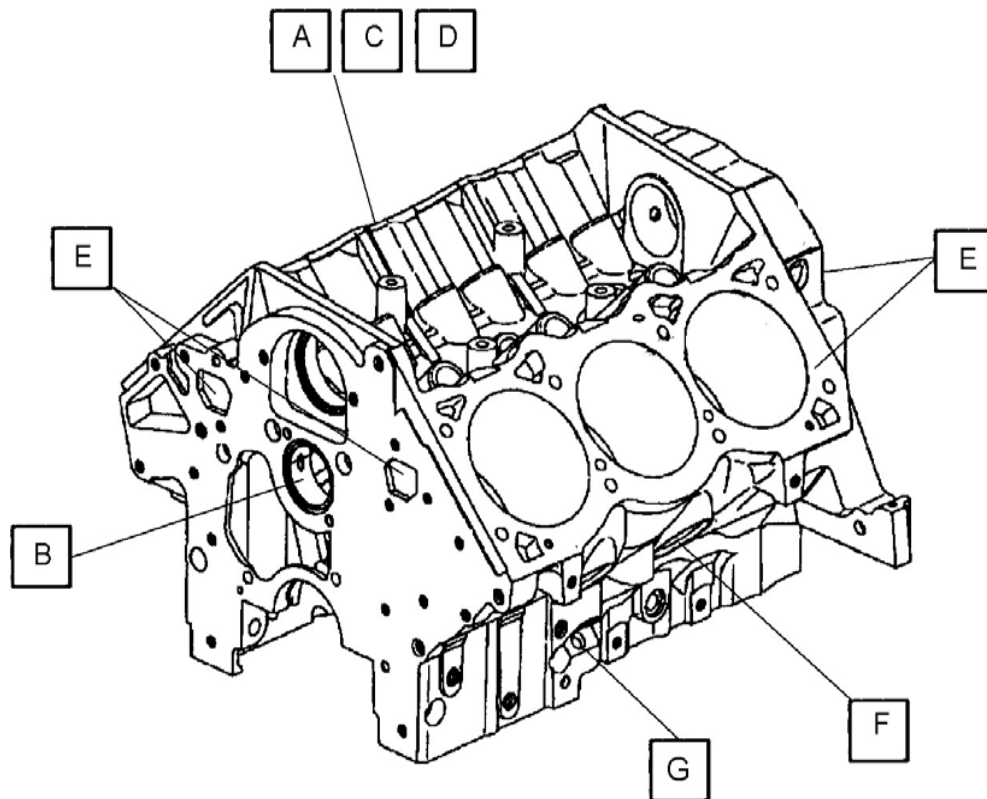
Specification	
1	444777 Plug Auto Hex Socket

REV	Date	Revision History
1	12/31/97	Block-3

View	
<b>Engine Block</b>	
New block and pre-hone prep	
Plugged holes in front of engine	

<b>New Block and Pre-Hone Prep</b>	<b>Sequence III G</b>
------------------------------------	-----------------------

Section	Sheet
1	3



Description of Operation	
A	Remove all casting slag and core sand deposits from the coolant passages on new blocks and check for core sand deposits on used blocks
B	Remove all camshaft bearings and oil gallery plugs.
C	Clean all gasket surfaces.
D	Chase all threaded holes for the main caps and cylinder head fasteners using a Class 2B Tap.
E	Install block-off plates over the coolant passages on the front face, rear face, and cylinder deck. (Fabricate in-house)
F	Install coolant Welch plugs.
G	Ream dip stick hole using OHT3F-071-1 reamer for calibrated dip stick.

Specification

REV	Date	Revision History
1	12/31/97	Block-4

View
<b>Engine Block</b>
New block and pre-hone prep

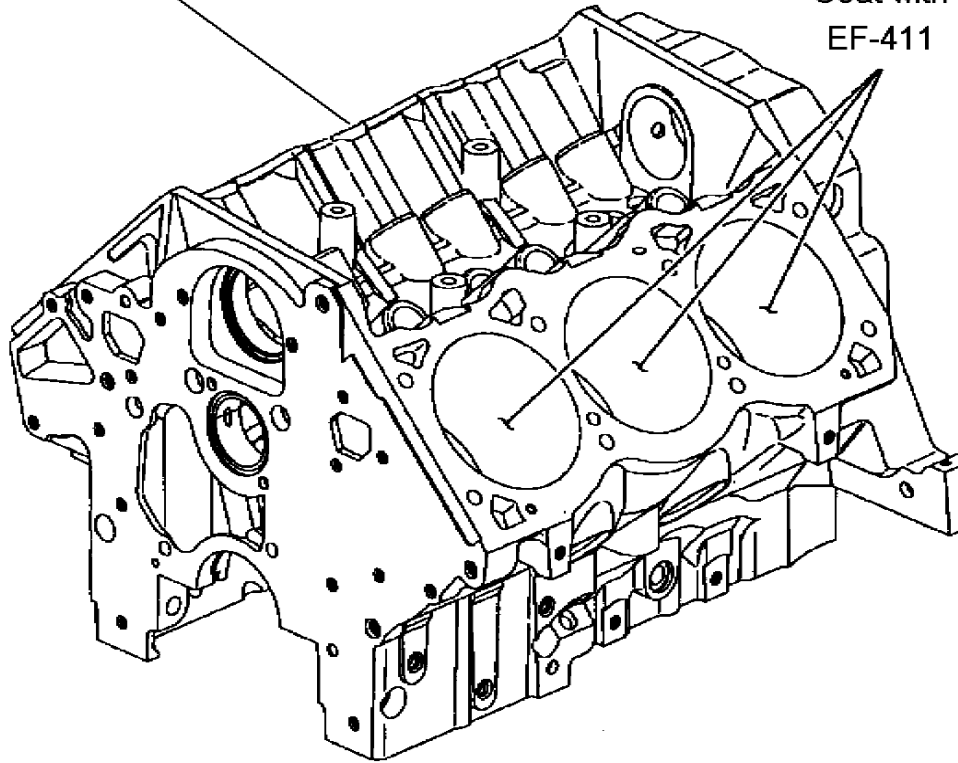
<b>New Block and Pre-Hone Prep</b>	<b>Sequence III G</b>
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Section	Sheet
1	4

Spray engine with 50/50  
Solution EF-411 / Alipahitic Naphtha

A B

Coat with  
EF-411



**Description of Operation**

- A The engine may be cleaned using an automated washing device, however, caution should be used to prevent oxidation flash over of the ferrous surfaces. Note: Do not use caustic chemicals or acid type baths. See 5A
- B The block must be thoroughly cleaned using brushes through the oil galleries, camshaft tunnel, and cylinder bores with aliphatic naphtha to remove any detergent residue before honing.
- ? (Step Sec. 1 sheet 6)  
Repeat step "A & B" after honing.
- Note: If this is the final cleaning after honing, spray the entire engine block using a 50/50 solution of EF-411 and aliphatic naphtha. Air dry to remove excess solution.
- ? (Step Sec. 3 sheet 1)

**Specification**

**View**

**Engine Block**

Engine block cleaning

**Section**

**Sheet**

1

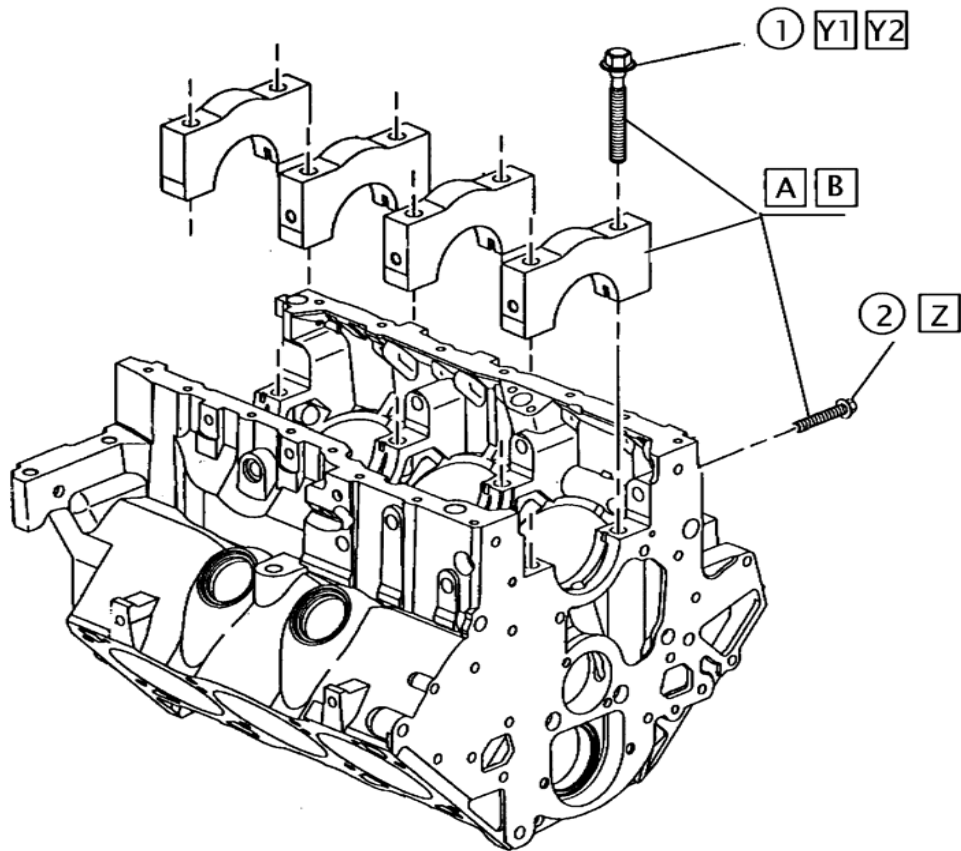
5

REV	Date	Revision History
1	12/31/97	Block-5

**New Block and Pre-Hone Prep**

**Sequence III G**

			Description of Operation	
<p>Automatic Parts Washer Procedure for IIIF Engine Blocks</p> <ol style="list-style-type: none"> <li>1) Use only NAT-50-S or PDN-50 soap at a concentration of 16 pounds of soap per 100 gallons of water.</li> <li>2) Set the temperature of the water to 140 degrees F.</li> <li>3) Do not pre-condition the water that is being used in any way.</li> <li>4) Prior to installing the engine in the parts washer, ensure that all coolant passages are blocked off to prevent cleaning solutions from entering the passages.</li> <li>5) Allow the block to run through the cleaning cycle for a period of 30 to 40 minutes.</li> <li>6) After the cycle is complete, immediately remove the block from the washer and thoroughly clean all residue from the NAT-50 or PDN-50 soaps from the engine block, crankcase, valley, and external areas with stoddard solvent and brushing.</li> <li>7) Wipe cylinder bores out with a lint free towel.</li> <li>8) Spray engine block with a mixture of 50/50 EF-411 and stoddard solvent.</li> </ol>				
			<b>Specification</b>	
<b>REV</b>	<b>Date</b>	<b>Revision History</b>	<b>View</b>	
1	9/5/00	Procedure for Better Engineering Jet Washer usage	<b>Engine Block</b>	
2	4/28/03	Updated cleaning instructions	Engine block cleaning procedure for automated type jet washers	
<b>New Block and Pre-Hone Prep</b>		<b>Sequence IIIG</b>	<b>Section</b>	<b>Sheet</b>
			1	5A



**Description of Operation**

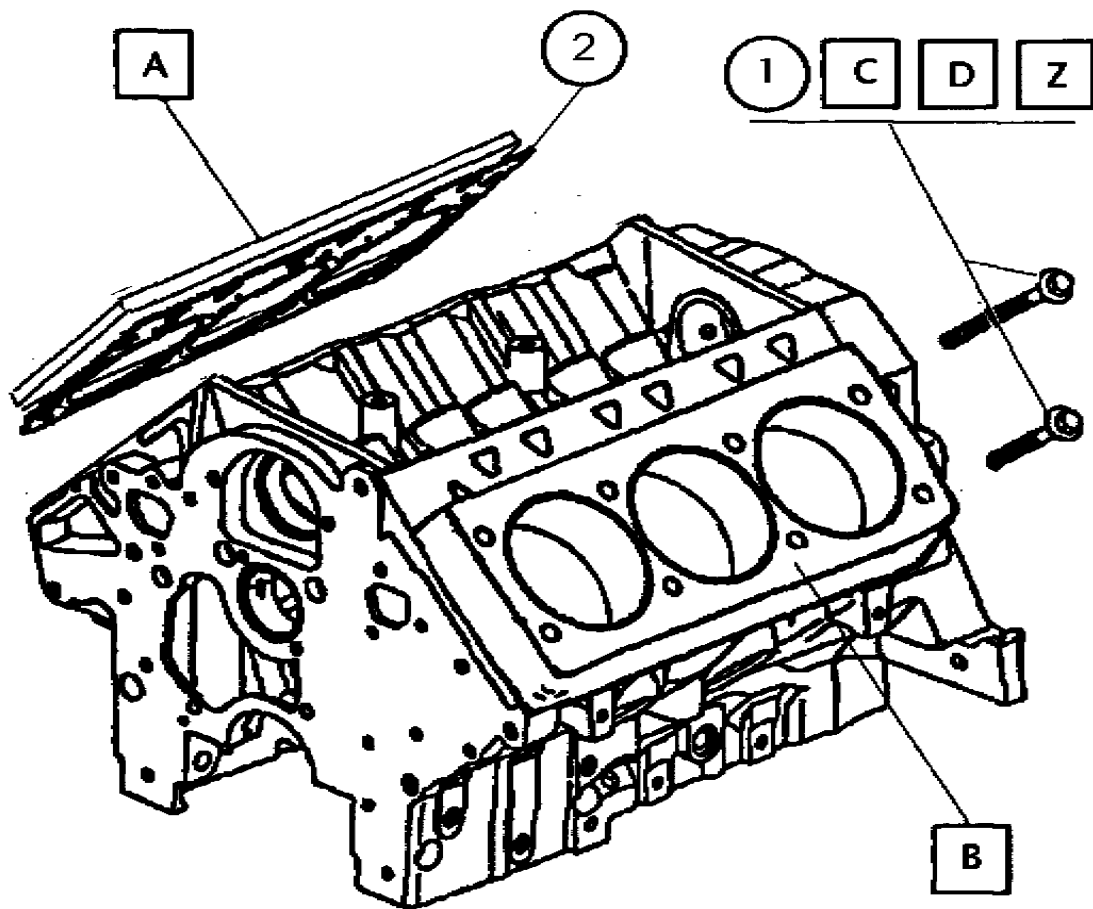
- A Clean and oil all main cap bolts (EF-411) and install main caps. Note: Do not use air tools to run main caps down.
- B Install main cap with fasteners as guides and tap into position with plastic mallet or use very light pressure by hand with speed handle and socket in crisscross pattern to draw the main cap down.
- C Install main cap side bolts
- Y1 Tighten all main bolts to 70 Nm to fully seat main caps and then loosen the bolts 360° counterclockwise.
- Y2 Torque & Angle  
20Nm then 40Nm + 35°+35°+35° (repeat 3 times from center out)
- Z Torque & Angle 15Nm + 45°

**Specification**

- 1 24503056 Bolt (8) see note Y (Tighten before Z)
- 2 24505576 Bolt (6) see note Z (Tighten after Y)

REV	Date	Revision History
1	1/10/98	Block-6
New Block and Pre-Hone Prep		Sequence III G

View	
Engine Block	
Main cap installation	
Section	Sheet
1	6



**Description of Operation**

- A Remove cylinder deck block off plates.
- B Install B-H-J Torque Plates w/gaskets (GM-3.8/3E-R-S-T-HT)
- C Note: When installing torque plates, 1) move the bottom row of fasteners to the top, 2) discard the top row of fasteners, 3) use the post test fasteners from the last teardown in the bottom row on the torque plates.
- D Use the Torque Sensor 1 wrench set on soft joint for gasketed applications.
- Z 30Nm-50Nm-80Nm - JCS-TEL to yield.  
(Step Sec.2 sheet 1)

**Specification**

- 1 25527831 Bolt Cyl. Head (8)(Long)  
See note Z  
Use in upper and lower position with double hardened washers on lower row. Obtain washers from B-H-J.
- 2 24503801 Gasket RH.  
24503802 Gasket LH.

**View**

**Engine Block**

B-H-J Torque Plate installation

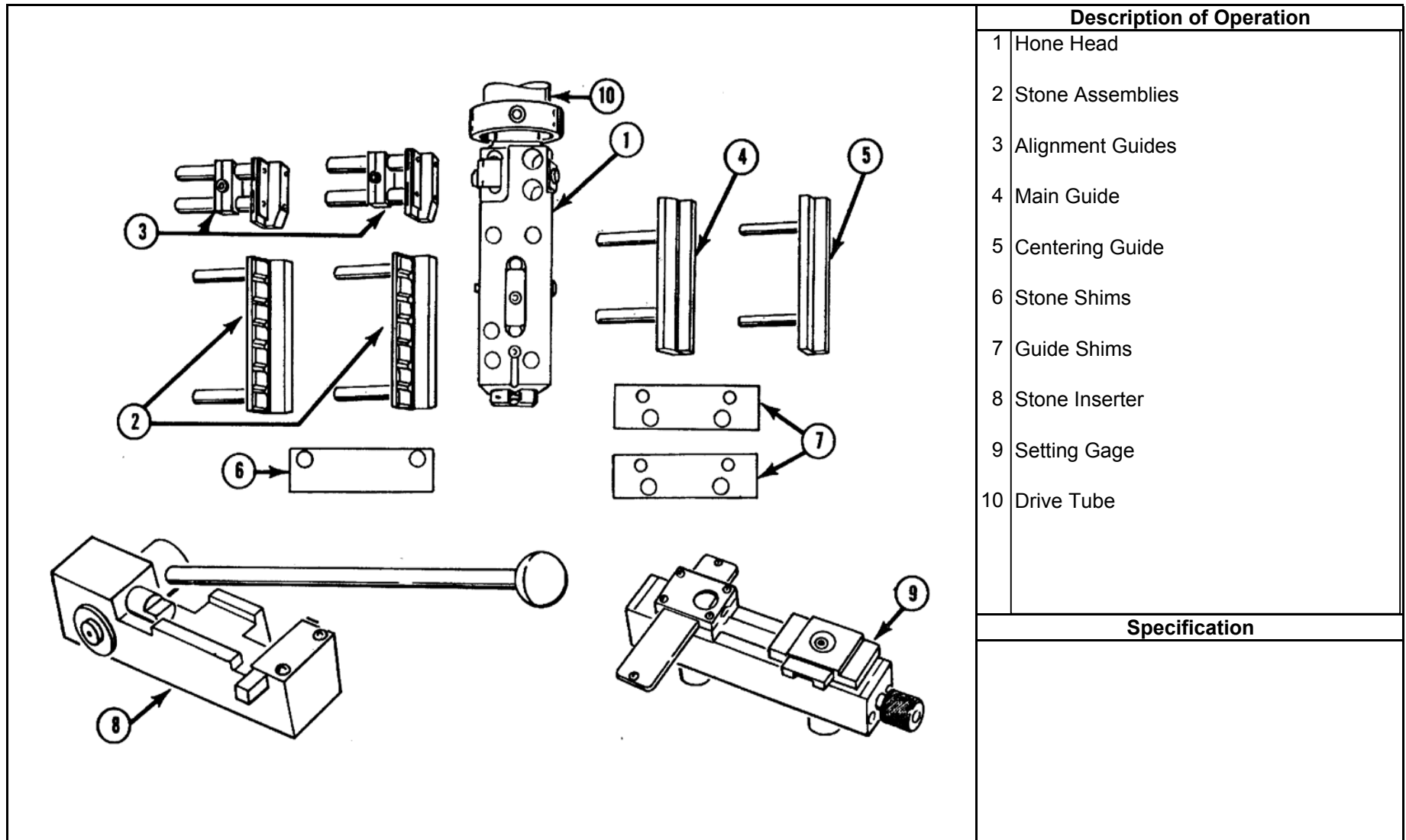
Section	Sheet
1	7

REV	Date	Revision History
1	1/1/98	Block-7

<b>New Block and Pre-Hone Prep</b>	<b>Sequence III G</b>
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## **Section 2**

### **Cylinder Block Honing**



Description of Operation	
1	Hone Head
2	Stone Assemblies
3	Alignment Guides
4	Main Guide
5	Centering Guide
6	Stone Shims
7	Guide Shims
8	Stone Inserter
9	Setting Gage
10	Drive Tube

Specification	

REV	Date	Revision History
1	1/7/98	Hone-1-1

View	
Hone Unit Details	

Cylinder Honing	Sequence III G
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Section	Sheet
2	1



**Description of Operation**

Set the turret block to the standard position and adjust the setting block snugly in the cylinder bore.

19 Place the stone assembly in the setting gage with the slide scale set at "0". Add shims as necessary to adjust to 1 - 2 on the slide scale for the stone and guide assemblies.

20 Place the plateau honing tool in the setting gage with the slide scale set at "0". Add shims as necessary to adjust to 3 - 4 on the slide scale.

Note: The alignment guides are not used during honing of IIIF blocks.

**Specification**

- 1 EHU 512 Stone
- 2 C30-PHT-731 Plateau Honing Tool

**View**

**Stones & Guides**

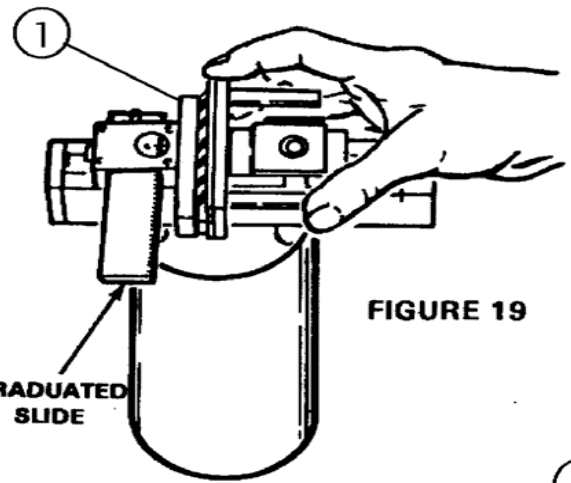
Stone and guide adjustment

**Section**

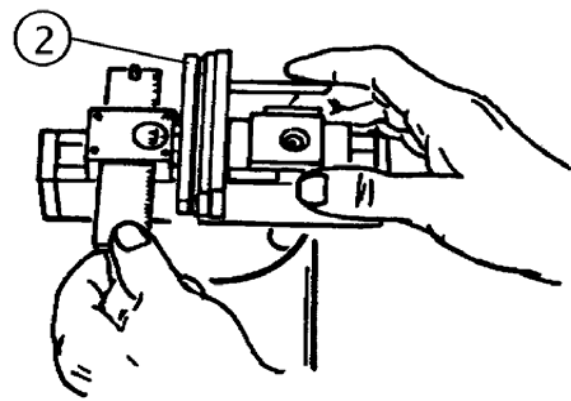
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**Sheet**

2

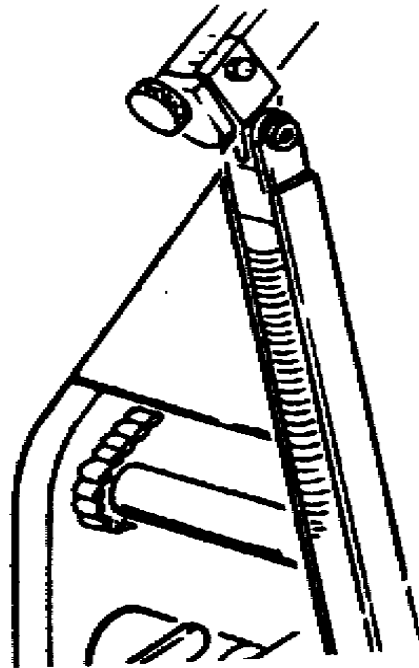
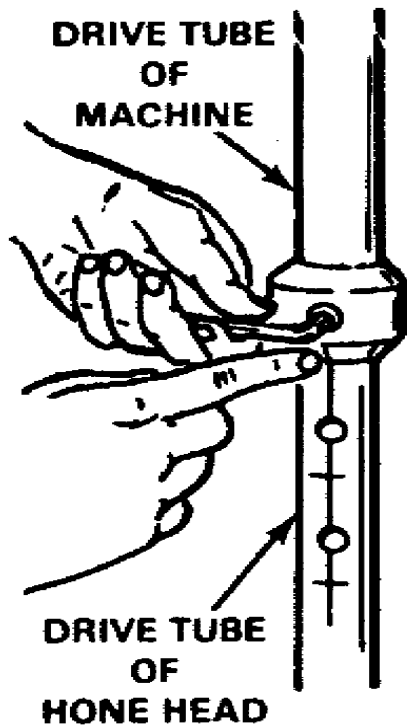


**FIGURE 19**



**FIGURE 20**

REV	Date	Revision History
1	1/7/98	Hone-3-1 & 3-2
Cylinder Honing		Sequence III G



**Description of Operation**

Slip the Drive Tube of the Hone Head into the Drive Tube of the CV-616-46 and tighten the set screw with the first set of index marks in line.

**Specification**

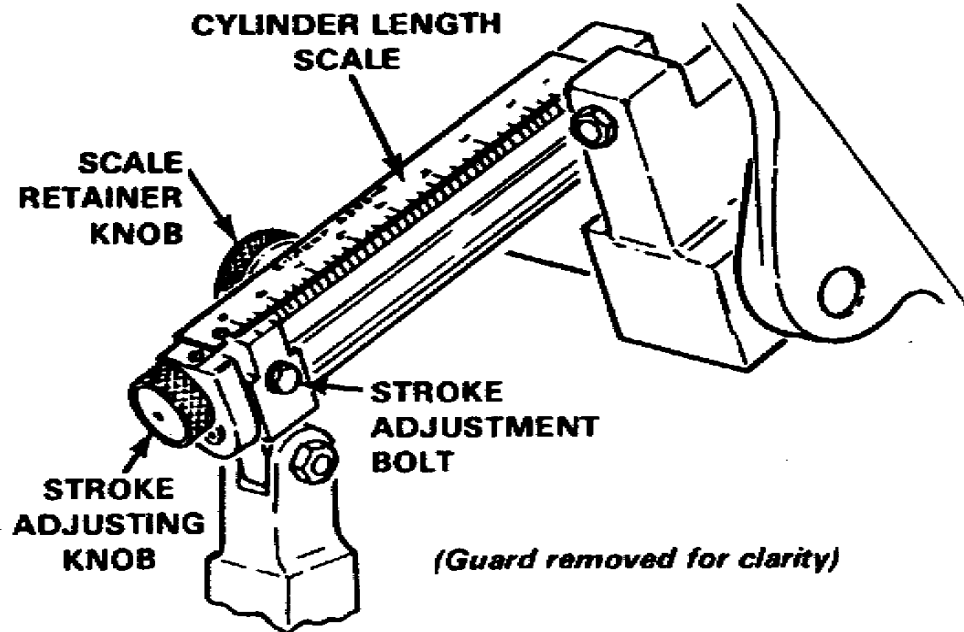
REV	Date	Revision History
1	1/7/98	Hone-2-2

View
<b>Drive Tube</b>
Drive tube adjustment

**Cylinder Honing**

**Sequence III G**

Section	Sheet
2	3



**FIGURE 23**

**Description of Operation**

Loosen stroke adjustment bolt and set stroke length at 5 3/8"

Note; to change the Stroke Scale to Metric, order PNP 1275M.

**Specification**

**View**

**Stroke Length**

**Section**

2

**Sheet**

4

REV	Date	Revision History
1	1/7/98	Hone-4

**Cylinder Honing**

**Sequence III G**

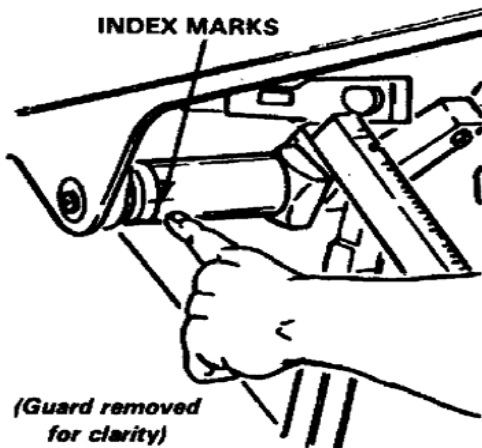


FIGURE 24

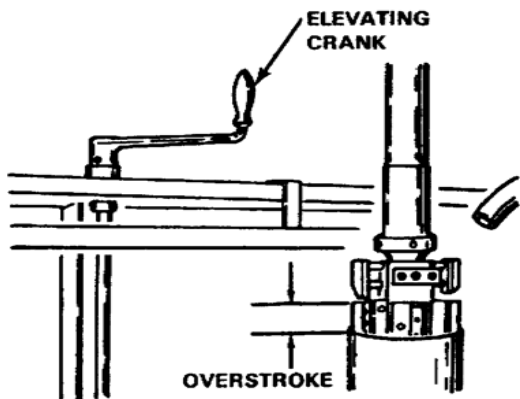


FIGURE 25

Stone Length		Top Overstroke Setting	
Inches	mm	Inches	mm
2-3/4"	70 mm	3/8"	9,5 mm
3-1/2"	89 mm	5/8"	16 mm
4-1/2"	115 mm	13/16"	21 mm
6"	152 mm	1-1/16"	27 mm

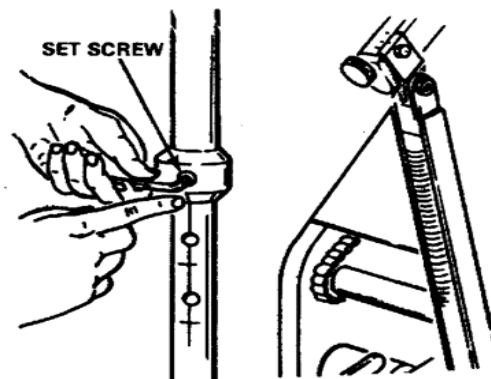


FIGURE 26

**Description of Operation**

With the hone head in the cylinder and the index marks lined up as shown in figure 24, use the elevating crank to adjust the overstroke length to 3/8" as indicated in figure 26 for 2 3/4" stone length.

Note: Drive tube should be set at first set of index marks.

**Specification**

**View**

**Overstroke**

Overstroke adjustment

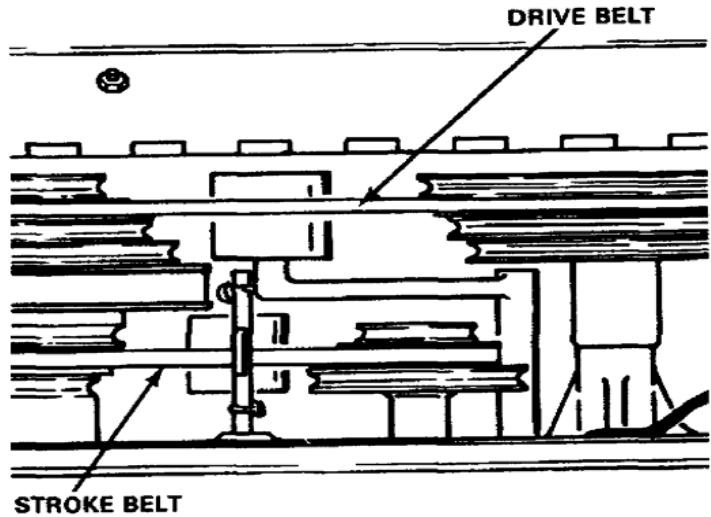
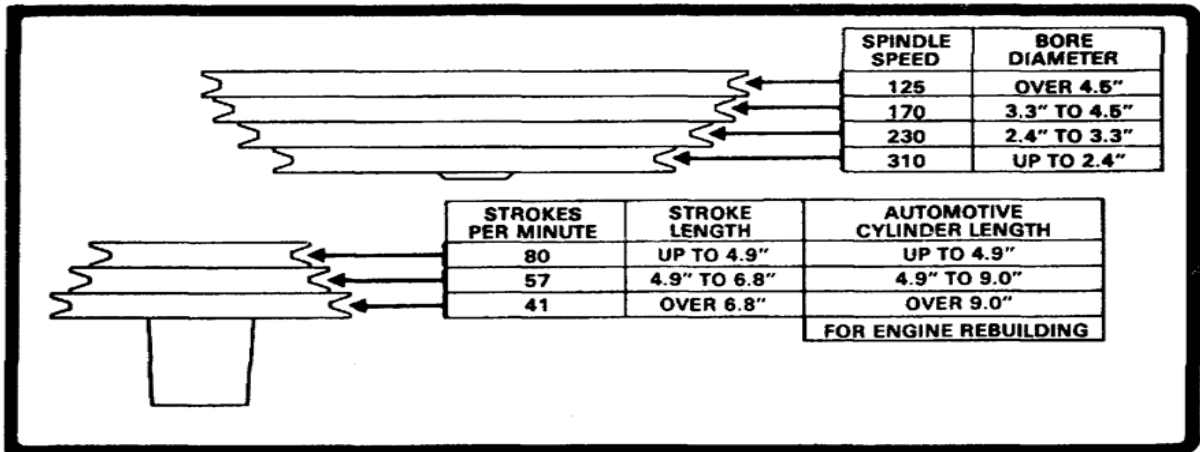
**Section**

2

**Sheet**

5

REV	Date	Revision History
1	1/7/98	Hone 4 & 5



**FIGURE 28**

**Description of Operation**

Open the left side of the belt cover and set the spindle speed at 170 and the strokes per minute at 57.

**Specification**

**View**

**Speed & Stroke**

**Section**

**Sheet**

2

6

REV	Date	Revision History
1	1/7/98	Hone-6

**Cylinder Honing**

**Sequence III G**

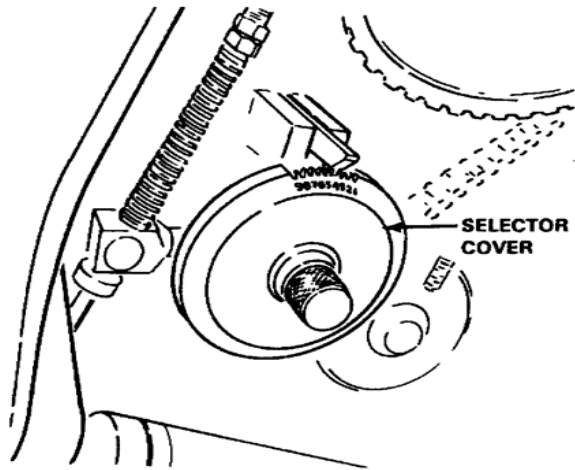


FIGURE 29

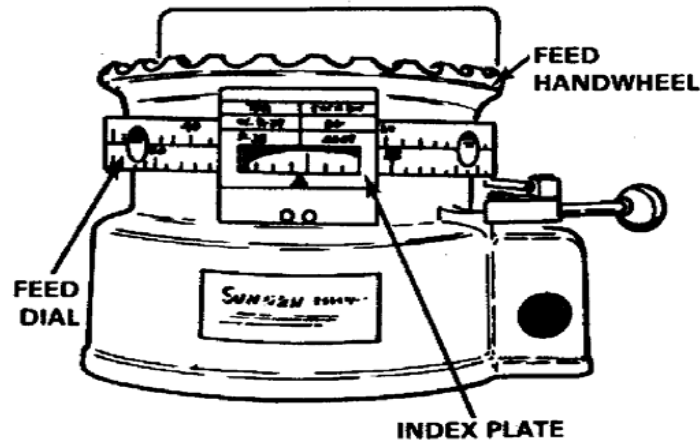


FIGURE 30

**Description of Operation**

Set the ratchet feed rate on the selector cover to 4. See figure 29

Use the index plate for the lower scale identified as P28 .005 per division.

Note: to change the Hand Wheel Assembly and Stroke Plate to Metric, order CV-215MA.

**Specification**

**View**

**Ratchet Feed & Index Plate**

**Section**

2

**Sheet**

7

REV	Date	Revision History
1	1/7/98	Hone-7
2	12/1/99	Change note from .0005 to .005

**Cylinder Honing**

**Sequence III G**

<p style="text-align: center;"><b>Honing Operations Guide</b></p> <p>Rough Cut to Size (EHU-512 Stones)</p> <ol style="list-style-type: none"> <li>1 Insert hone head into cylinder and rotate feed handle to the left while shaking the hone head until a slight resistance is felt.</li> <li>2 Adjust the feed dial for the amount of stock to be removed. (See supplemental section IV.C. honing to size.</li> <li>3 Set mode switch to zero shutoff.</li> <li>4 Start honer and watch control panel for unit load and taper indication. Unit load should be between 20 and 30 units during operation. Adjust table for overstroke or dwell as necessary to eliminate taper.</li> </ol> <p>Plateau or Finish Hone (C30-PHT-731 Plateau Honing Tool)</p> <ol style="list-style-type: none"> <li>1 Insert hone head into cylinder and rotate feed handle to the left while shaking the hone head until a slight resistance is felt.</li> <li>2 Adjust feed dial so it will not shut the machine off before the control panel timer.</li> <li>3 Set mode switch to timed mode and set controller to 45 seconds.</li> <li>4 Start honer and increase unit load to 20 to 30 units and allow to run until system shuts off.</li> </ol> <p style="text-align: center;"><b>SEE SUPPLEMENTAL SECTION IV. HOW TO HONE</b></p>			<b>Description of Operation</b>	
			<p>Use LP8X-55 Chlorine free fluid set at 7L/min. flow rate. Use dual canister filtration system with honing mats CV-1100. Change filters, fluid, and mats every 15 hours of operation.</p>	
<p style="text-align: center;"><b>SEE SUPPLEMENTAL SECTION IV. HOW TO HONE</b></p>			<b>Specification</b>	
			<b>View</b>	
<b>REV</b>	<b>Date</b>	<b>Revision History</b>	<b>Fluid and Operations Guide</b>	
1	1/7/98			
<b>Cylinder Honing</b>		<b>Sequence III G</b>	<b>Section</b>	<b>Sheet</b>
			2	8

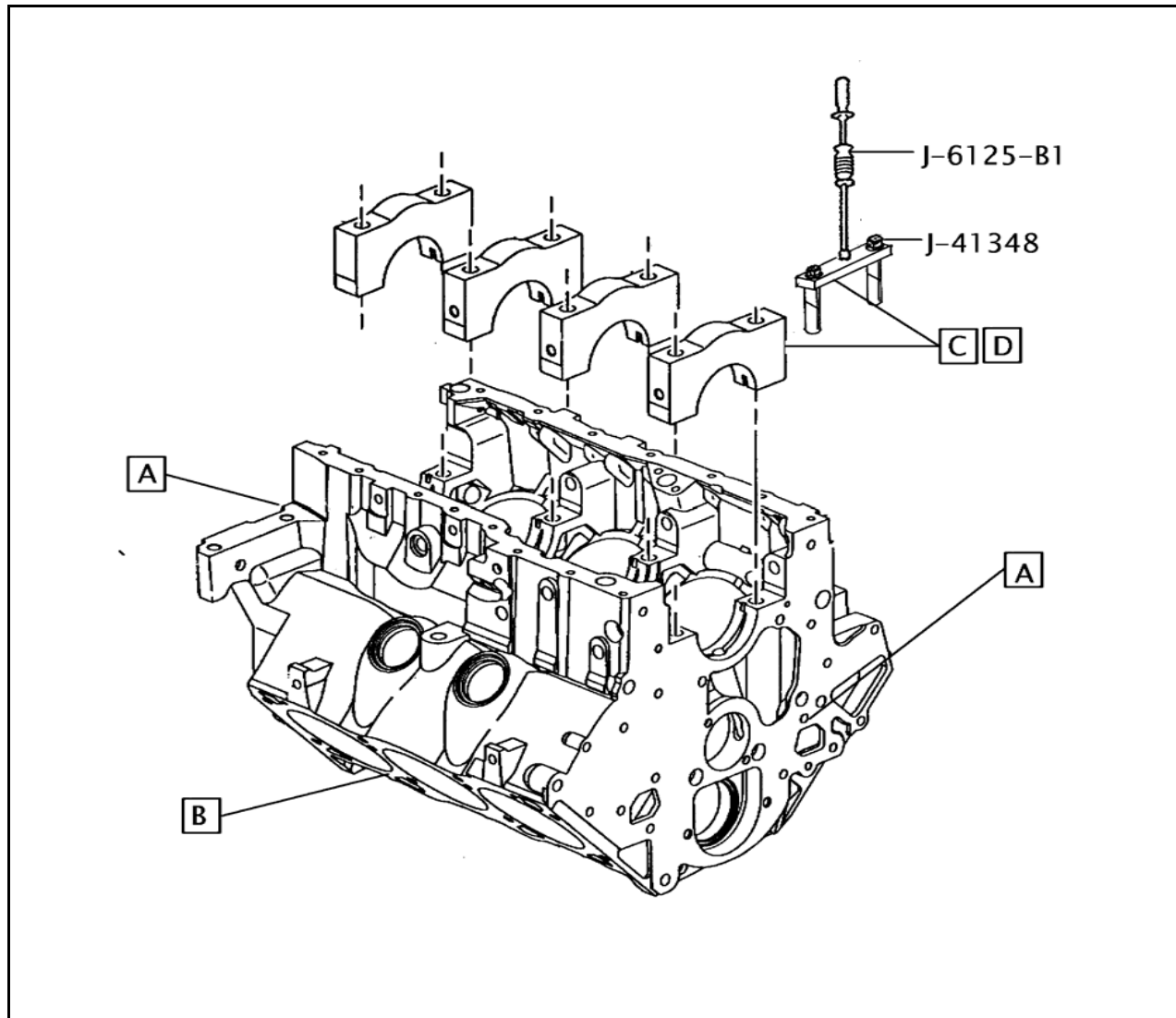






## **Section 3**

### **Short Block Assembly**



Description of Operation	
A	Remove all block off plates
B	Remove torque plates
C	Remove main cap side & main bolts.
D	Use Kent-Moore J-41348 main bearing cap puller & J-6125-1B slide hammer to remove main caps.
<p>Note: Main bearing caps are press fit. Do not hammer caps back and forth during removal. Damage to the caps may result in damage to engine bearings during test.</p>	

Specification

REV	Date	Revision History
1	01/01/98	Block-8

View	
Short Block	
Block off plate, torque plate and main cap removal	

Short Block Assembly	Sequence III G
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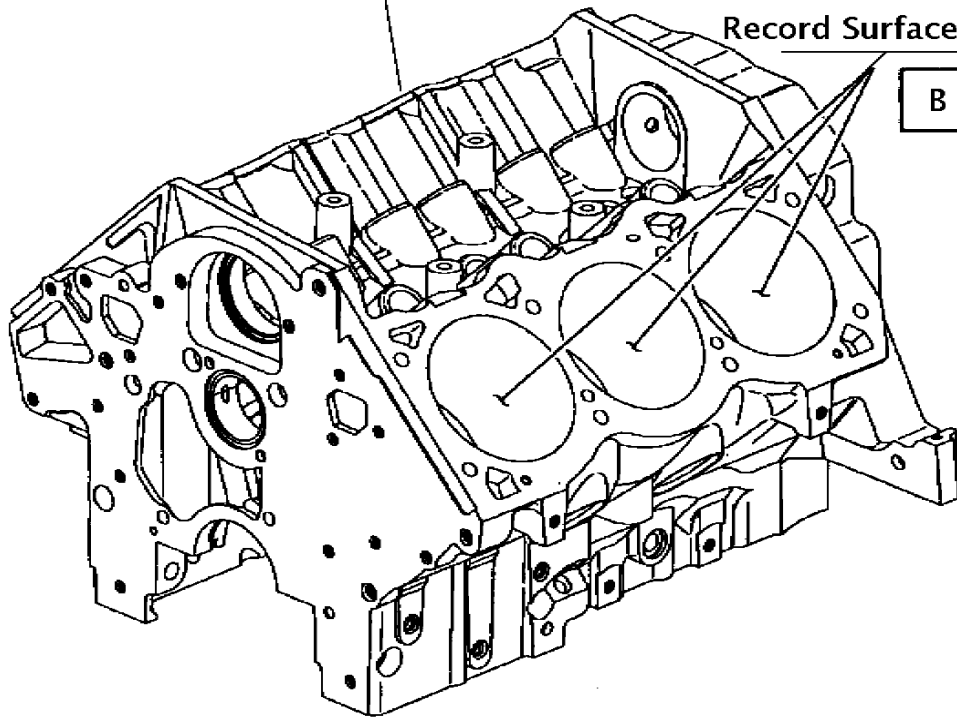
Section	Sheet
3	1

Check engine block for cleanliness

A

Record Surface Finish

B



**Description of Operation**

- A Check engine block, camshaft tunnel, lifter bores, oil galleries, gasket surfaces, and cylinder bores for cleanliness.
- B Check and record cylinder bore surface finish Ra and confirm bore diameters / run number.

**Specification**

**View**

Engine block cleanliness inspection and cylinder surface finish/size recording

**Section**

**Sheet**

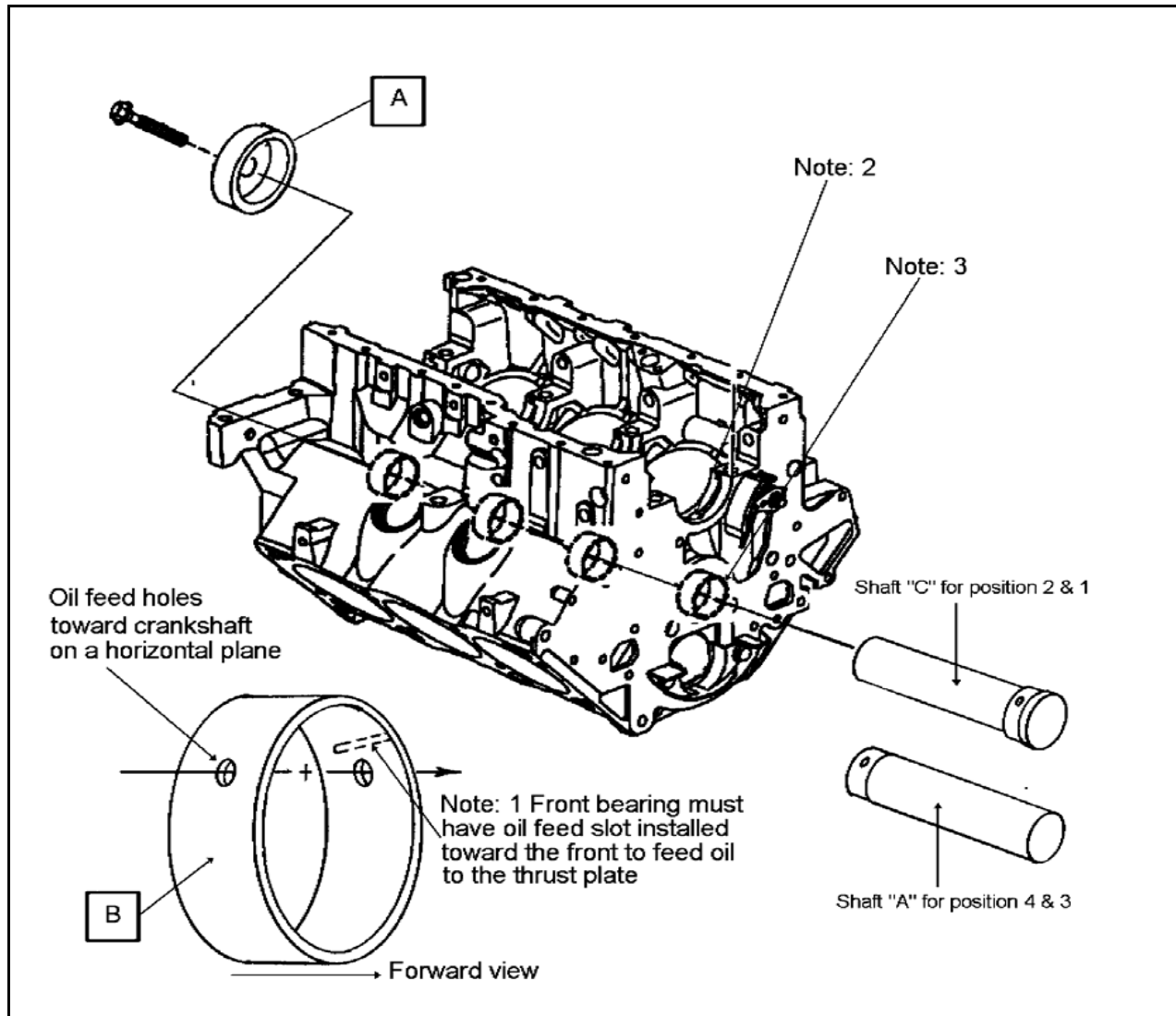
3

2

REV	Date	Revision History
1	01/02/98	Block-9

**Short Block Assembly**

**Sequence III G**



**Description of Operation**

A Install camshaft bearings using OHT3F-019-1 camshaft bearing installation tool. Sections:  
A for #4 rear & #3 intermediate  
C for #2 intermediate and #1 front

B Lubricate bearing bore and bearing OD. with EF-411. Install bearings with the oil feed holes positioned toward the crankshaft on a horizontal plane. See view "B" and Note: 1

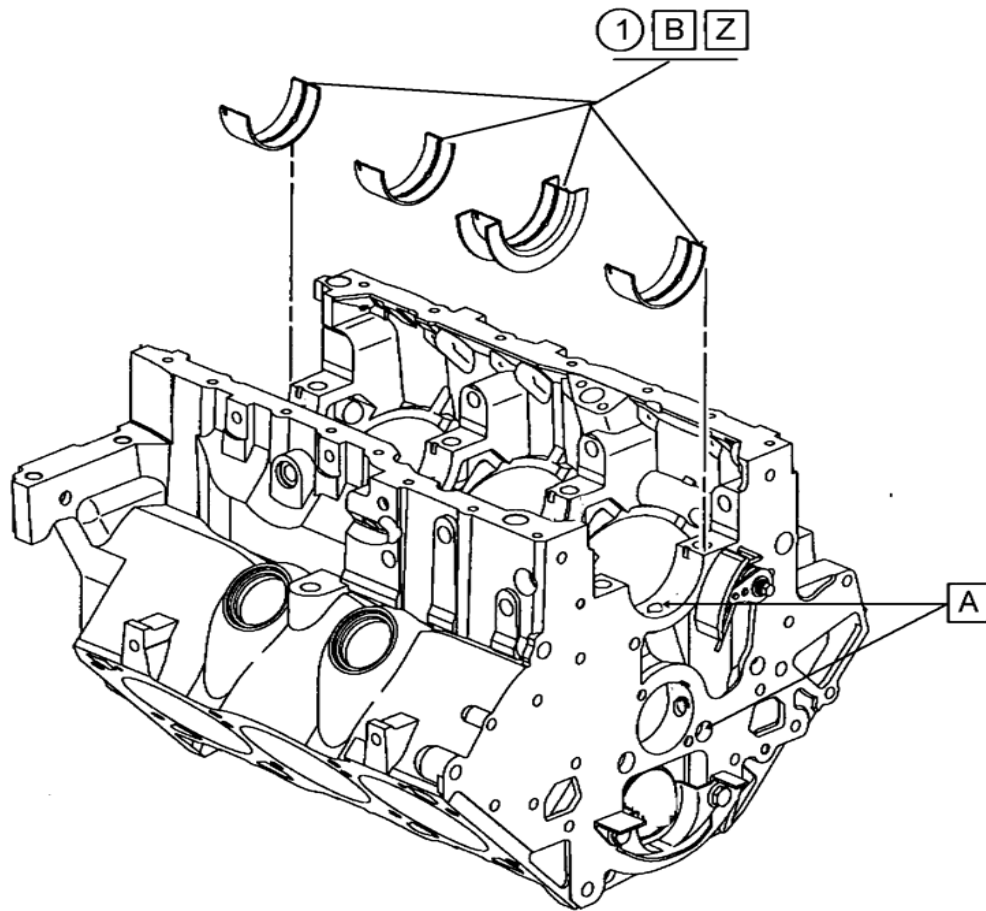
**Specification**

1 Bearing camshaft #1 & #4  
OHT3F-028-09

2 Bearing camshaft #2 & #3  
OHT3F-028-10  
Both bearings are included in  
OHT3F-042-2

REV	Date	Revision History
1	01/02/98	Block-10

View	
<b>Short Block</b>	
Camshaft bearing positioning and installation	



**Description of Operation**

- A Using compressed air, blow through each oil gallery feed from the main bearing support through the camshaft bearings to dislodge any babbit material that might have come off the camshaft bearings during installation. Use an inspection light to ensure proper alignment of the camshaft bearings and that all debris has been removed from the main and lifter oil galleries.
- B Check the upper main bearing bores for cleanliness and install the upper main bearings in the engine block.
- Z Lubricate with EF-411

**Specification**

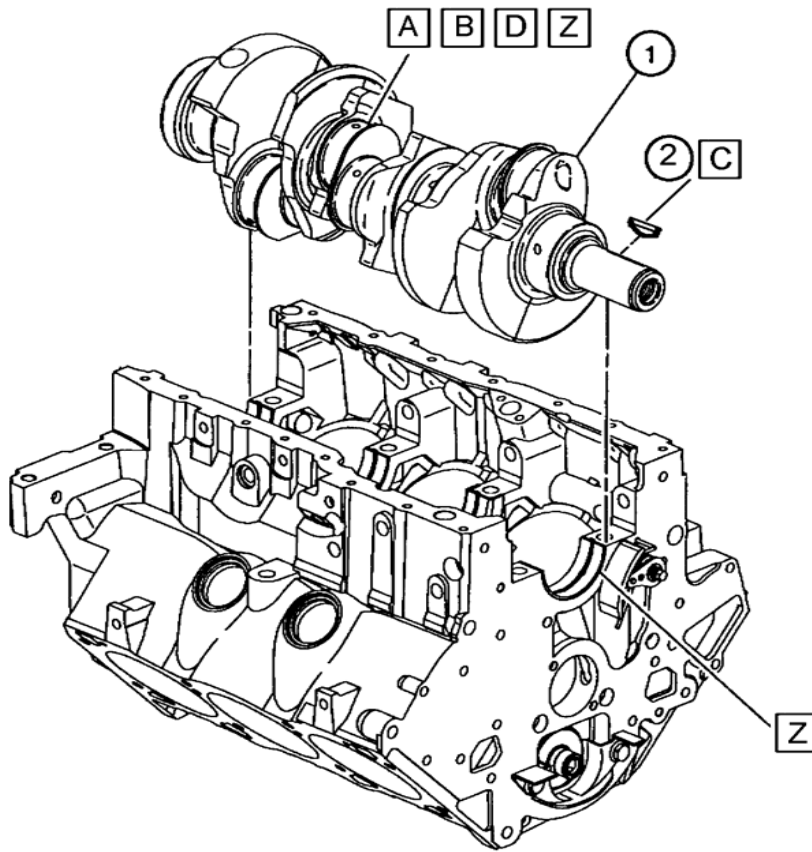
- 1 OHT3F-042-2  
OH-101 (1,3,4, Upper)  
OH-102 (1,3, Lower)  
OH-103 (4 Lower)  
OH-104 (2 Lower)  
OH-105 (2 Upper)

REV	Date	Revision History
1	01/03/98	Block-11

View
<b>Short Block</b>
Upper main bearing inspection and installation

<b>Short Block Assembly</b>	<b>Sequence III G</b>
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Section	Sheet
3	4



**Description of Operation**

- A Clean the crankshaft using an approved commercial cleaning agent followed by aliphatic naphtha and Mylar strip polishing cloth (use Mylar polishing cloth only if journals are nicked or oxidized, Do Not use to remove varnish). The final step should be aliphatic naphtha and nylon bristle brushing of the oil galleries. Spray crankshaft with 50/50 solution and blow excess with compressed air.
- B Check journal diameters.  
Mains 63.470 - 63.495mm  
Rods 57.1170 - 57.1475mm
- C Install key
- D Install crankshaft in engine block using care to not move the upper main bearings.
- Z Lubricate with EF-411

**Specification**

- 1 24502168 Crankshaft
- 2 25534912 Key

**View**

**Short Block**

Crankshaft cleaning, inspection, and installatio

**Section**

3

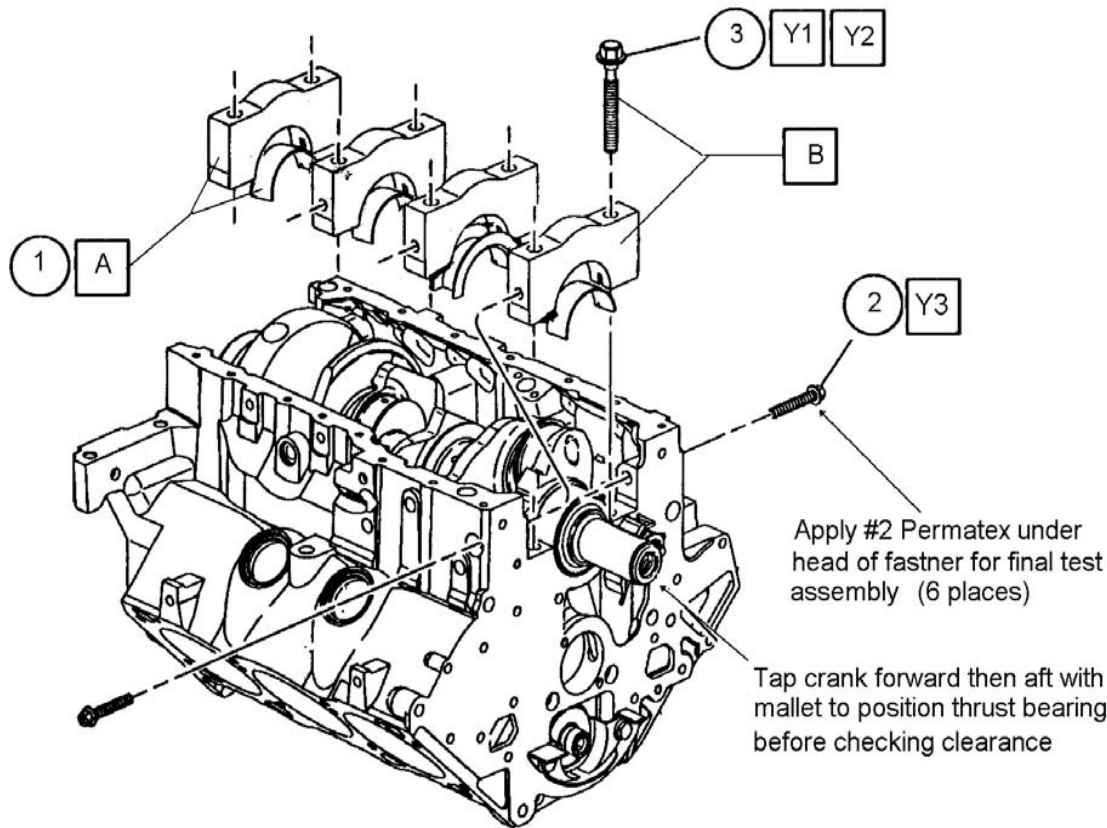
**Sheet**

5

REV	Date	Revision History
1	01/03/98	Block-12

**Short Block Assembly**

**Sequence III G**



Description of Operation	
A	Install lower main bearings into main caps. Clean and oil all main cap bolts (EF-411) and install main caps. Note: Do not use air tools to run main caps down.
B	Install main cap with fasteners as guides and tap into position with plastic mallet or use very light pressure by hand with speed handle and socket in crisscross pattern to draw the main cap down.
C	Install main cap side bolts
Y1	Tighten all main bolts to 70 Nm to fully seat main caps and then loosen the bolts 360° counterclockwise. Check crankshaft end play 0.076 - 0.276mm
Y2	Torque & Angle 20Nm then 40Nm + 35°+35°+35° (repeat 3 times from center out)
Y3	Torque & Angle 15Nm + 45° (See note on sealer usage)

Specification	
1	OHT3F-042-2 Bearing kit
2	24505576 Bolt side (6) See note on sealer usage
3	24503056 Bolt main cap (8)

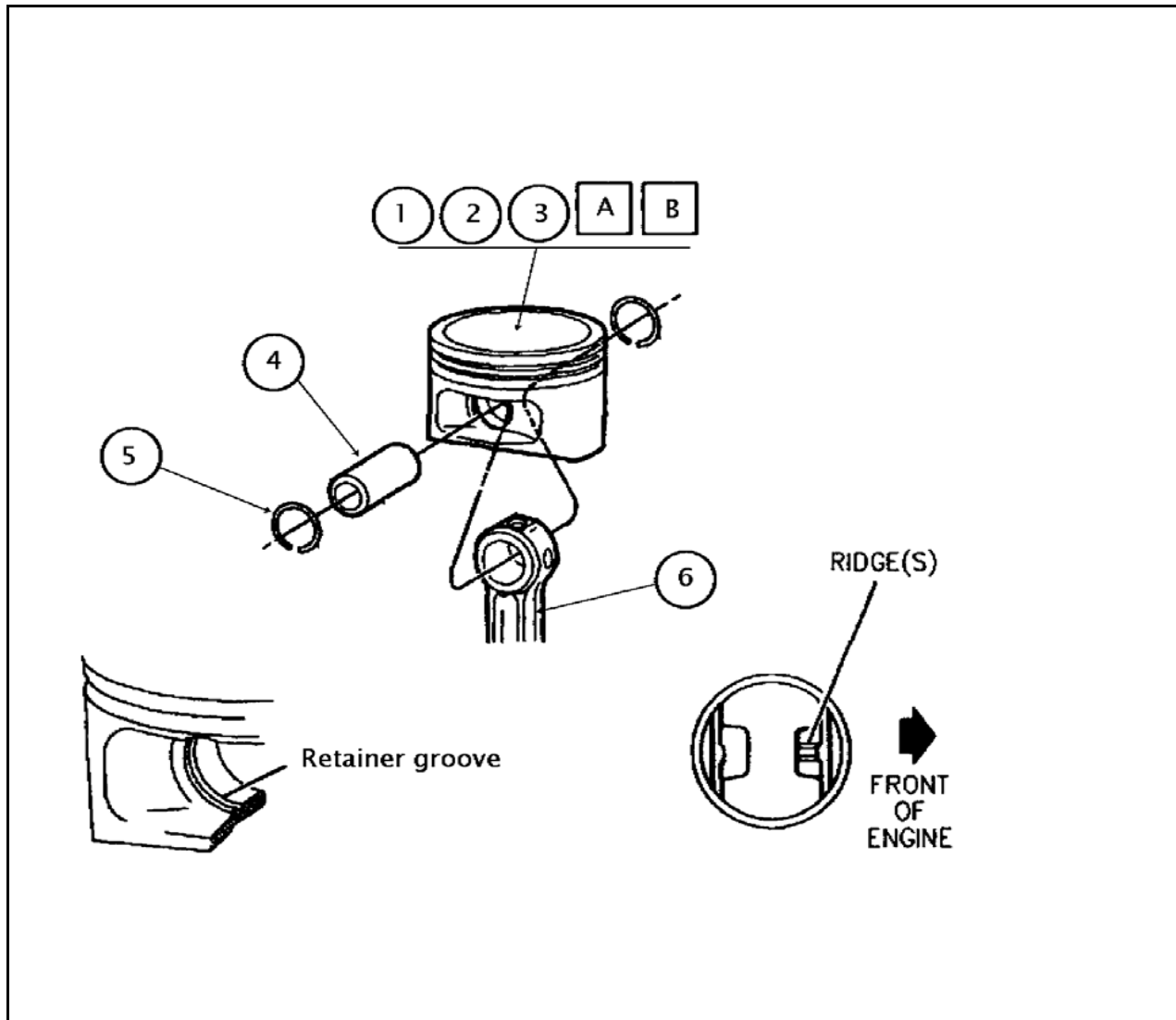
REV	Date	Revision History
1	01/10/98	Block-13

View	
<b>Short Block</b>	
Lower main bearing and crankshaft final test installation	

<b>Short Block Assembly</b>	<b>Sequence III G</b>
-----------------------------	-----------------------

Section	Sheet
3	6





**Description of Operation**

A Confirm run number and proper grade piston selections.

B Lubricate piston pin and connecting rod with EF-411. Install one piston pin retainer clip into the retaining groove. Install the con rod with the dimple to the rear and piston pin. Install the second retainer clip. Make sure both retainer clips are properly seated in their grooves.

**Specification**

1	OHT3F-053-1	Grade 12 test piston set
2	OHT3F-054-1	Grade 34 test piston set
3	OHT3F-055-1	Grade 56 test piston set
4	OHT3F-014-1	Piston pin set
5	OHT3F-012-1	Retainer clip set
6	24501696	Connecting rod

REV	Date	Revision History
1	01/03/98	Block-14

**View**

**Piston, Pin and Connecting Rod**

Piston pin and Connecting Rod assembly

**Short Block Assembly**

**Sequence III G**

<b>Section</b>	<b>Sheet</b>
3	7

**Hard Metric Piston & Ring Sizes**

Grade/Run	Bore Size	Gage	+/-0.0254mm		Piston Size
			Target Ring Gap		
12/1st	96.52	96.53	Top 0.64	2nd 1.070	96.482 - 96.497
12/2nd	96.54	96.53	Top 0.64	2nd 1.070	96.482 - 96.497
34/3rd	96.56	96.57	Top 0.64	2nd 1.070	96.522 - 96.537
34/4th	96.58	96.57	Top 0.64	2nd 1.070	96.522 - 96.537
56/5th	96.60	96.61	Top 0.64	2nd 1.070	96.562 - 96.577
56/6th	96.62	96.61	Top 0.64	2nd 1.070	96.562 - 96.577

All gaps to be +/- 0.0254mm,

As measured in Ring Gage using Starrett Taper Gage # 270

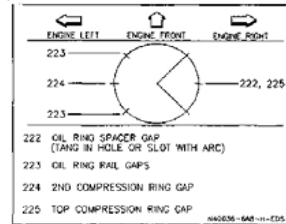
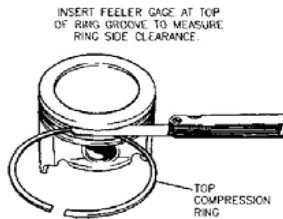


Figure 64 - Piston Ring Gap Location

RUN	OHT PART NUMBER	DESCRIPTION	COLOR	STRIPE(S)
1	3G050-TOP 1	TOP RING	PINK	ONE (1)
	3G050-SECOND 1	SECOND RING	YELLOW	ONE (1)
2	3G050-TOP 2	TOP RING	PINK	TWO (2)
	3G050-SECOND 2	SECOND RING	YELLOW	TWO (2)
3	3G051-TOP 3	TOP RING	PINK	THREE (3)
	3G051-SECOND 3	SECOND RING	YELLOW	THREE (3)
4	3G051-TOP 4	TOP RING	BROWN	ONE (1)
	3G051-SECOND 4	SECOND RING	GREEN	ONE (1)
5	3G052-TOP 5	TOP RING	BROWN	TWO (2)
	3G052-SECOND 5	SECOND RING	GREEN	TWO (2)
6	3G052-TOP 6	TOP RING	BROWN	THREE (3)
	3G052-SECOND 6	SECOND RING	GREEN	THREE (3)

NOTE: PAINT IDENTIFICATION MUST BE REMOVED FROM RING PRIOR TO GAP MEASUREMENT

**Description of Operation**

Confirm correct ring grade and gaps for the engine run / piston grade. No piston ring gap adjustments are allowed.

Check for proper ring side clearance.  
Top & 2nd. 0.033 - 0.079mm  
Oil control 0.023 - 0.201mm

Position rings on piston according to ring stagger chart.

Lubricate assembly with EF-411

To check ring gap, use OHT3F - 050, 051, and 052 Ring Gage with Starrett Taper Gage #270

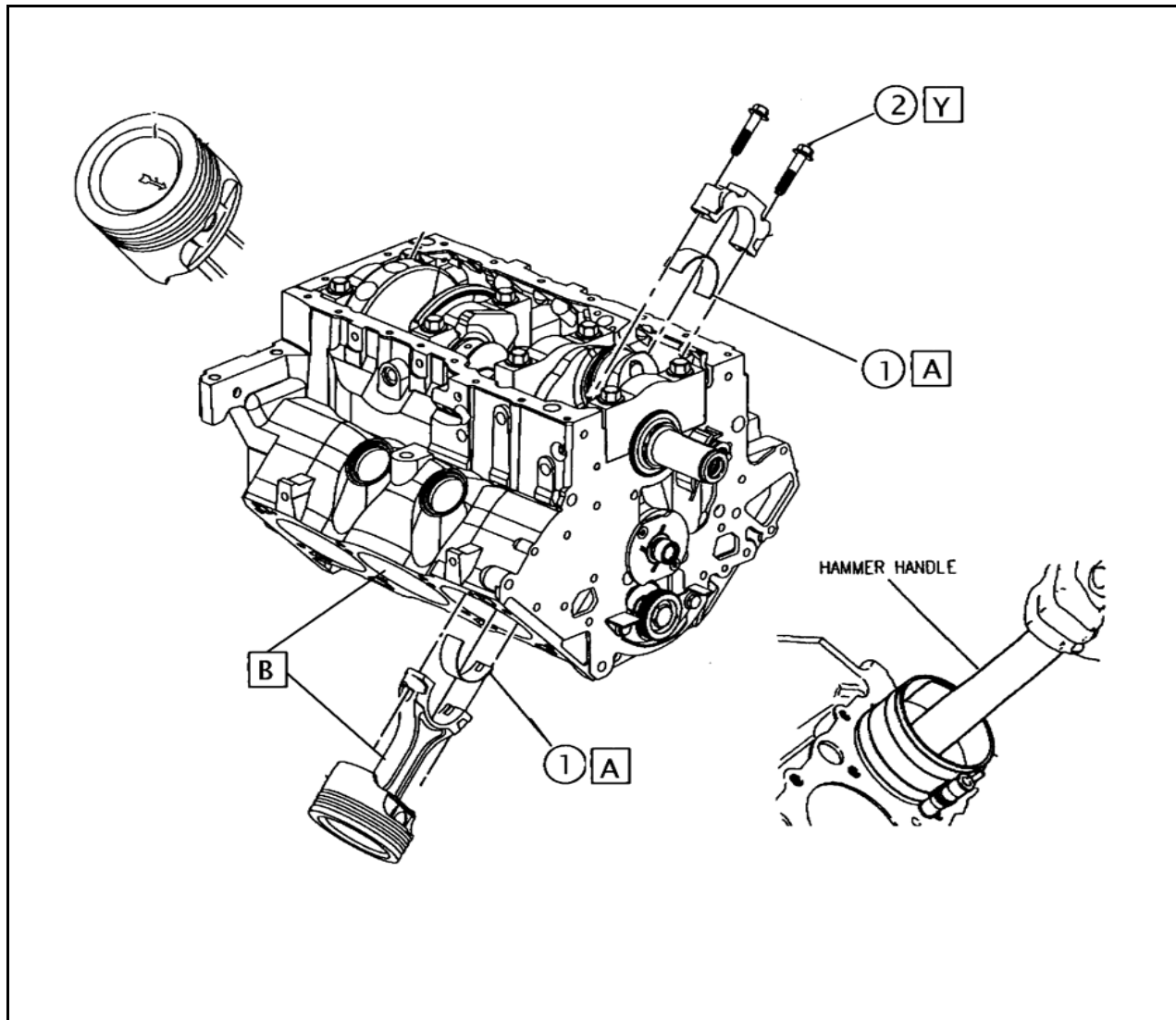
**Specification**

- 1 OHT3G-050 run 1
- 2 OHT3G-050 run 2
- 3 OHT3G-051 run 3
- 4 OHT3G-051 run 4
- 5 OHT3G-052 run 5
- 6 OHT3G-052 run 6

REV	Date	Revision History
1	06/18/02	IIIIG Block-15
2	04/28/03	Update color coding
3	09/10/03	Correct top ring gap typo from 0.064 to 0.64mm

<b>Short Block Assembly</b>	<b>Sequence IIIIG</b>
-----------------------------	-----------------------

View	
<b>Piston Ring</b>	
Piston ring installation and clearance	
<b>Section</b>	<b>Sheet</b>
3	8



Description of Operation	
A	Install connecting rod bearings and lubricate assembly with EF-411.
B	Clean cylinder bores and lubricate with EF-411. Install piston assembly using suitable piston ring compressor and soft ended installation tool.
Y	Torque & Angle 27Nm + 50°
C	Check connecting rod side clearance 0.102 - 0.508mm

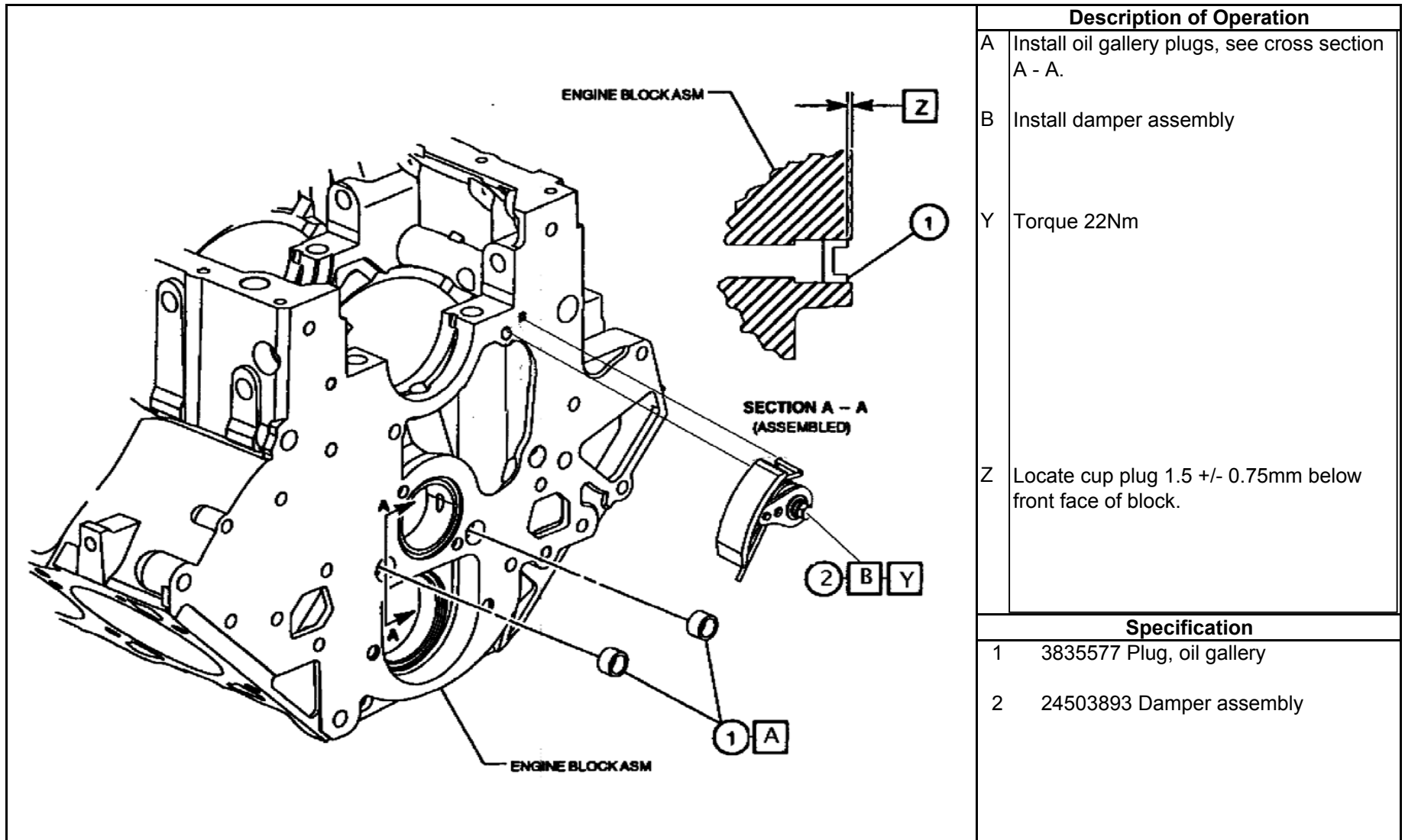
Specification	
1	OHT3F-042-2 Con rod bearing OH-106
2	25531956 Bolt con rod

REV	Date	Revision History
1	1/3/98	Block-16

View	
Short Block	
Piston and rod assembly installation	

Short Block Assembly	Sequence III G
----------------------	----------------

Section	Sheet
3	9



Description of Operation	
A	Install oil gallery plugs, see cross section A - A.
B	Install damper assembly
Y	Torque 22Nm
Z	Locate cup plug 1.5 +/- 0.75mm below front face of block.

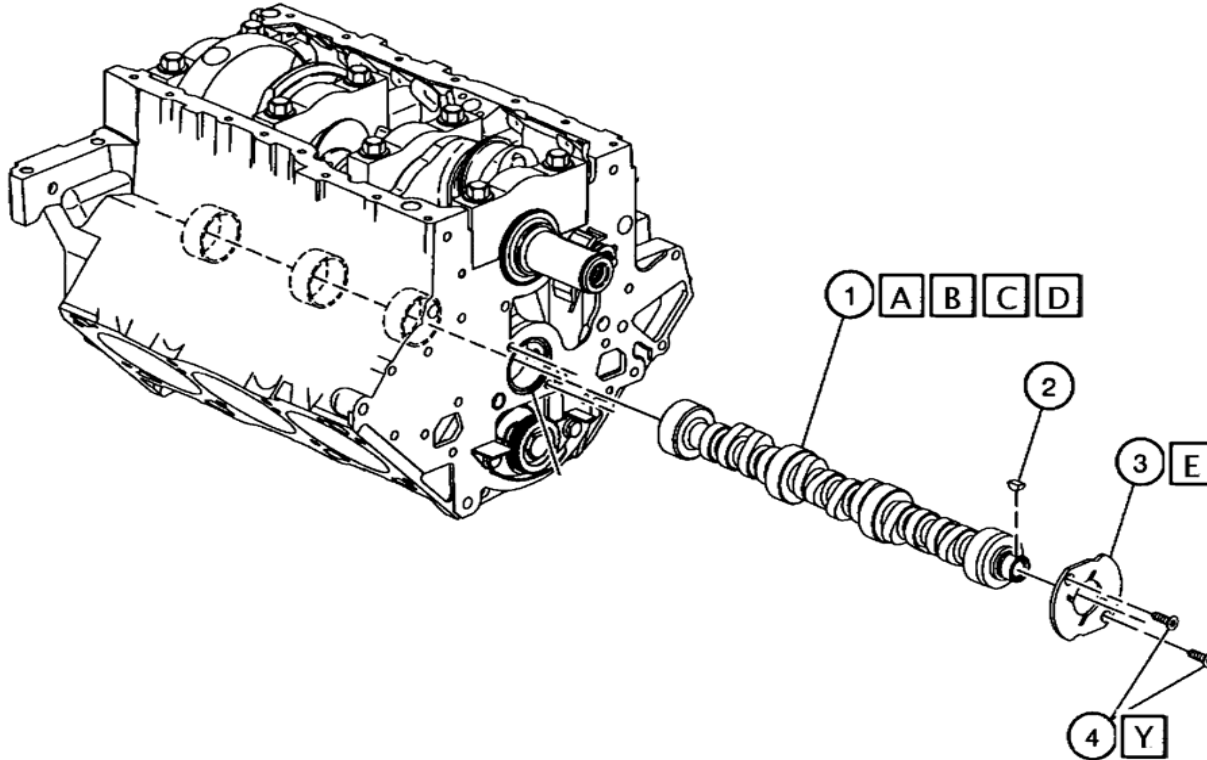
Specification	
1	3835577 Plug, oil gallery
2	24503893 Damper assembly

REV	Date	Revision History
1	1/3/98	Block-17

View	
<b>Short Block</b>	
Oil gallery plugs and timing chain damper	

<b>Short Block Assembly</b>	<b>Sequence III G</b>
-----------------------------	-----------------------

Section	Sheet
3	10



**Description of Operation**

- A Check and de-burr if necessary, the front thrust surface of the camshaft.
- B Clean camshaft with aliphatic naphtha and very clean shop towel. Note: make sure all grinding residue is removed before continuing.
- C Make pre-test measurements at the rear side of each lobe and record to the nearest 0.001mm.
- D Lubricate the camshaft journals and lobes with EF-411 and install.
- E Lubricate thrust plate and install
- Y Torque 15Nm

**Specification**

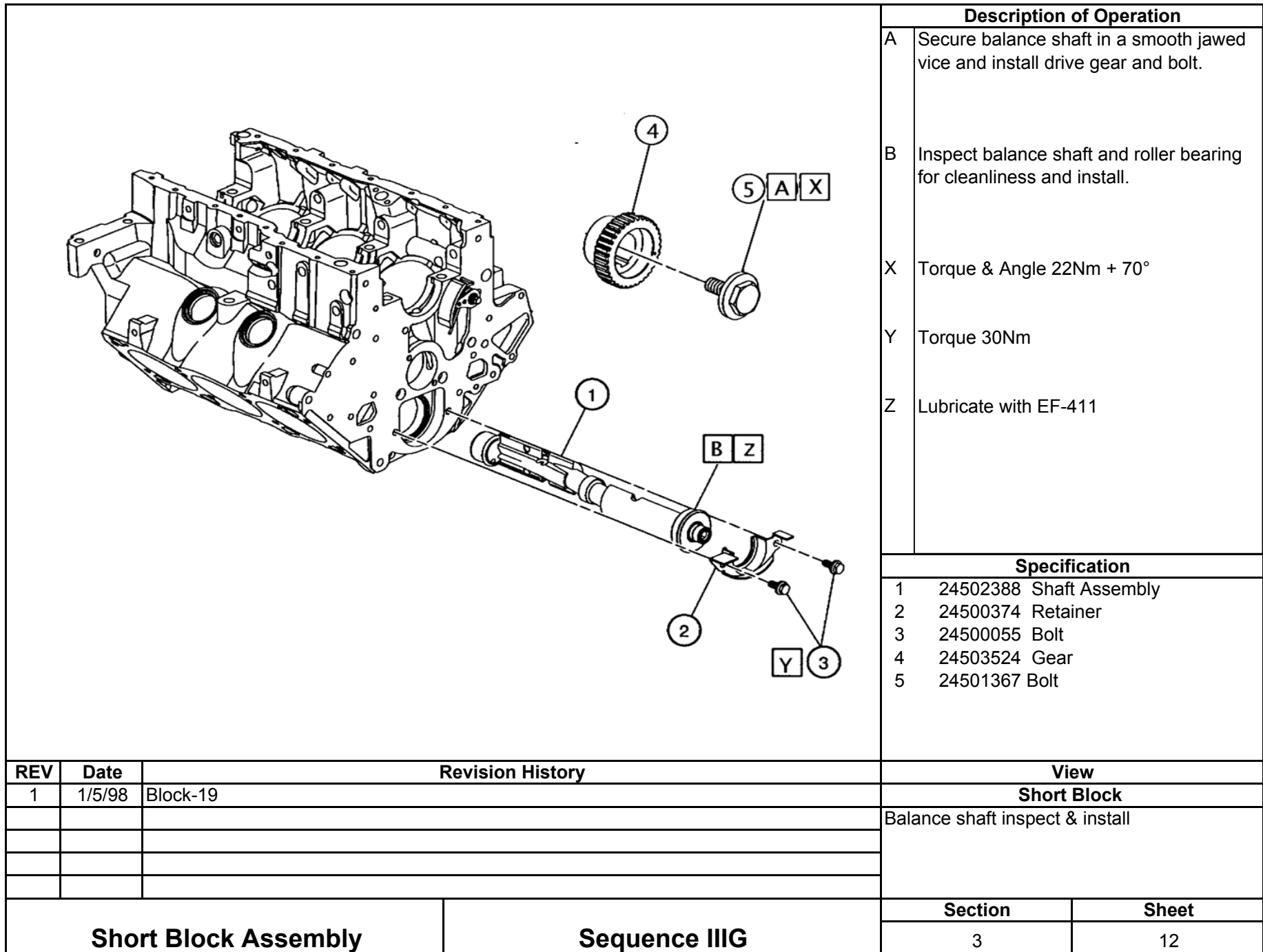
- 1 OHT3F-008-8 Phosphated Camshaft **(For Use in IIIG Testing Only)**
- 2 24500618 Key (Replace each test)
- 3 OHT3F-011-2 Thrust plate (0.152")
- 4 25519242 Bolt/screw

REV	Date	Revision History
1	1/13/98	Block-18

View
<b>Short Block</b>
Camshaft cleaning, measurement, and installation

<b>Short Block Assembly</b>	<b>Sequence IIIG</b>
-----------------------------	----------------------

<b>Section</b>	<b>Sheet</b>
3	11



**Description of Operation**

- A Secure balance shaft in a smooth jawed vice and install drive gear and bolt.
- B Inspect balance shaft and roller bearing for cleanliness and install.
- X Torque & Angle 22Nm + 70°
- Y Torque 30Nm
- Z Lubricate with EF-411

**Specification**

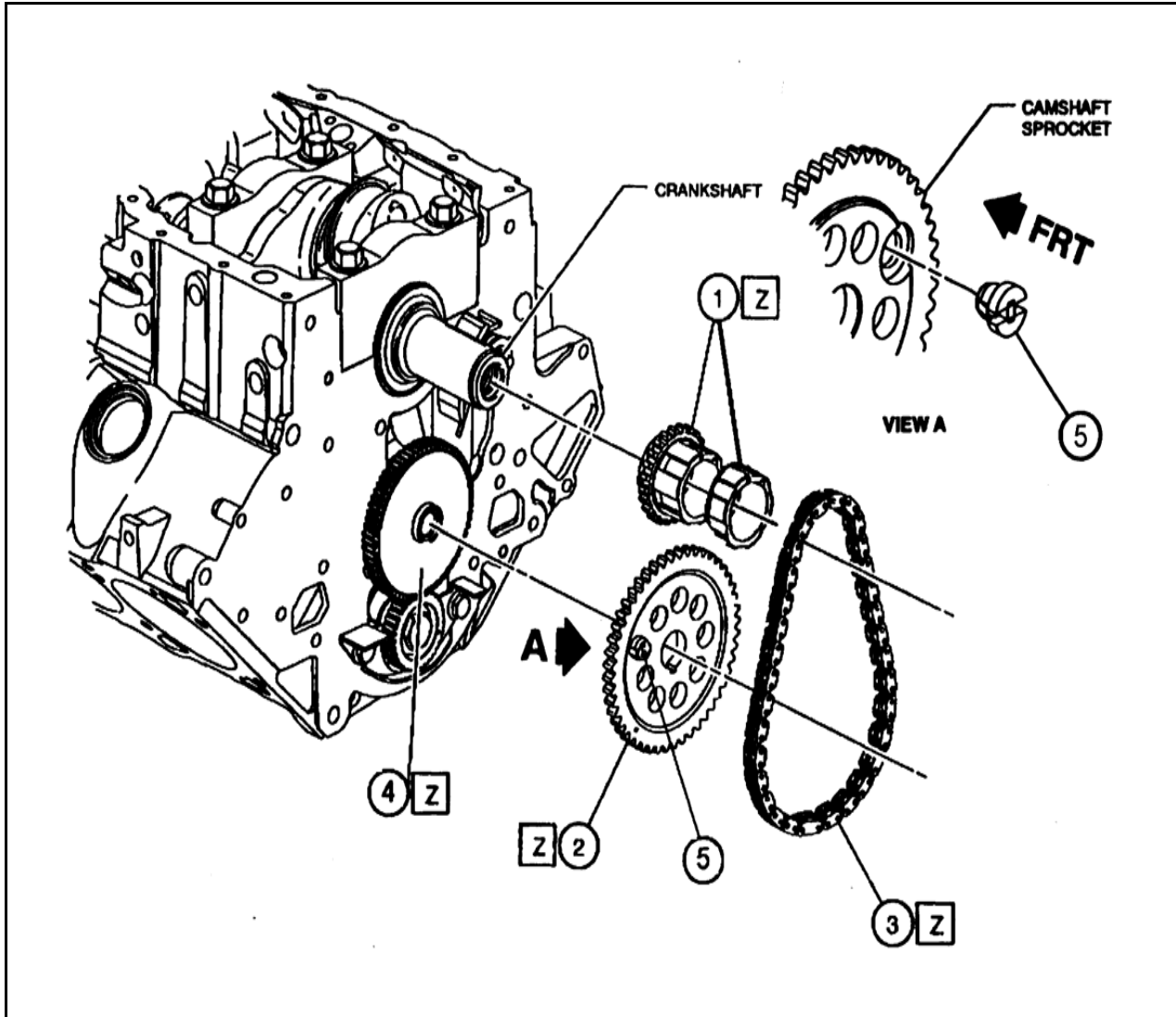
1	24502388	Shaft Assembly
2	24500374	Retainer
3	24500055	Bolt
4	24503524	Gear
5	24501367	Bolt

REV	Date	Revision History
1	1/5/98	Block-19

View
<b>Short Block</b>
Balance shaft inspect & install

<b>Short Block Assembly</b>	<b>Sequence III G</b>

<b>Section</b>	<b>Sheet</b>
3	12



**Description of Operation**

Timing gear set. See part number information.

A Install magnet See view "A"

Z Lubricate with EF-411

Note: Inspect balance shaft and replace as necessary if damage to gear teeth and / or thrust surface is evident.

**Specification**

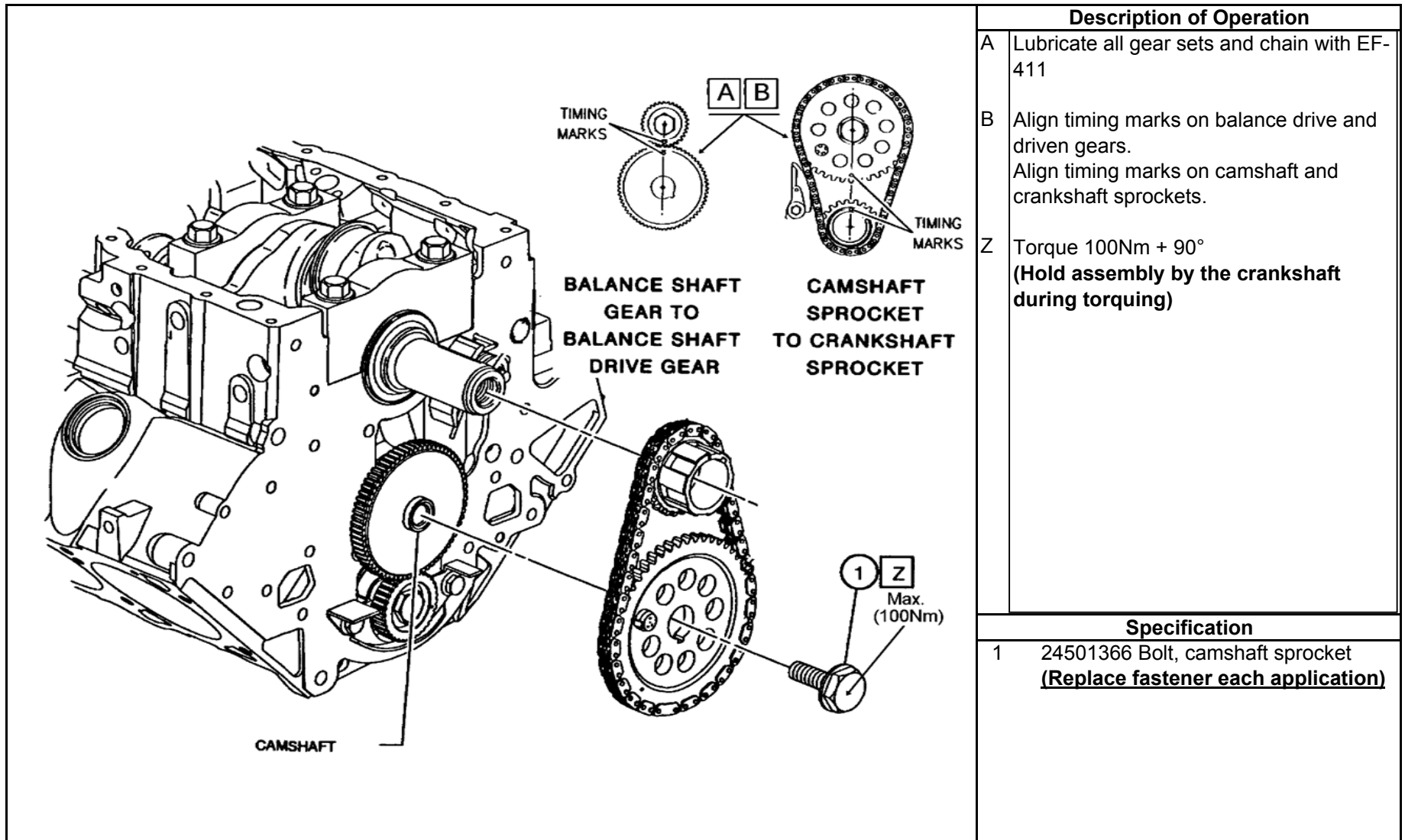
1	OHT3F-036-1 Sprocket, 2pc.
2	24505306 Sprocket, camshaft
3	24504668 Chain
4	24504792 Gear
5	10456195 Magnet

REV	Date	Revision History
1	1/5/98	Block-20

**View**

**Short Block**

Timing gear set



Description of Operation	
A	Lubricate all gear sets and chain with EF-411
B	Align timing marks on balance drive and driven gears. Align timing marks on camshaft and crankshaft sprockets.
Z	Torque 100Nm + 90° <b>(Hold assembly by the crankshaft during torquing)</b>

Specification	
1	24501366 Bolt, camshaft sprocket <b><u>(Replace fastener each application)</u></b>

REV	Date	Revision History
1	1/5/98	Block-21

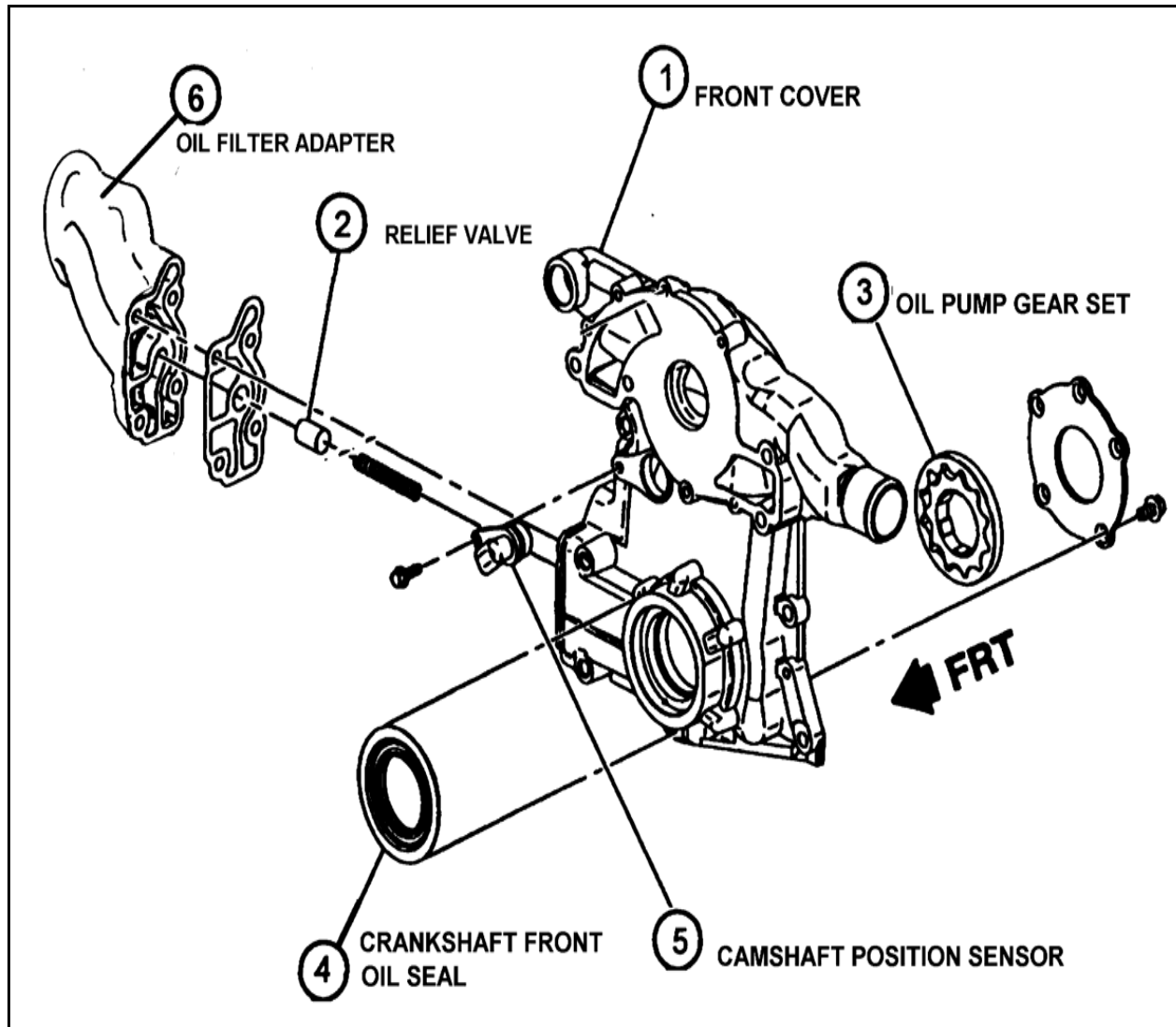
View	
<b>Short Block</b>	
Timing gear set alignment & torque	

<b>Short Block Assembly</b>	<b>Sequence III G</b>	<b>Section</b>	<b>Sheet</b>
		3	14



## **Section 4**

### **Front Cover, Rear Cover, and Sump**



**Description of Operation**

Assembly view

**Specification**

1	OHT3F-085-1 Front Cover
2	25530949 Valve, oil pressure relief
3	24505433 Oil pump gear set
4	24504098 Seal
5	10456148 Camshaft position sensor
6	24501300 Adapter, oil filter

REV	Date	Revision History
1	01/05/98	Block-22
2	04/28/03	Change front cover over to OHT part number

**View**

**Front Cover**

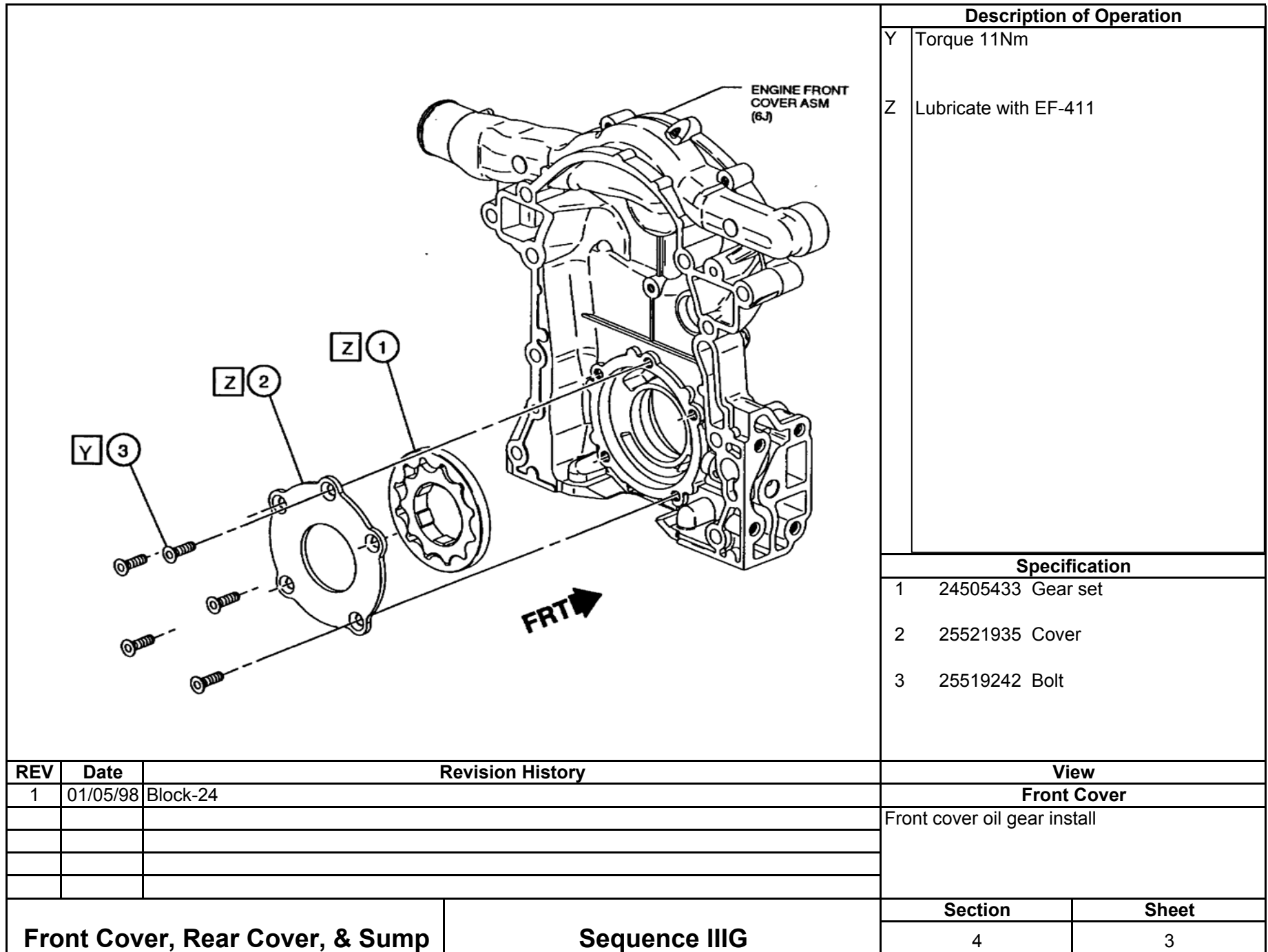
Front cover assembly view

**Front Cover, Rear Cover, & Sump**

**Sequence III G**

<b>Section</b>	<b>Sheet</b>
4	1





Description of Operation	
Y	Torque 11Nm
Z	Lubricate with EF-411

Specification	
1	24505433 Gear set
2	25521935 Cover
3	25519242 Bolt

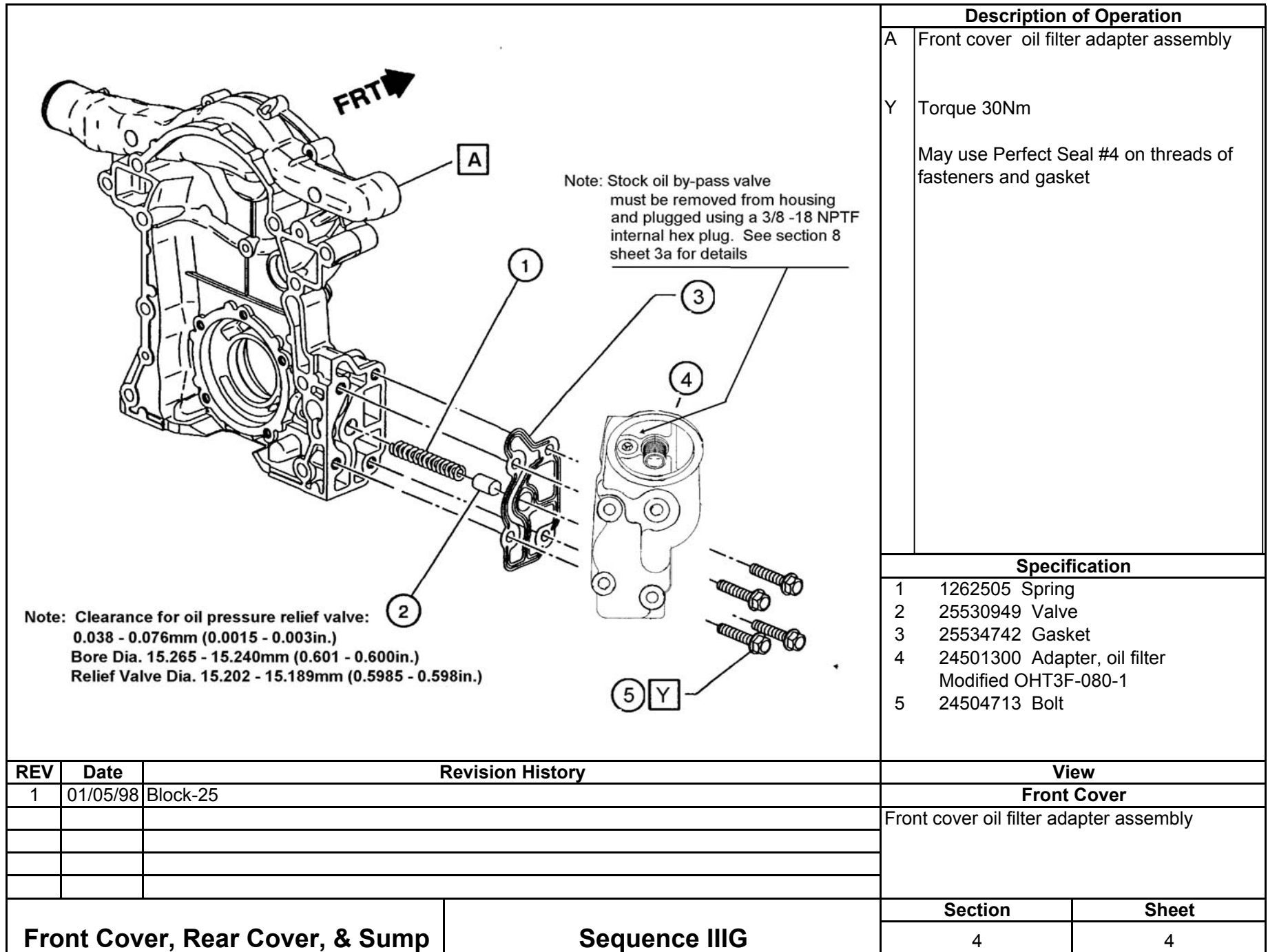
REV	Date	Revision History
1	01/05/98	Block-24

View	
Front Cover	
Front cover oil gear install	

**Front Cover, Rear Cover, & Sump**

**Sequence III G**

Section	Sheet
4	3



**Description of Operation**

A	Front cover oil filter adapter assembly
Y	Torque 30Nm  May use Perfect Seal #4 on threads of fasteners and gasket

**Specification**

1	1262505 Spring
2	25530949 Valve
3	25534742 Gasket
4	24501300 Adapter, oil filter Modified OHT3F-080-1
5	24504713 Bolt

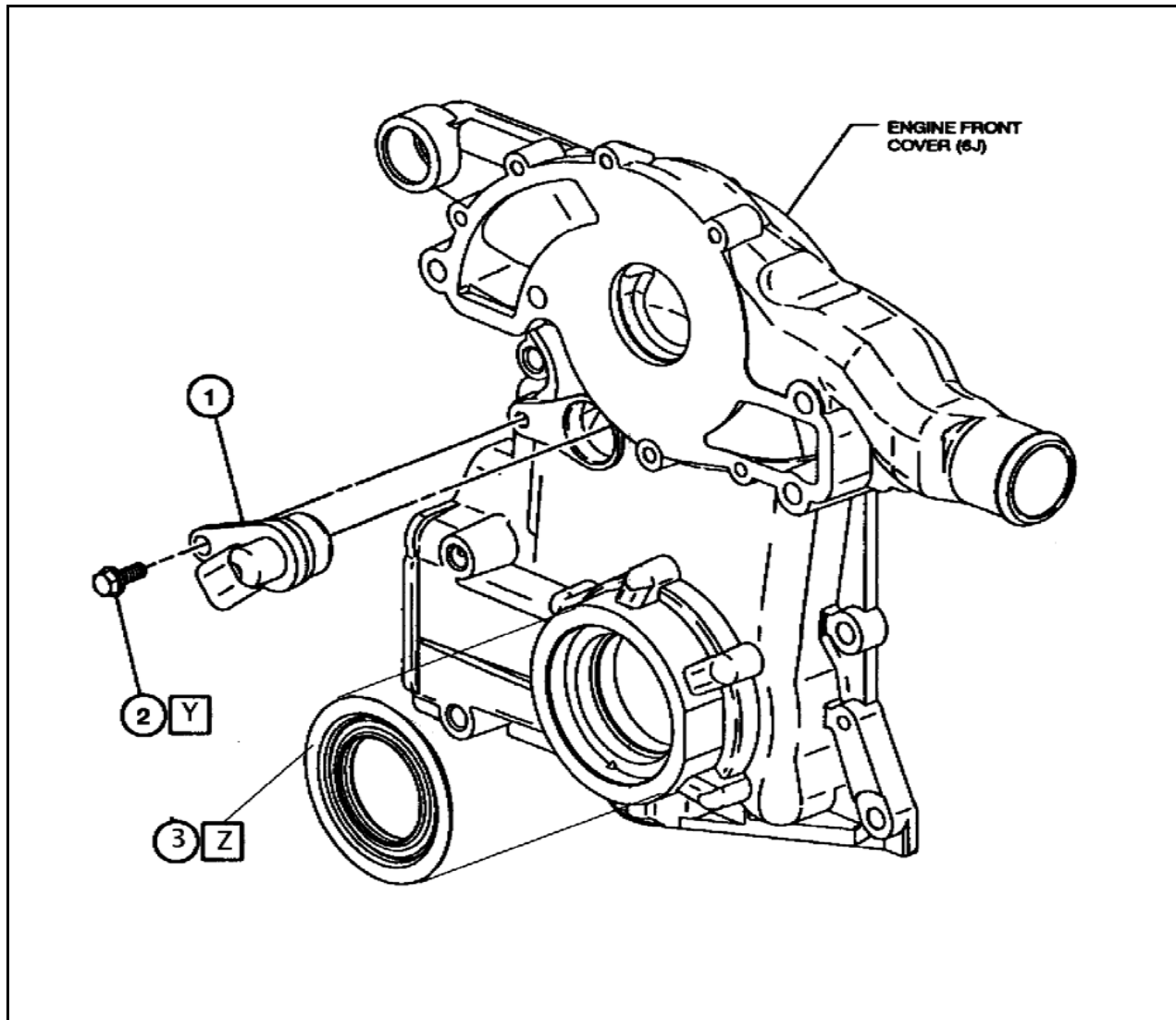
REV	Date	Revision History
1	01/05/98	Block-25

**View**

<b>Front Cover</b>
Front cover oil filter adapter assembly

<b>Front Cover, Rear Cover, &amp; Sump</b>	<b>Sequence III G</b>
--	-----------------------

<b>Section</b>	<b>Sheet</b>
4	4



Description of Operation	
Y	Torque 30Nm
Z	Use a light application of #4 Permatex around the rear side of the seal where it contacts the front cover.

Specification	
1	10456148 Camshaft sensor
2	25526395 Bolt
3	24504098 Seal

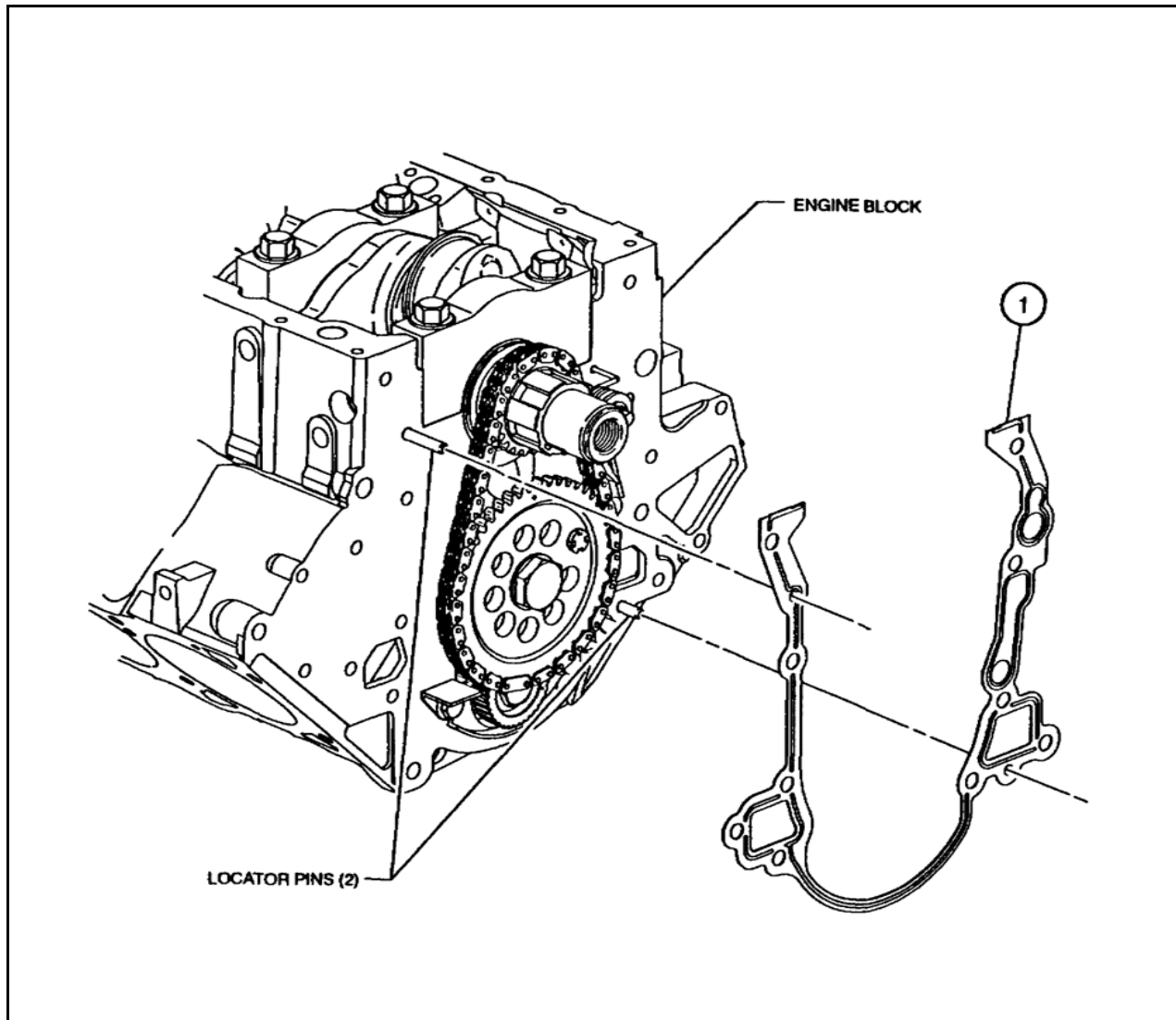
REV	Date	Revision History
1	01/05/98	Block-29

View	
Front Cover	
Front cover camshaft sensor and seal install	

**Front Cover, Rear Cover, & Sump**

**Sequence III G**

Section	Sheet
4	5



**Description of Operation**

Note:  
Perfect seal #4 may be used around coolant passages on gasket.

**Specification**

1 24502252 Gasket

REV	Date	Revision History
1	01/05/98	Block-26

**View**

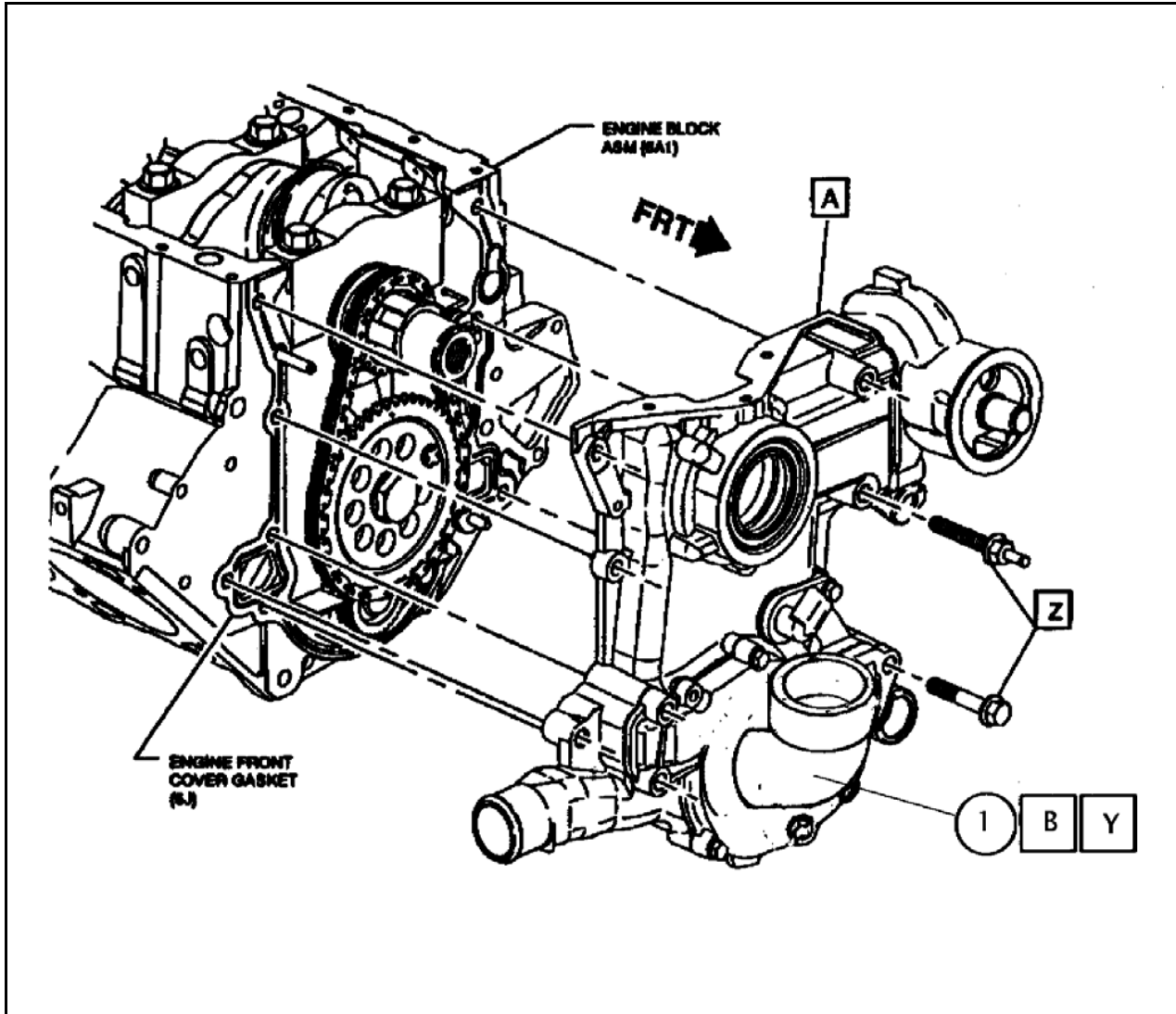
**Front Cover**

Front cover gasket install

**Front Cover, Rear Cover, & Sump**

**Sequence III G**

Section	Sheet
4	6



Description of Operation	
A	Front cover assembly
B	Install coolant inlet adapter with front cover
Y	Torque 30Nm
	Install thermocouple in OHT3F-031 with sensing tip centered in flow.

Specification	
1	OHT3F-031-3 Bolts included on print

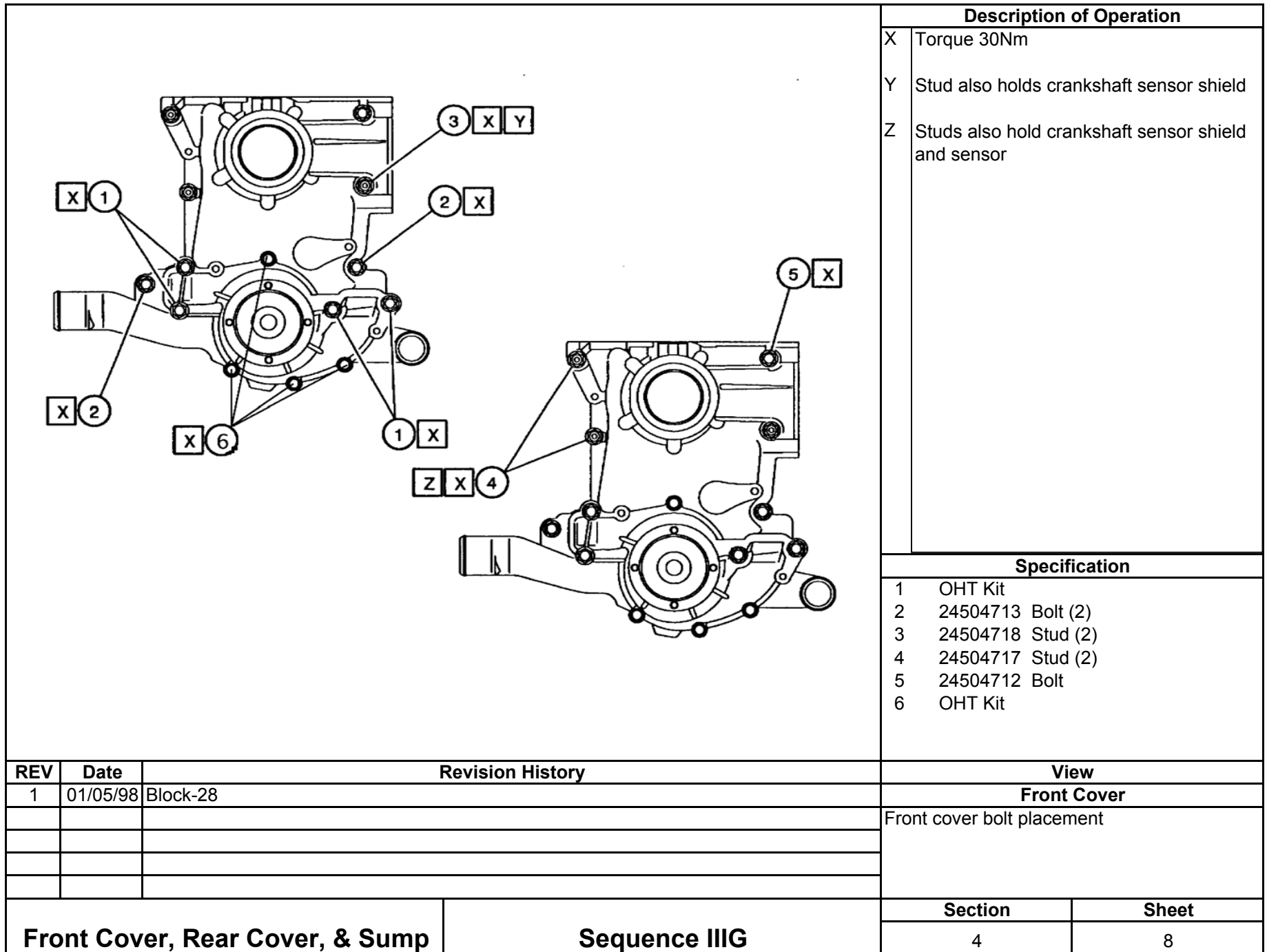
REV	Date	Revision History
1	01/05/98	Block-30
2	12/01/99	Add thermocouple information

View
Front Cover
Front cover install

Front Cover, Rear Cover, & Sump	Sequence III G
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Section	Sheet
4	7





**Description of Operation**

X	Torque 30Nm
Y	Stud also holds crankshaft sensor shield
Z	Studs also hold crankshaft sensor shield and sensor

**Specification**

1	OHT Kit
2	24504713 Bolt (2)
3	24504718 Stud (2)
4	24504717 Stud (2)
5	24504712 Bolt
6	OHT Kit

REV	Date	Revision History
1	01/05/98	Block-28

**View**

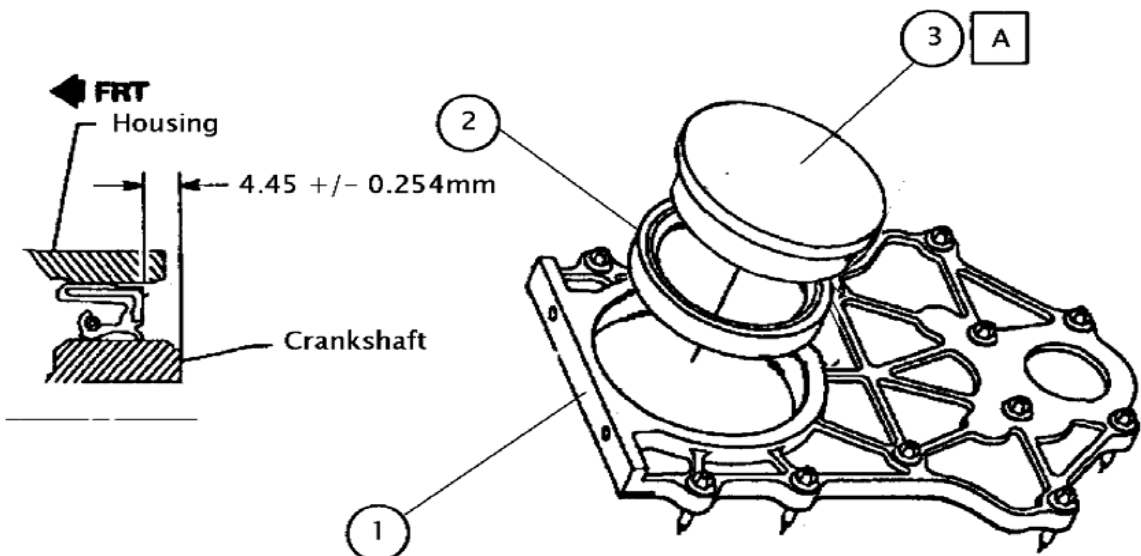
**Front Cover**

Front cover bolt placement

<b>Section</b>	<b>Sheet</b>
4	8

**Front Cover, Rear Cover, & Sump**

**Sequence III G**



**Description of Operation**

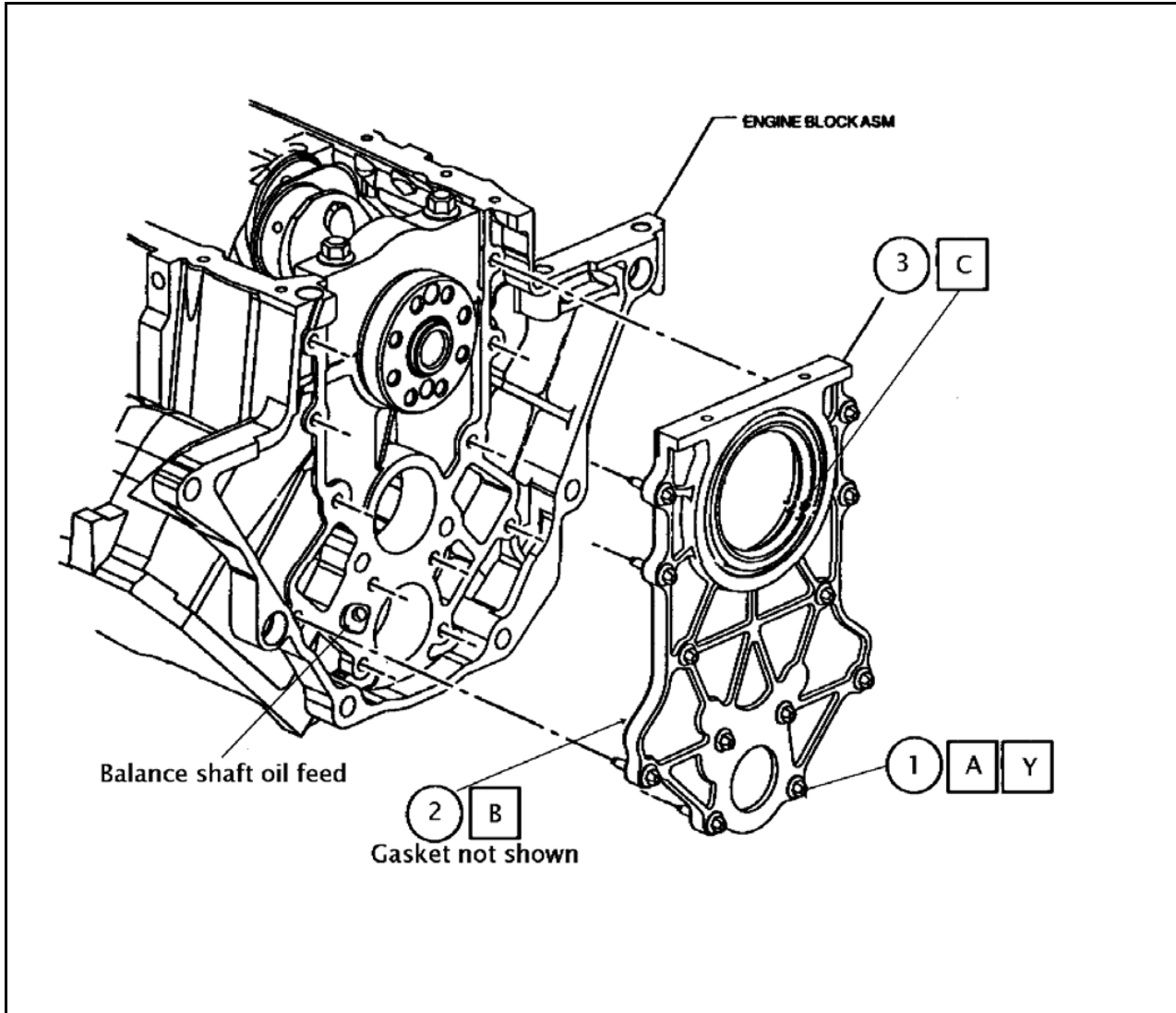
A Install rear main lip seal using GM R&D supplied installation tool and a light duty bench press until seal bottoms in housing.

**Specification**

- 1 24502297 Rear cover housing
- 2 25534760 Seal
- 3 GM R&D Seal Installation Tool

REV	Date	Revision History
1	01/05/98	Block-31

View
<b>Rear Cover</b>
Rear seal installation

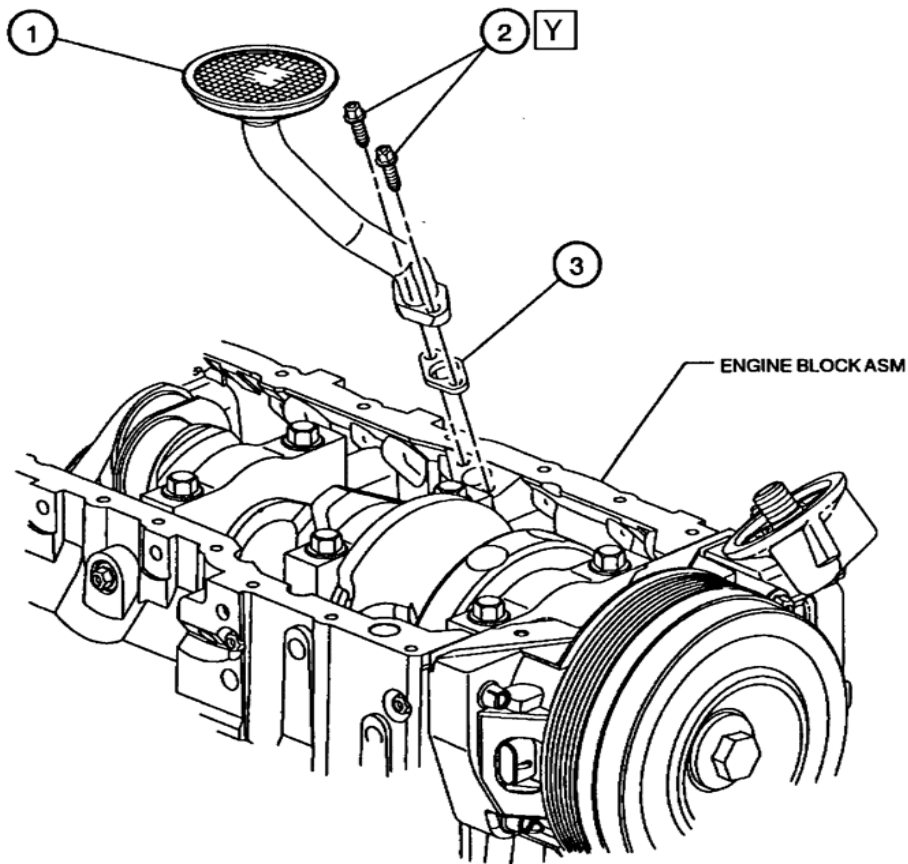


Description of Operation	
A	Install new bolts with nylon positioning collar for each run.
B	Install gasket (not shown in view) <b>Note: Position rear cover plate gasket so that rear balance shaft oil feed is lined up with correct side of cover plate.</b>
C	Lubricate rear lip seal with EF-411 and use extreme care not to damage rear lip seal during rear cover plate installation.
Y	Torque & Angle 15Nm + 50°  Note: Perfect Seal #4 sealer may be used around coolant passages on gasket.

Specification	
1	24503970 Bolt
2	24506644 Gasket
3	24502297 Housing assembly

REV	Date	Revision History
1	01/05/98	Block-32
2	12/01/99	Add Perfect seal note.

View	
<b>Rear Cover</b>	
Rear cover installation	



**Description of Operation**

Install oil screen assembly

Y Torque 15Nm

**Specification**

- 1 24505569 Screen assembly
- 2 24505570 Bolt
- 3 24501259 Gasket

REV	Date	Revision History
1	01/05/98	Block-33

**View  
Sump**

Oil pickup tube

**Section**

**Sheet**

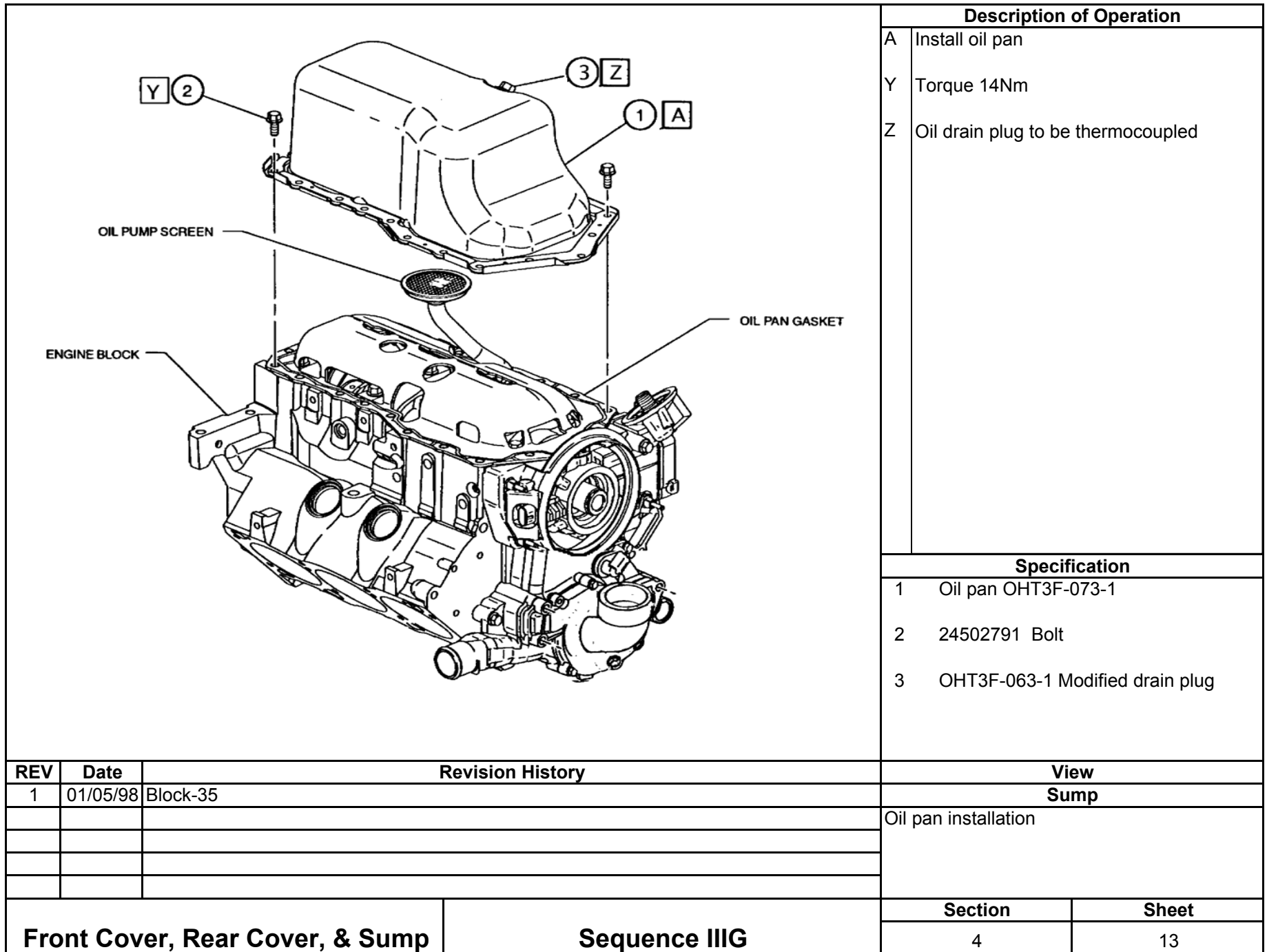
4

11

**Front Cover, Rear Cover, & Sump**

**Sequence III G**





Description of Operation	
A	Install oil pan
Y	Torque 14Nm
Z	Oil drain plug to be thermocoupled

Specification	
1	Oil pan OHT3F-073-1
2	24502791 Bolt
3	OHT3F-063-1 Modified drain plug

REV	Date	Revision History
1	01/05/98	Block-35

View
Sump
Oil pan installation

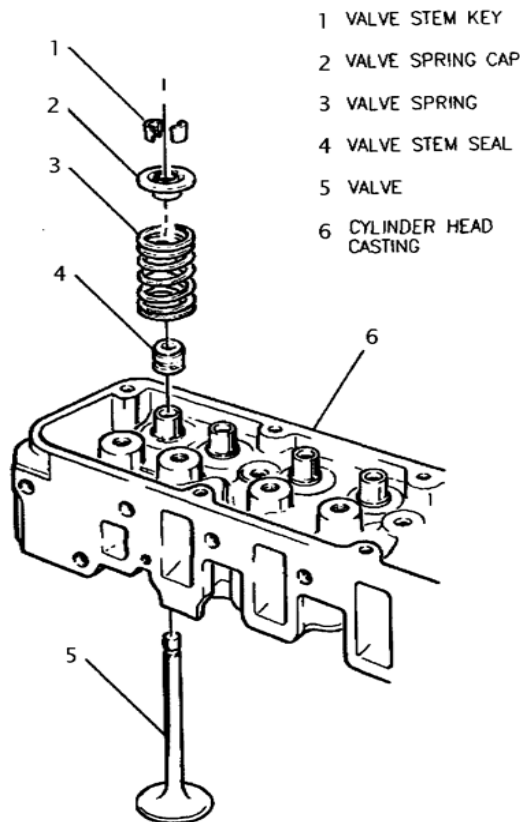
**Front Cover, Rear Cover, & Sump**

**Sequence III G**

Section	Sheet
4	13

## **Section 5**

### **Cylinder Head and Valves**



- 1 VALVE STEM KEY
- 2 VALVE SPRING CAP
- 3 VALVE SPRING
- 4 VALVE STEM SEAL
- 5 VALVE
- 6 CYLINDER HEAD CASTING

During calibration, use OHT3F-070-1 Sleeve to protect seals from being cut and OHT3F-072, 006", 010", 015", & 020" shims to assist in obtaining proper load.

**Description of Operation**

Clean cylinder head with aliphatic naphtha and spray with 50/50 solution of EF-411 and aliphatic naphtha. Remove excess solution using compressed air.

Lubricate valve stems and guides with EF-411 during assembly. Ensure valve stem moves freely in guide before installing valve seal. Use a protective sheath over the valve stem that extends downward past the keeper grooves when installing the valve stem seals.

Install the valve springs, retainers, and keepers.

Calibrate the valve spring load to 912N +/- 44N @ 9.5mm (205lbf +/- 10lbf @ 0.375in.) travel.

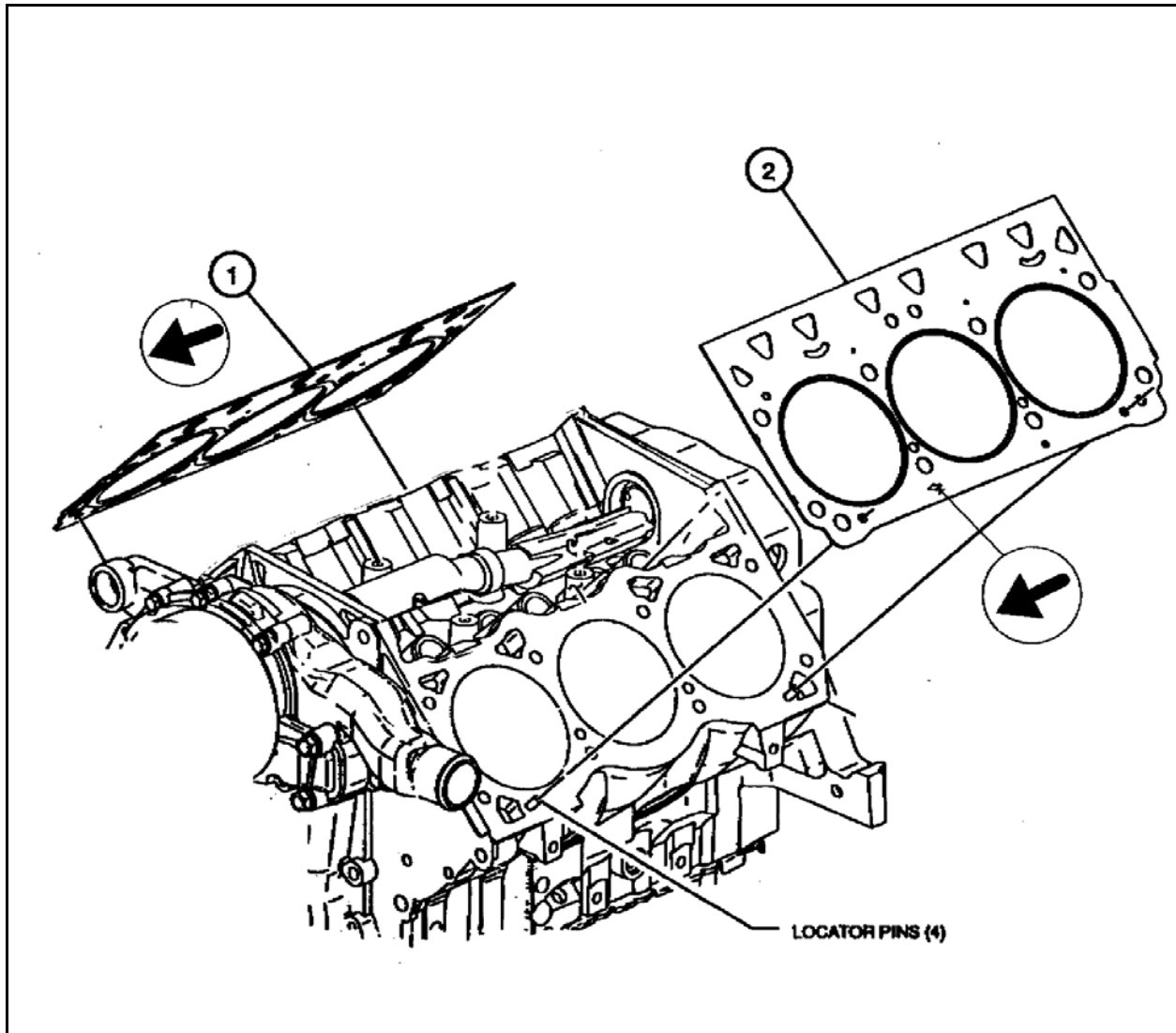
**Specification**

- 1 1016634 Valve stem key
- 2 24502257 Valve spring cap
- 3 OHT3G-059-1 Valve spring (Pink)
- 4 OHT3F-060-1 Seal int.  
OHT3F-061-1 Seal exh. White stripe
- 5 24502254 Valve int.(STD)  
24504195 Valve exh.(STD)
- 6 24502259 Head, GM Raceshop

REV	Date	Revision History
1	01/06/98	Block-36
2	09/10/03	Change calibration +/- from 22N to 44N (5lbf. To 10lbf.)
Head Assembly		Sequence III G

View	
Head Assembly	
Valve & spring assembly	
Section	Sheet
5	1





**Description of Operation**

Head gaskets are not interchangeable. Installing the head gasket with the arrow pointing to the rear will cause gasket failure and possible engine failure.

Install the head gasket with the arrow pointing toward the front of the engine.

Do not use any sealers on the head gaskets.

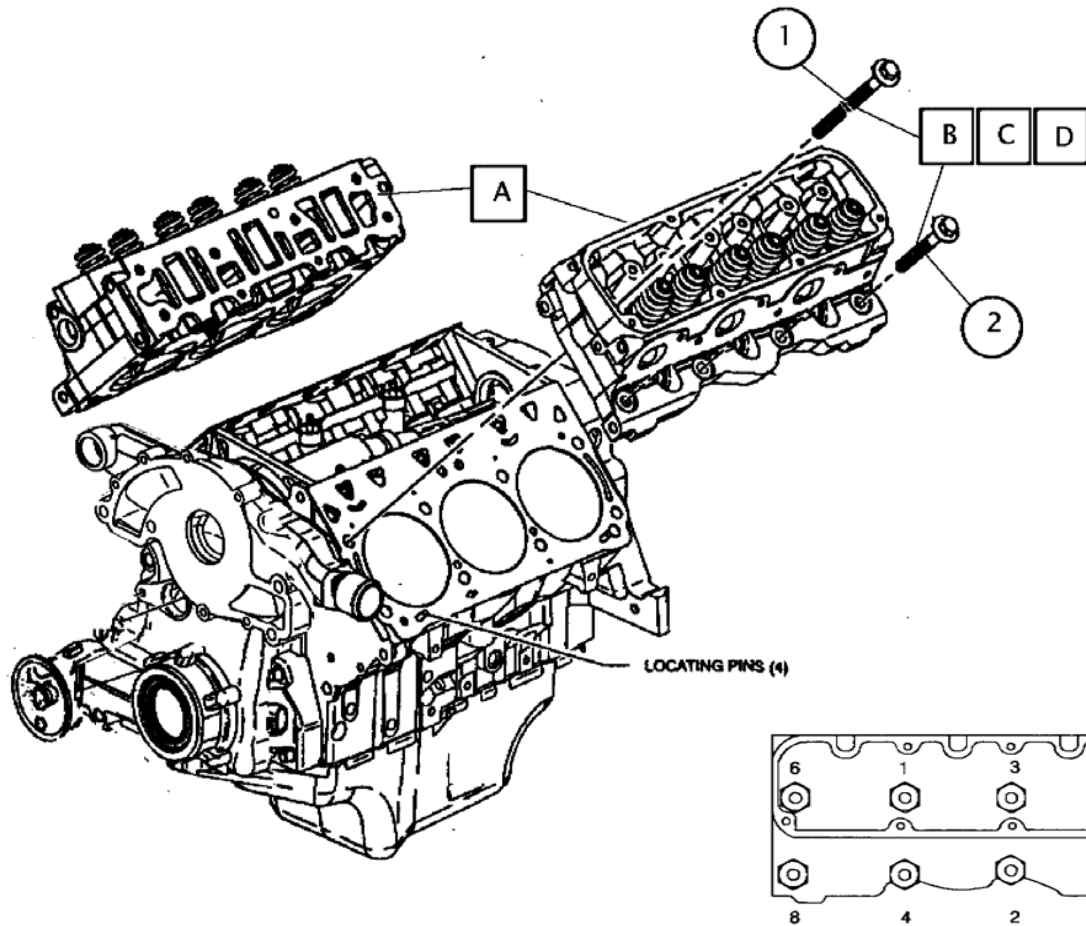
Specification	
1	24503801 Gasket RH
2	24503802 Gasket LH

REV	Date	Revision History
1	01/06/98	Block-37

View
<b>Head Gaskets</b>
Head gasket install

<b>Head Assembly</b>	<b>Sequence III G</b>
----------------------	-----------------------

Section	Sheet
5	2



**Description of Operation**

- A Carefully install cylinder heads.
  - B Clean all Teflon type sealer from new bolt threads and underside of head.
  - C Install #2 Permatex on threads and underside of fastener head.
  - D Torque fasteners from center out using a crisscross pattern with the Torque Sensor 1 wrench set on soft joint for gasketed applications.
- 30Nm-50Nm-80Nm - JCS-TEL to yield.

**Specification**

- 1 25527831 Bolt Cyl. Head (8) Long
- 2 25533811 Bolt Cyl. Head (8) Short

**View**

**Cylinder Head**

Cylinder head installation

**Section**

5

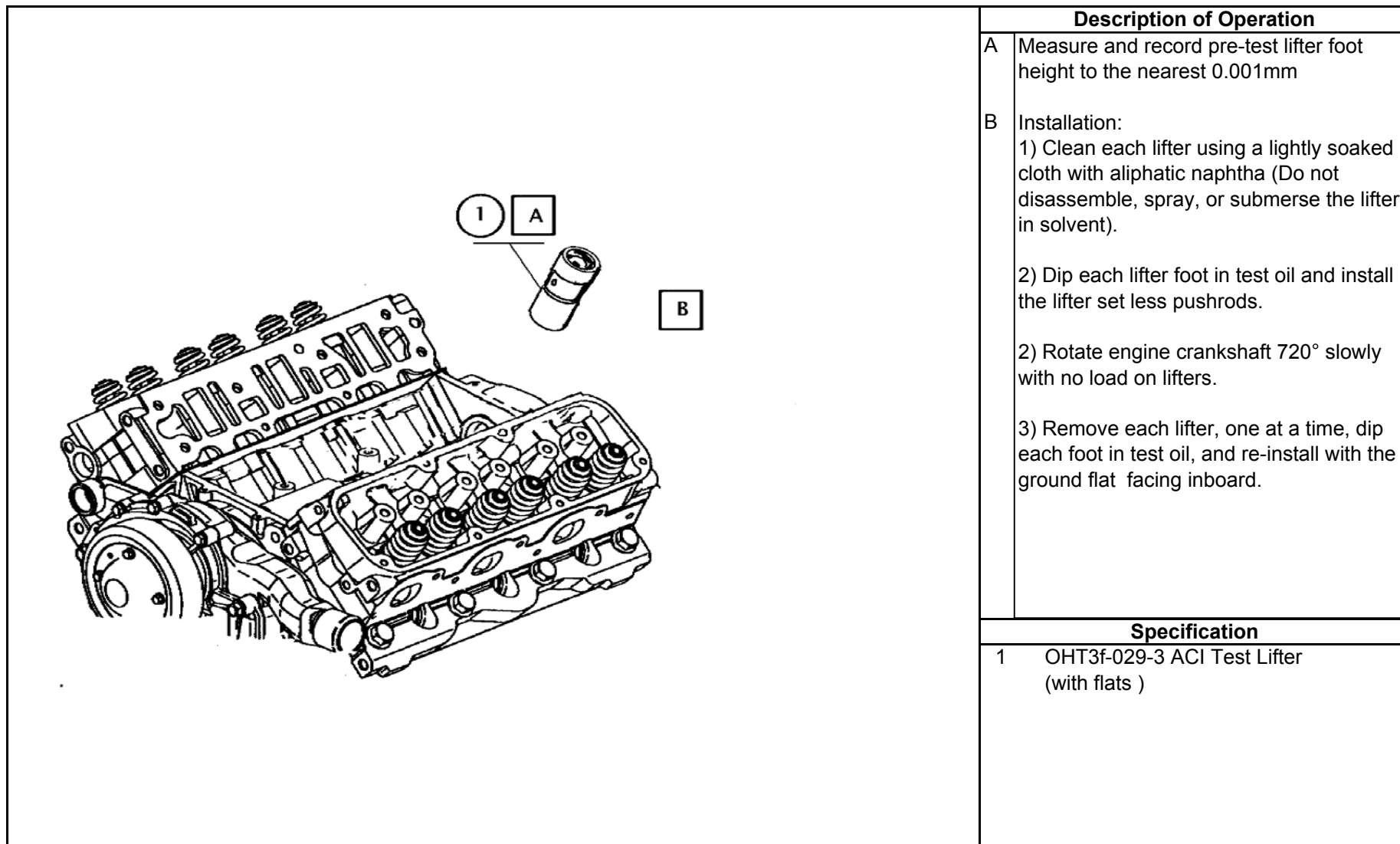
**Sheet**

3

REV	Date	Revision History
1	01/06/98	Block-38 & 50
<b>Head Assembly</b>		<b>Sequence III G</b>

## **Section 6**

### **Long Block Assembly**



**Description of Operation**

- A Measure and record pre-test lifter foot height to the nearest 0.001mm
- B Installation:
  - 1) Clean each lifter using a lightly soaked cloth with aliphatic naphtha (Do not disassemble, spray, or submerge the lifter in solvent).
  - 2) Dip each lifter foot in test oil and install the lifter set less pushrods.
  - 2) Rotate engine crankshaft 720° slowly with no load on lifters.
  - 3) Remove each lifter, one at a time, dip each foot in test oil, and re-install with the ground flat facing inboard.

**Specification**

- 1 OHT3f-029-3 ACI Test Lifter (with flats )

REV	Date	Revision History
1	1/6/98	Block-39

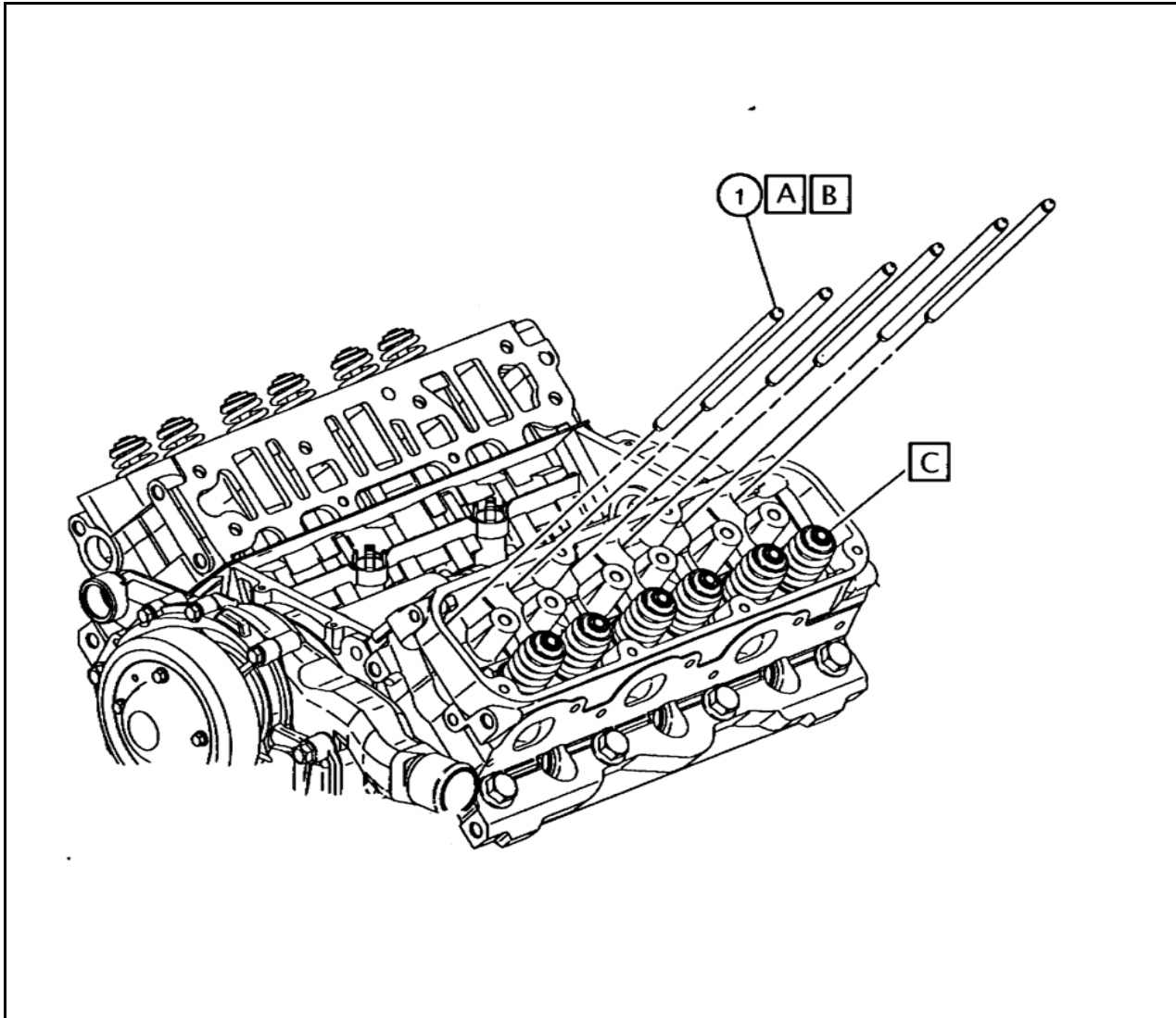
**View**

**Lifter Installation**

Lifter pre-oiling and installation

<b>Long Block Assembly</b>	<b>Sequence III G</b>
----------------------------	-----------------------

<b>Section</b>	<b>Sheet</b>
6	1



Description of Operation	
A	Clean all pushrods with aliphatic naphtha and spray with a 50/50 solution of EF-411 and aliphatic naphtha. Remove excess with compressed air. Lubricate each pushrod end, pushrod seat, and rocker arm ball socket with EF-411 prior to installation.
B	Install pushrods
C	Lubricate each valve stem seal and tip with EF-411.

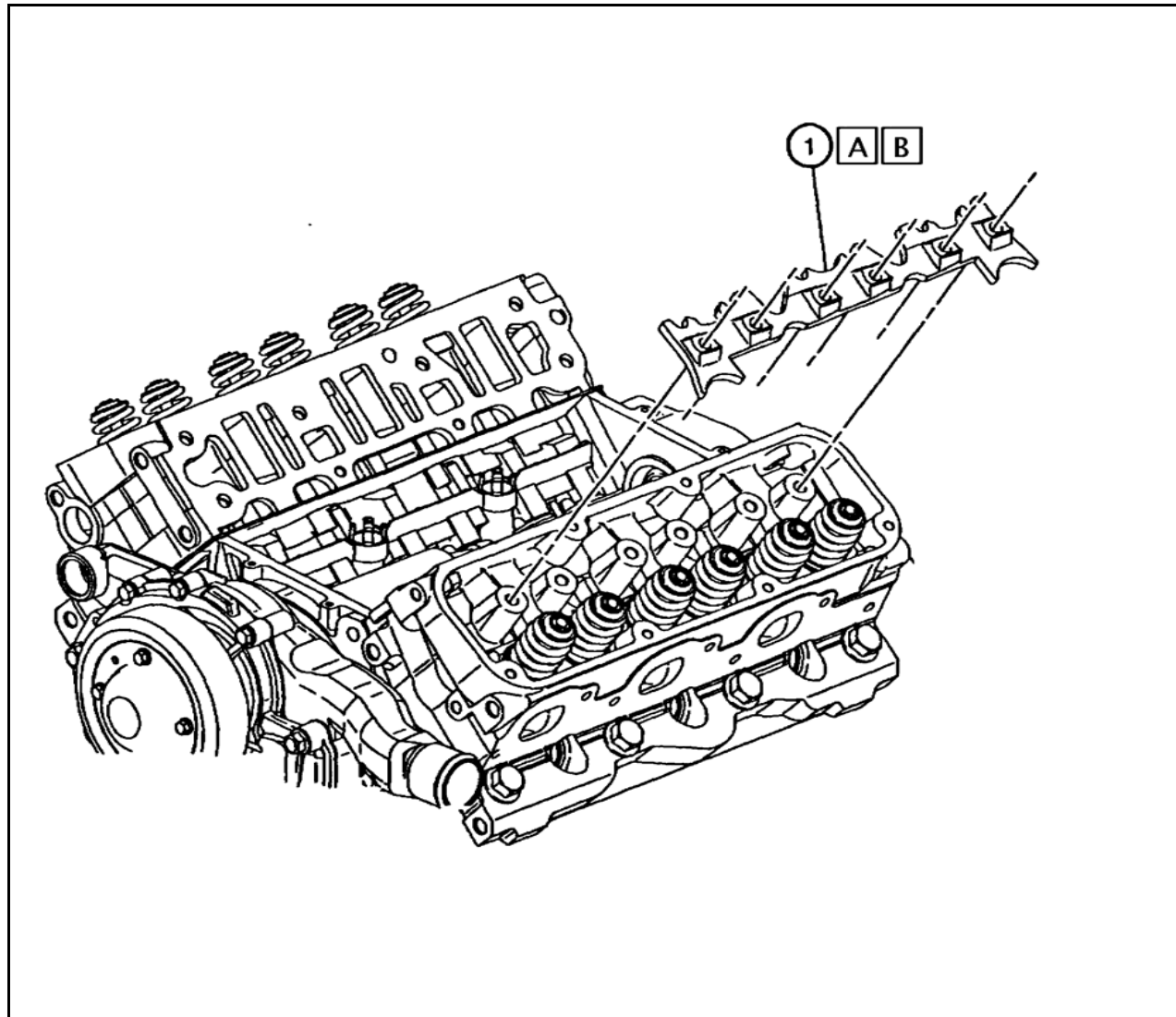
Specification	
1	OHT3F-007-1 Pushrod (Special Length)

REV	Date	Revision History
1	1/6/98	Block-40

View	
Pushrods	
Pushrod installation	

<b>Long Block Assembly</b>	<b>Sequence III G</b>
----------------------------	-----------------------

Section	Sheet
6	2



Description of Operation	
A	Clean and inspect for wear.
B	Install pushrod guide / rocker bearing retainer.

Specification	
1	24502278 Retainer

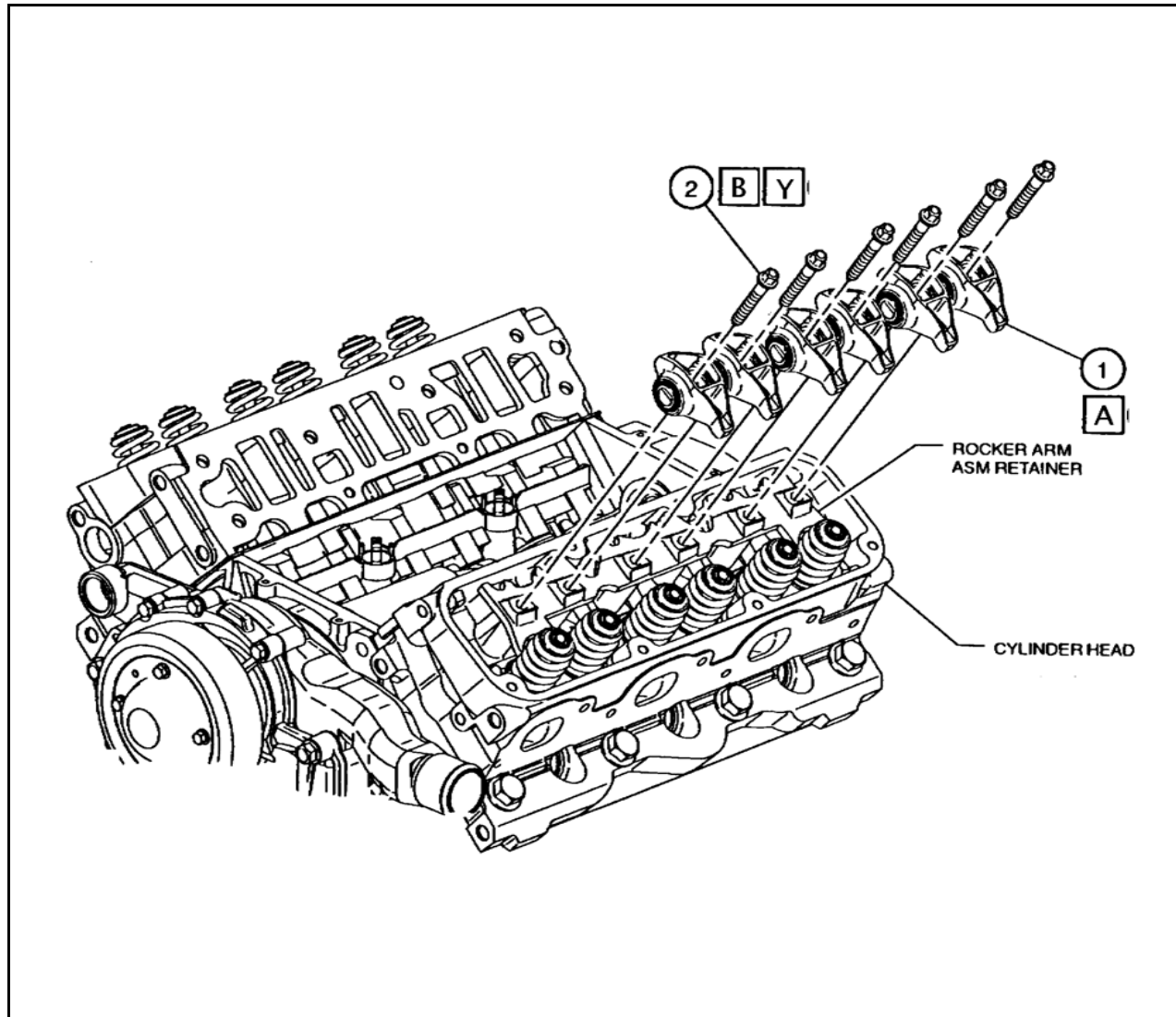
REV	Date	Revision History
1	1/6/98	Block-41

View
Retainer
Rocker bearing retainer installation

**Long Block Assembly**

**Sequence III G**

Section	Sheet
6	3



Description of Operation	
A	Lubricate rocker arms with EF-411 and install. <b>Note: Rocker arm assemblies are replaced every test. Do not dip or spray with aliphatic naphtha. Needle roller bearings will retain solvents.</b>
B	Lubricate bolts with EF-411 and install.
Y	Torque & Angle 25Nm + 70°
	Note: Do not rotate engine after final valvetrain loading.

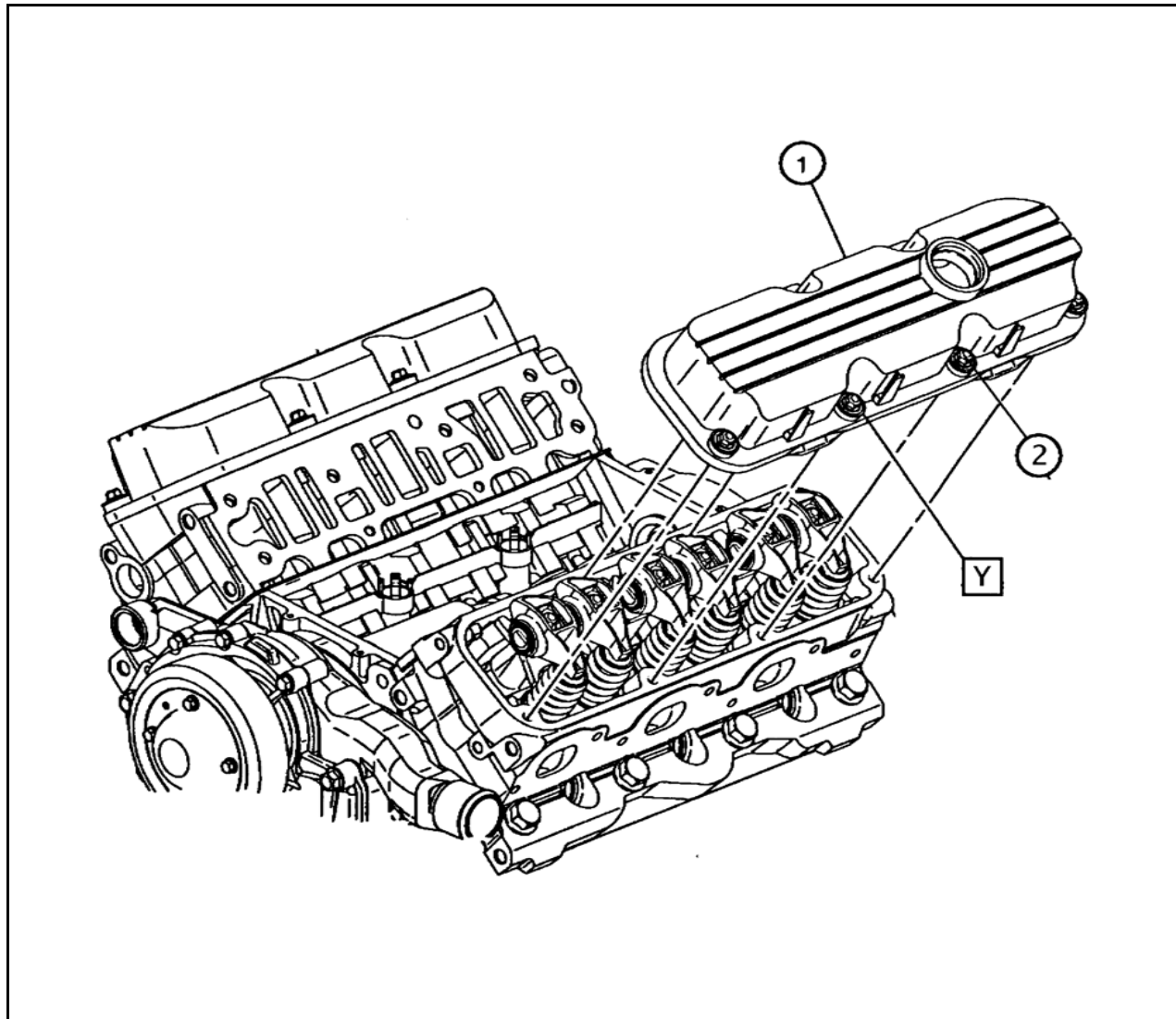
Specification	
1	OHT3F-058-1 Rocker Arm Assembly
2	Furnished less sealers with OHT Kit

REV	Date	Revision History
1	1/6/98	Block-42

View	
Rocker Arm	
Rocker arm installation	

<b>Long Block Assembly</b>	<b>Sequence III G</b>
----------------------------	-----------------------

Section	Sheet
6	4



Description of Operation	
	Install rocker covers
Y	Torque 10Nm

Specification	
1	25534751 Cover, Valve Lt (2)
2	24502164 Bolt 25534748 Bolt w/washer

REV	Date	Revision History
1	1/6/98	Block-43

View	
Rocker Cover	
Rocker cover installation	

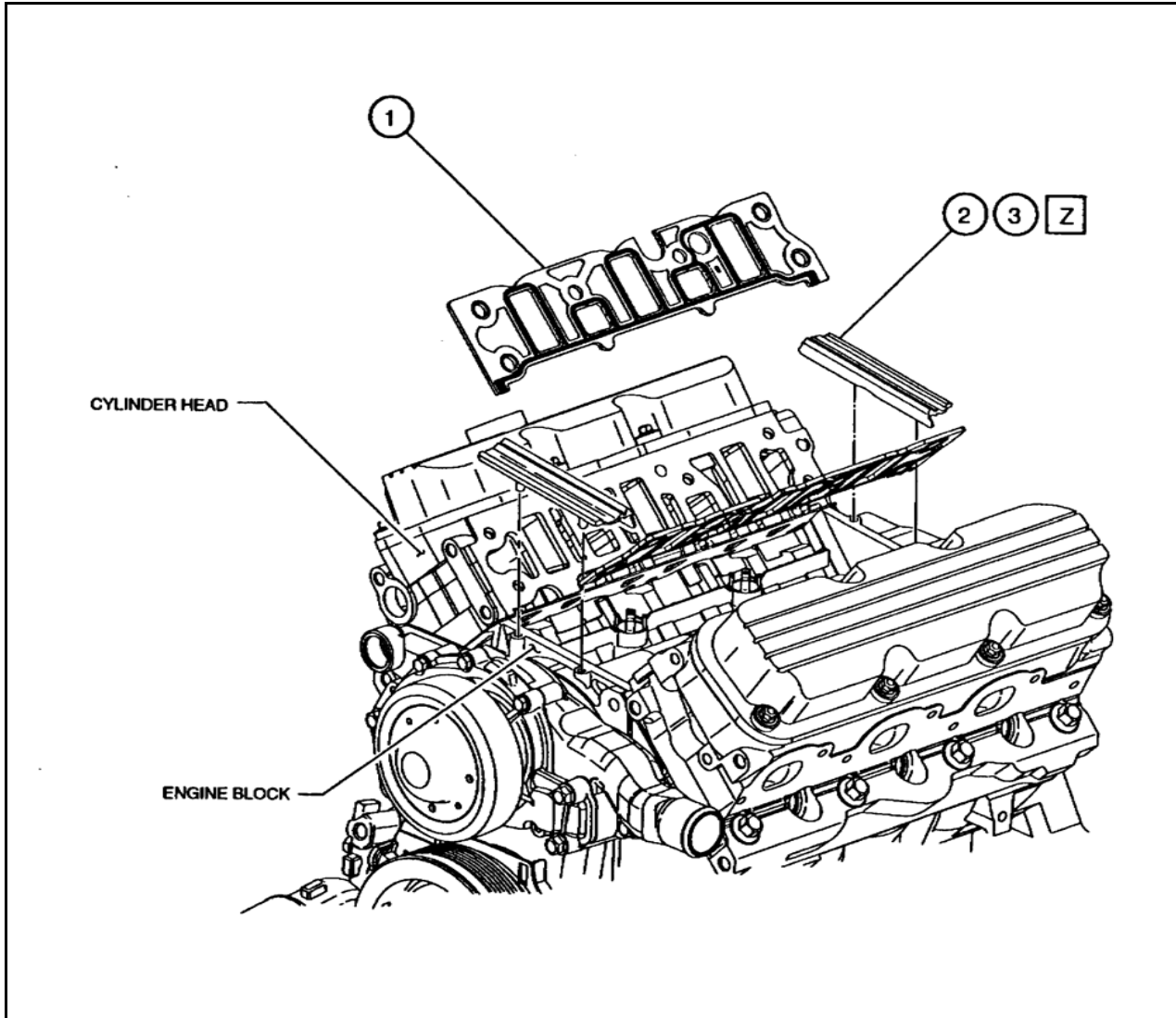
**Long Block Assembly**

**Sequence III G**

**Section**  
6

**Sheet**  
5





**Description of Operation**

2nd design gasket kit uses locating pins for front and rear seals

Z Apply GM RTV Sealer at both ends part # 12346193

**Specification**

1	12539093 Gskt. Kit 2nd design
2	Seal / part of kit
3	Sealant (see note Z)

REV	Date	Revision History
1	1/6/98	Block-44

**View**

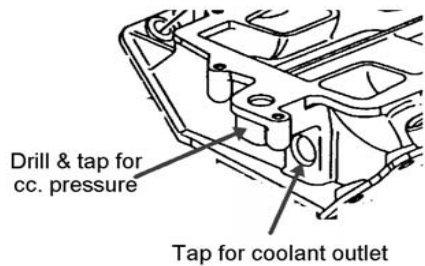
**Intake Gaskets**

Intake gasket installation

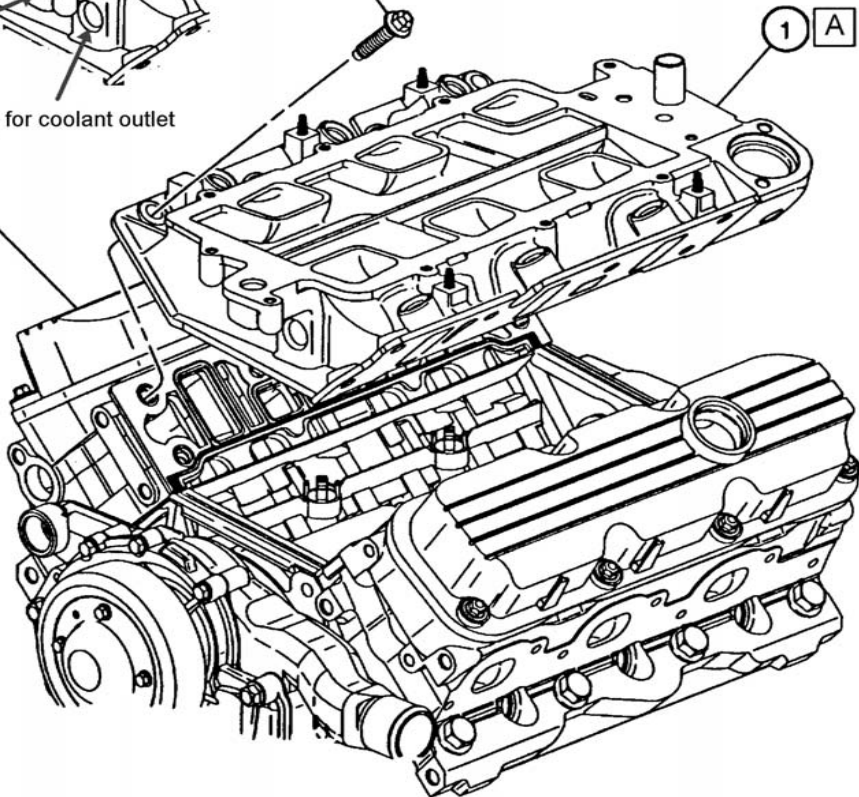
**Long Block Assembly**

**Sequence III G**

Section	Sheet
6	6



CYLINDER HEAD



**Description of Operation**

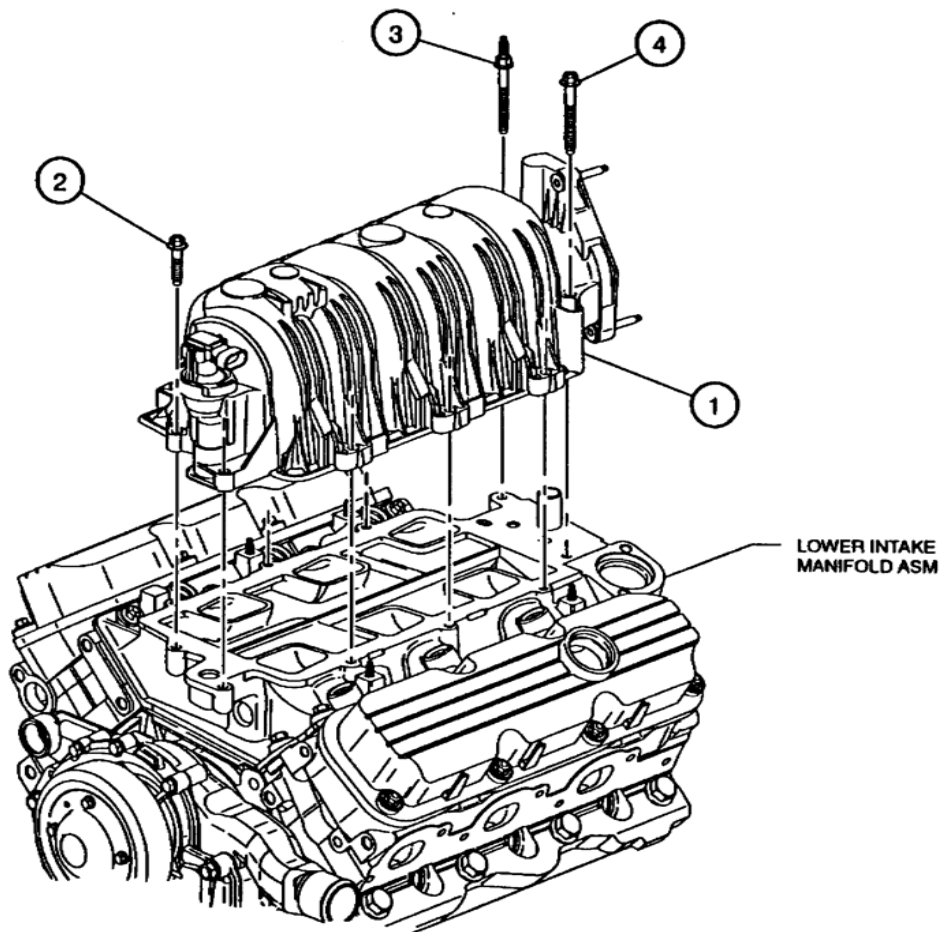
- A Install modified intake manifold
  - B Clean and lubricate bolts with Permatex #2 and install.
  - Y Torque 15Nm
- Drill and tap as indicated for the crankcase pressure line . Also tap coolant outlet port for coolant return line to process controller. Use a 3/4" I.D. unrestricted line for the return. Do not install shut off valves in the return line.

**Specification**

- 1 24505728 Manifold assembly
- 2 24504090 Bolt (12)

REV	Date	Revision History
1	1/6/98	Block-45
Long Block Assembly		Sequence III G

View	
Lower Intake	
Lower intake manifold installation	
Section	Sheet
6	7



**Description of Operation**

Install upper intake and gasket assembly.

Torque 10Nm (Max. torque)

Y

**Specification**

1 17096162 Manifold assembly  
17113137 Gasket Kit

2 24506498 Bolt (8)

3 24502453 Stud

4 24505205 Bolt

See note Y for torque

**View**

**Upper Intake**

Upper intake installation

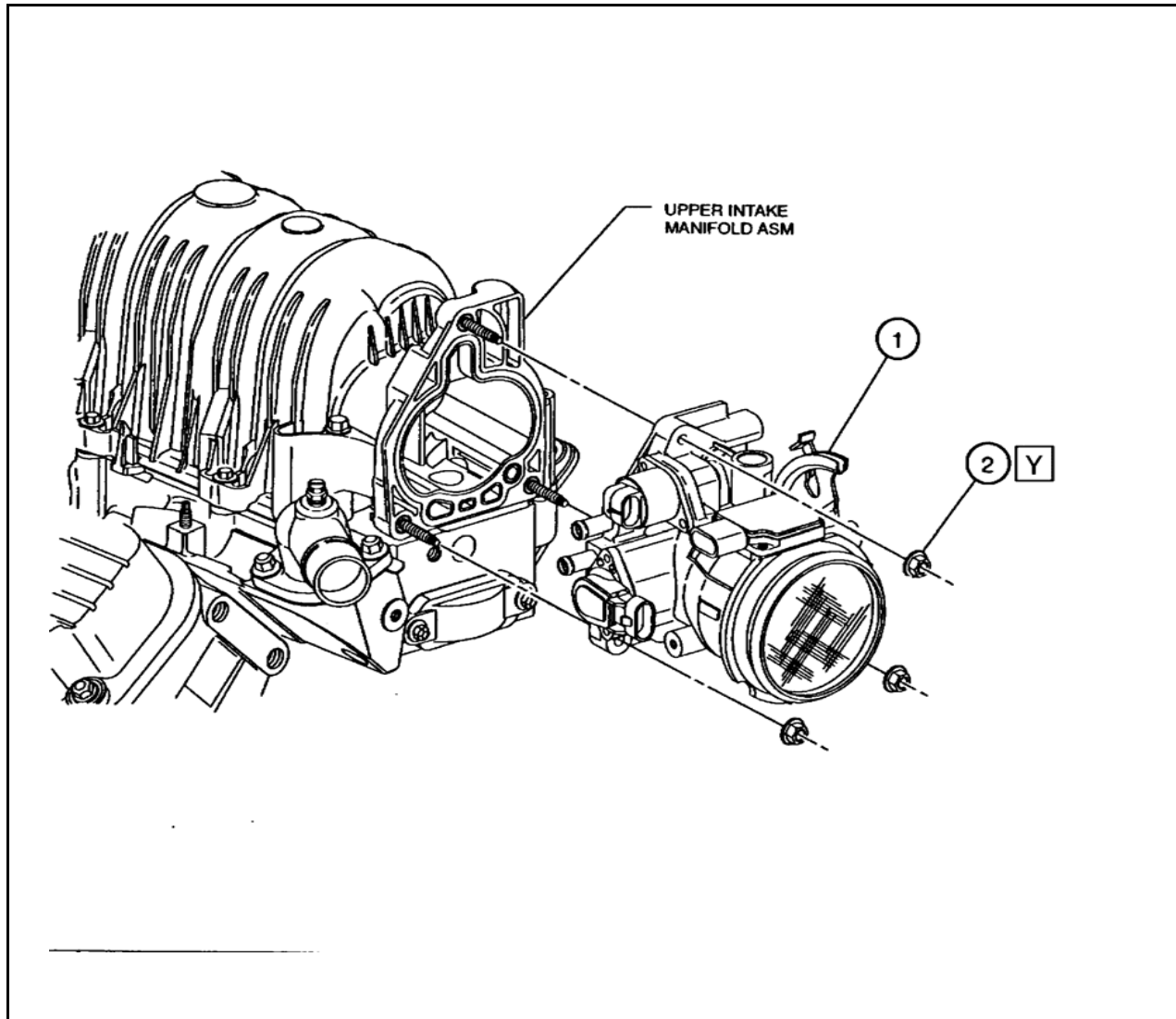
**Section**

**Sheet**

6

8

REV	Date	Revision History
1	1/6/98	Block-46
Long Block Assembly		Sequence III G



Description of Operation	
	Install modified throttle body
	<b>Note: See section 7 sheet 5 for modifications</b>
Y	Torque 10Nm

Specification	
1	24507235 Throttle Body (2 bolt Mass Air Flow Sensor) Use 12568877 or May be superseded with remanufactured part# 88961007
2	24506469 Nut

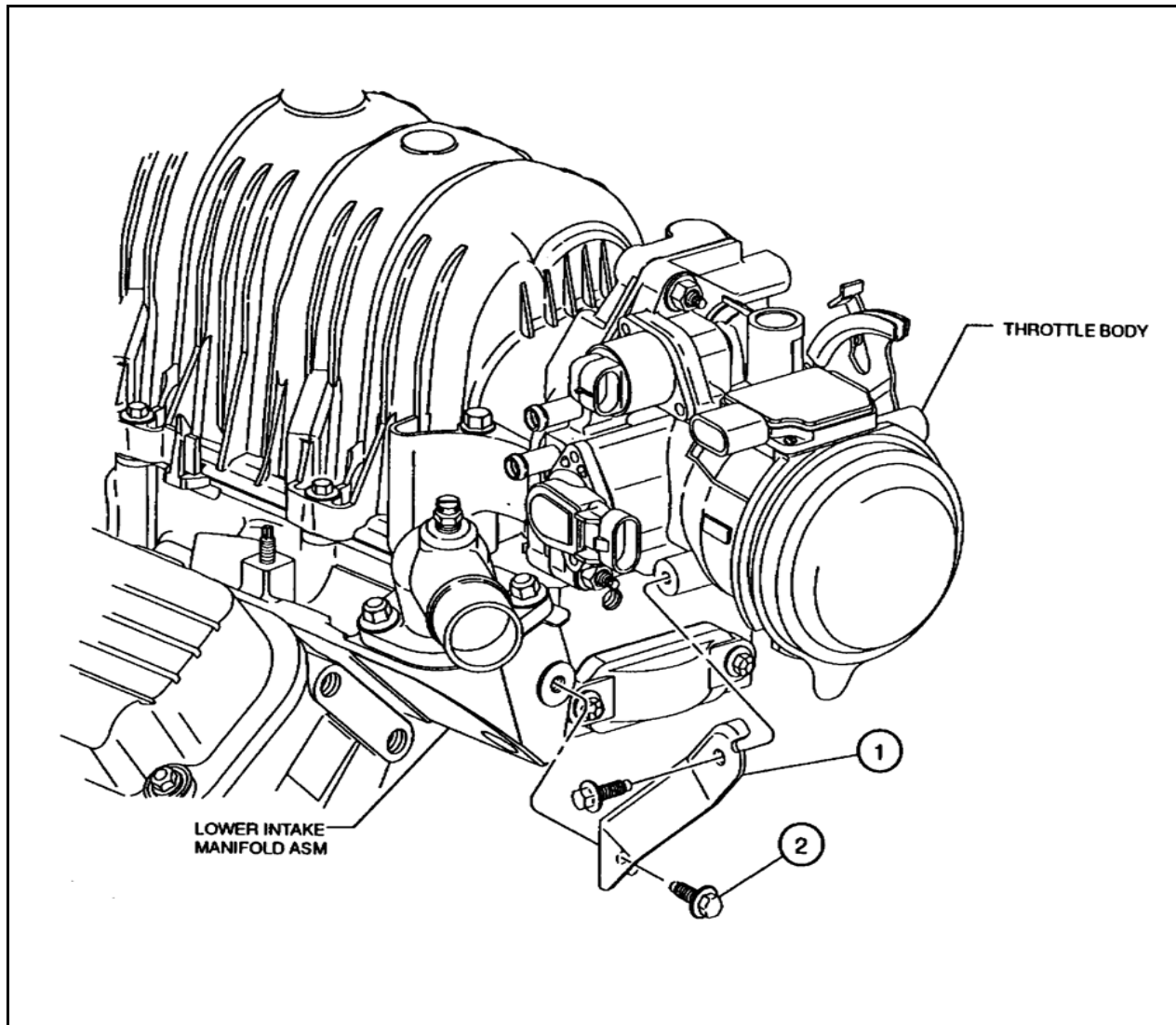
REV	Date	Revision History
1	1/6/98	Block-47
2	4/28/03	Add new mass airflow part number 12568877
3	6/23/03	Add 88961007 remanufactured from 12568877

View	
<b>Throttle Body</b>	
Throttle body installation	

**Long Block Assembly**

**Sequence III G**

Section	Sheet
6	9



Description of Operation	
	Install support bracket
Y	Torque 10Nm

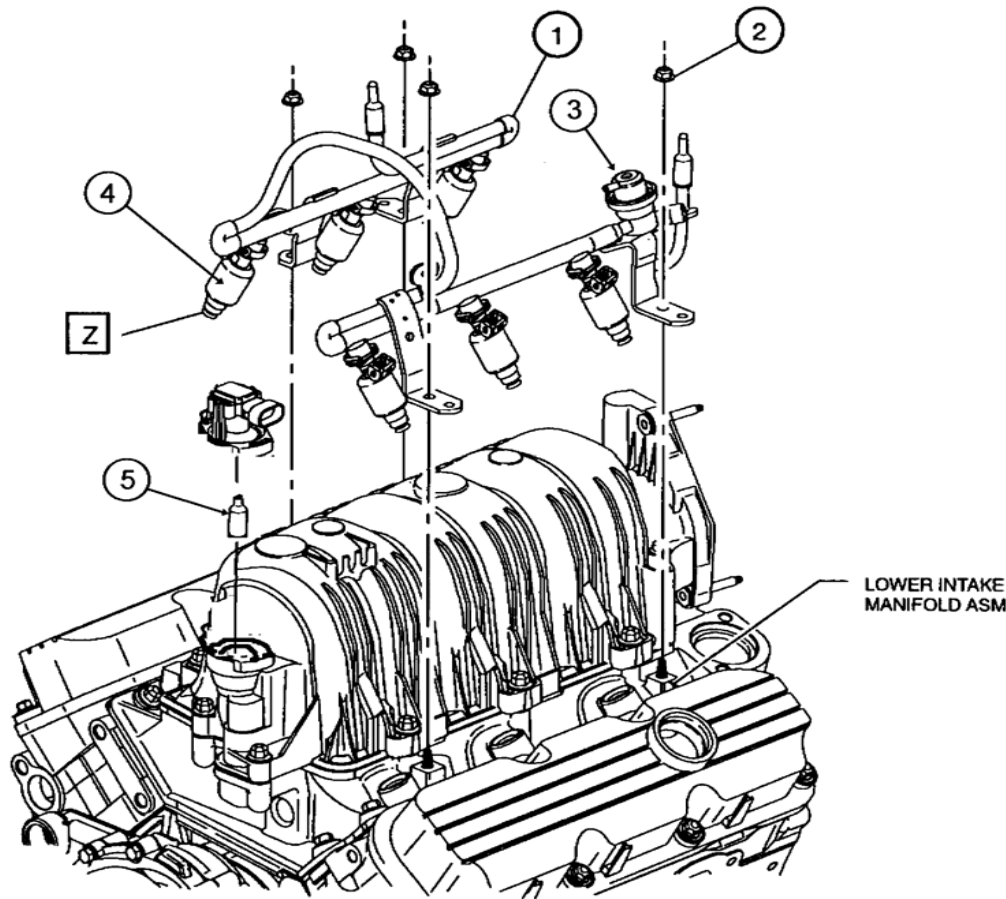
Specification	
1	24504697 Support
2	24503644 Bolt (2) See note Y for torque

REV	Date	Revision History
1	1/6/98	Block-48

View	
<b>Throttle Body Support</b>	
Throttle body support installation	

<b>Long Block Assembly</b>	<b>Sequence III G</b>
----------------------------	-----------------------

Section	Sheet
6	10



**Description of Operation**

Install injector assembly (See sec. 6.14.1 of Sequence IIIF Test Procedure)

Y Torque 10Nm

Z Lubricate O-ring with EF-411

**Specification**

- 1 17098211 Fuel Rail
- 2 24506469 Nut
- 3 17113346 Regulator
- 4 17120601 Injector
- 5 OHT3F-002-1 PCV Dummy

**View**

**Injector Assembly**

Injector assembly installation

**Section**

6

**Sheet**

11

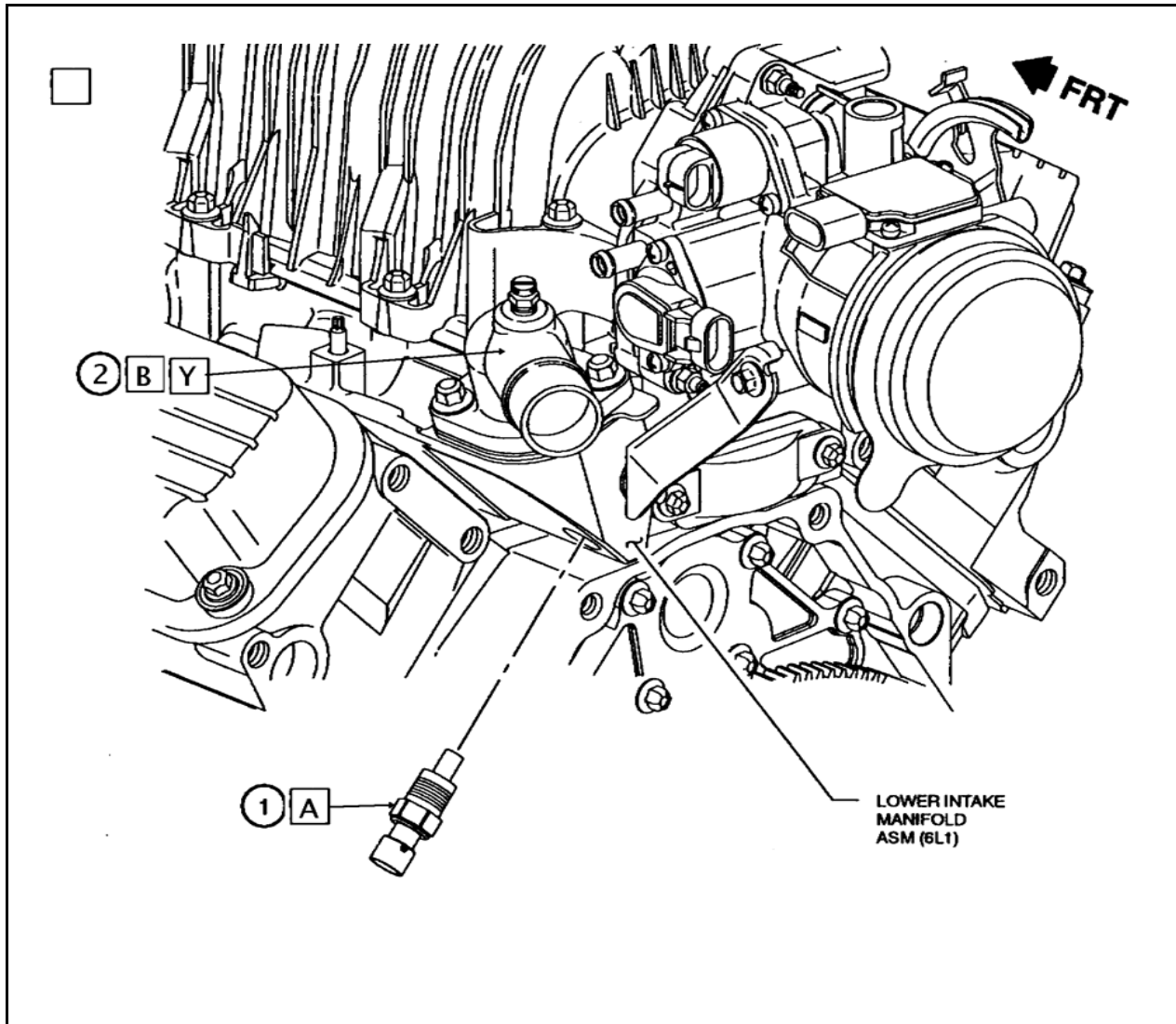
REV	Date	Revision History
1	1/6/98	Block-49

**Long Block Assembly**

**Sequence IIIG**

## **Section 7**

### **Final Dress**



Description of Operation	
A	Install production sensor as a plug only. <b>Do not use for connection to harness.</b> <b>Disable connector.</b>
B	Install coolant outlet
Y	Torque 27Nm

Specification	
1	10096181 Sensor (Used for plug only, disable connector)
2	OHT3F-034-1 Coolant Outlet (Not to detail on sheet)

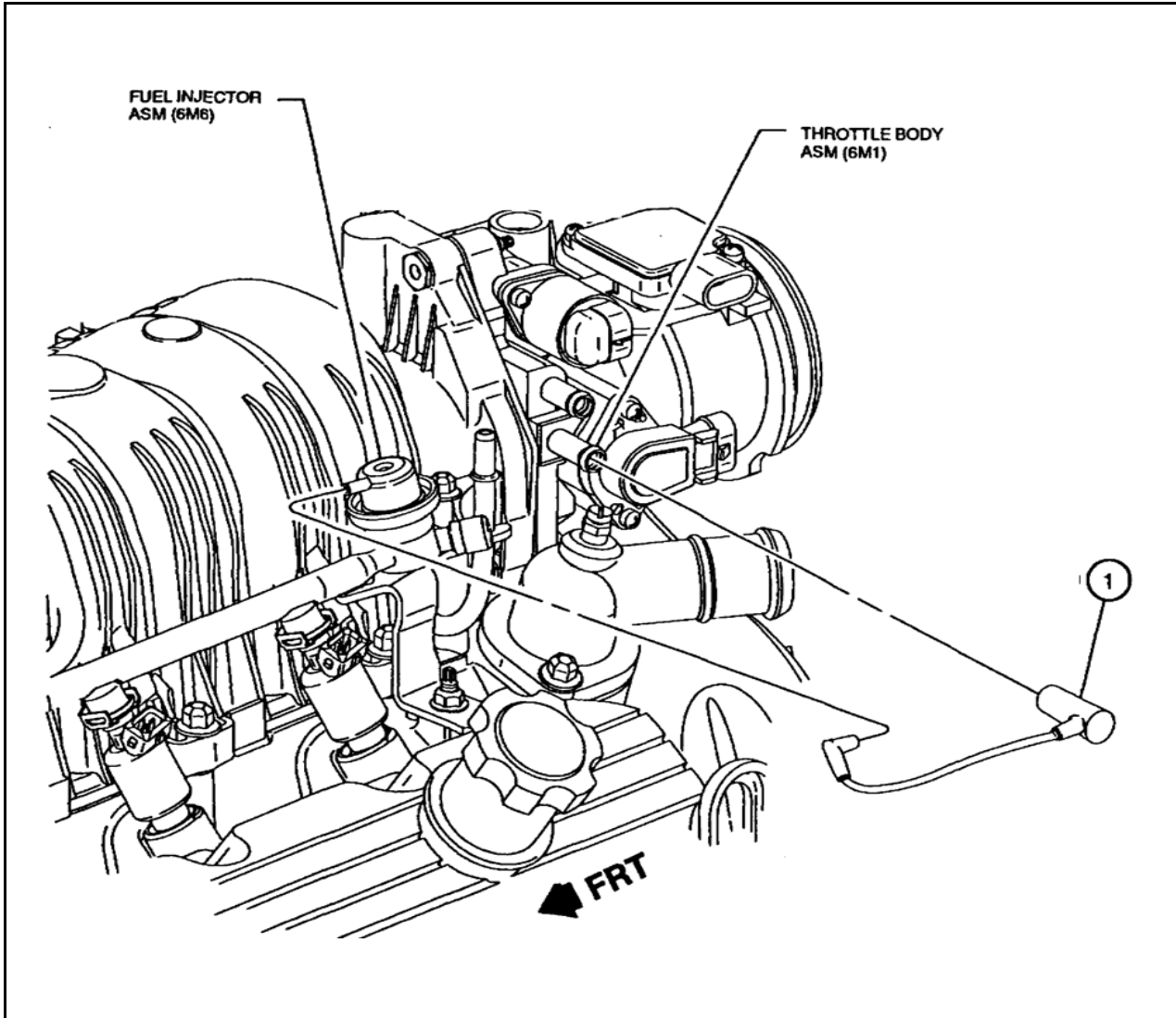
REV	Date	Revision History
1	1/10/98	Block-51

View	
Coolant Out & Sensor	

<b>Final Dress</b>	<b>Sequence III G</b>
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Section	Sheet
7	1





**Description of Operation**

Specification	
1	24505671 Tube

REV	Date	Revision History
1	1/10/98	Block-52

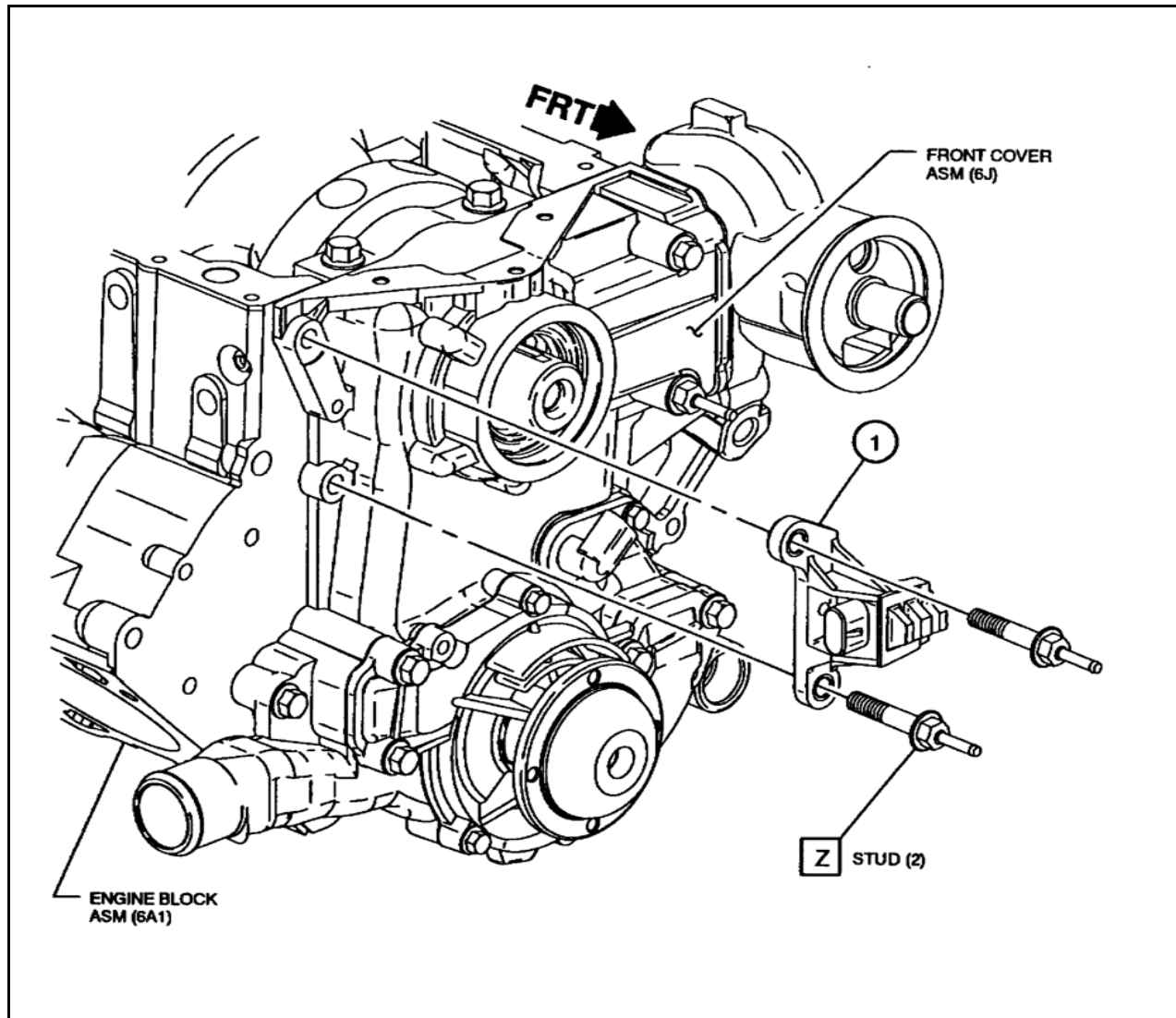
**View**

**Vacuum Hose**

**Final Dress**

**Sequence III G**

Section	Sheet
7	2



**Description of Operation**

Z See front cover section for bolt part numbers and torque.

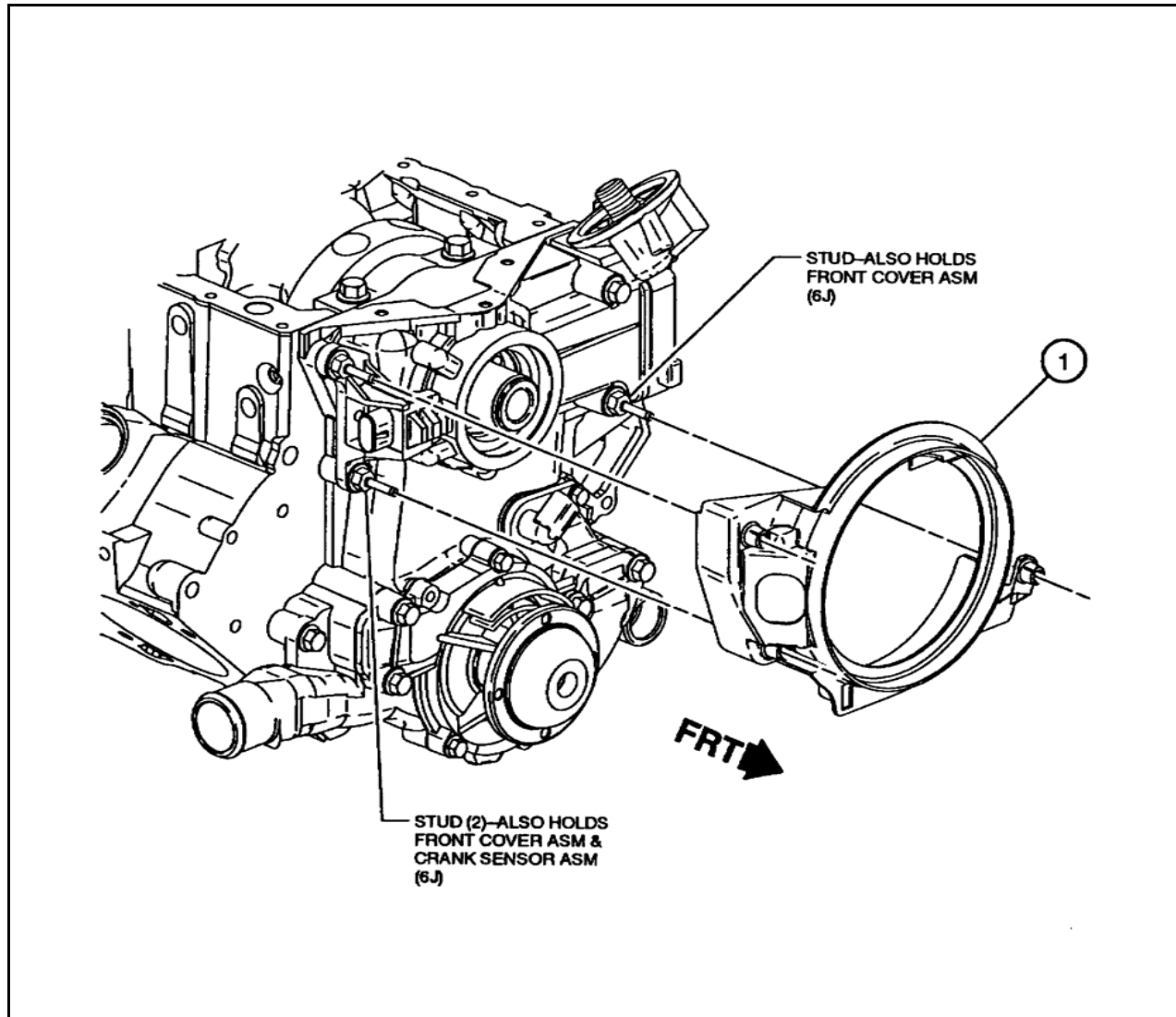
Specification	
1	10456161 Sensor

REV	Date	Revision History
1	1/10/98	Block-53

**View**  
**Crankshaft Sensor**

**Final Dress**                      **Sequence III F**

Section	Sheet
7	3



**Description of Operation**

**Specification**

1 24506440 Shield

REV	Date	Revision History
1	1/10/98	Block-54

**View**

**Crankshaft Sensor Shield**

**Final Dress**

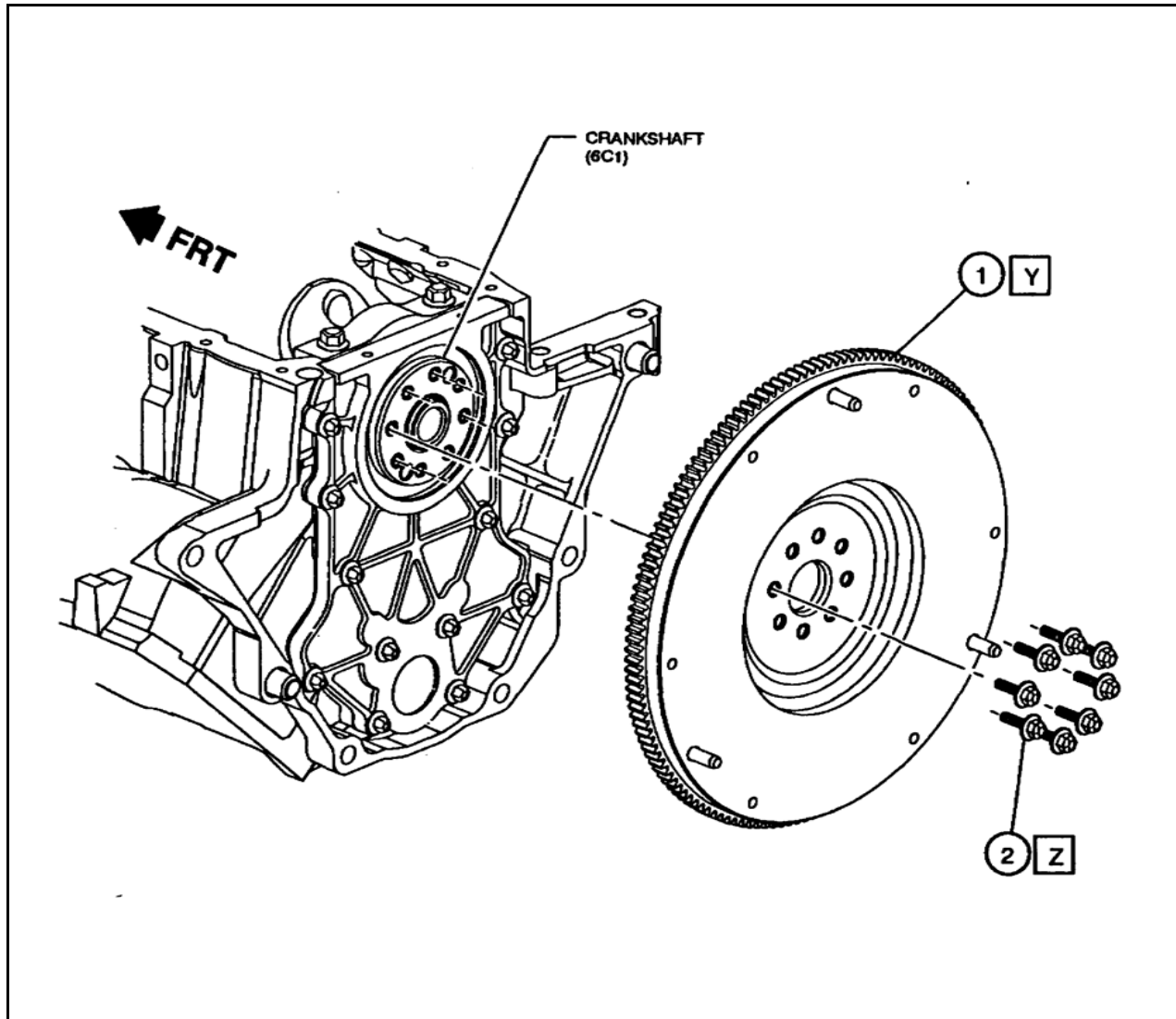
**Sequence III G**

**Section**

7

**Sheet**

4



Description of Operation	
Y	OHT-020-2 modified to fit offset balance and adapter plate for Dana 1550 four bolt yoke.
Z	Torque & Angle 15Nm + 50°

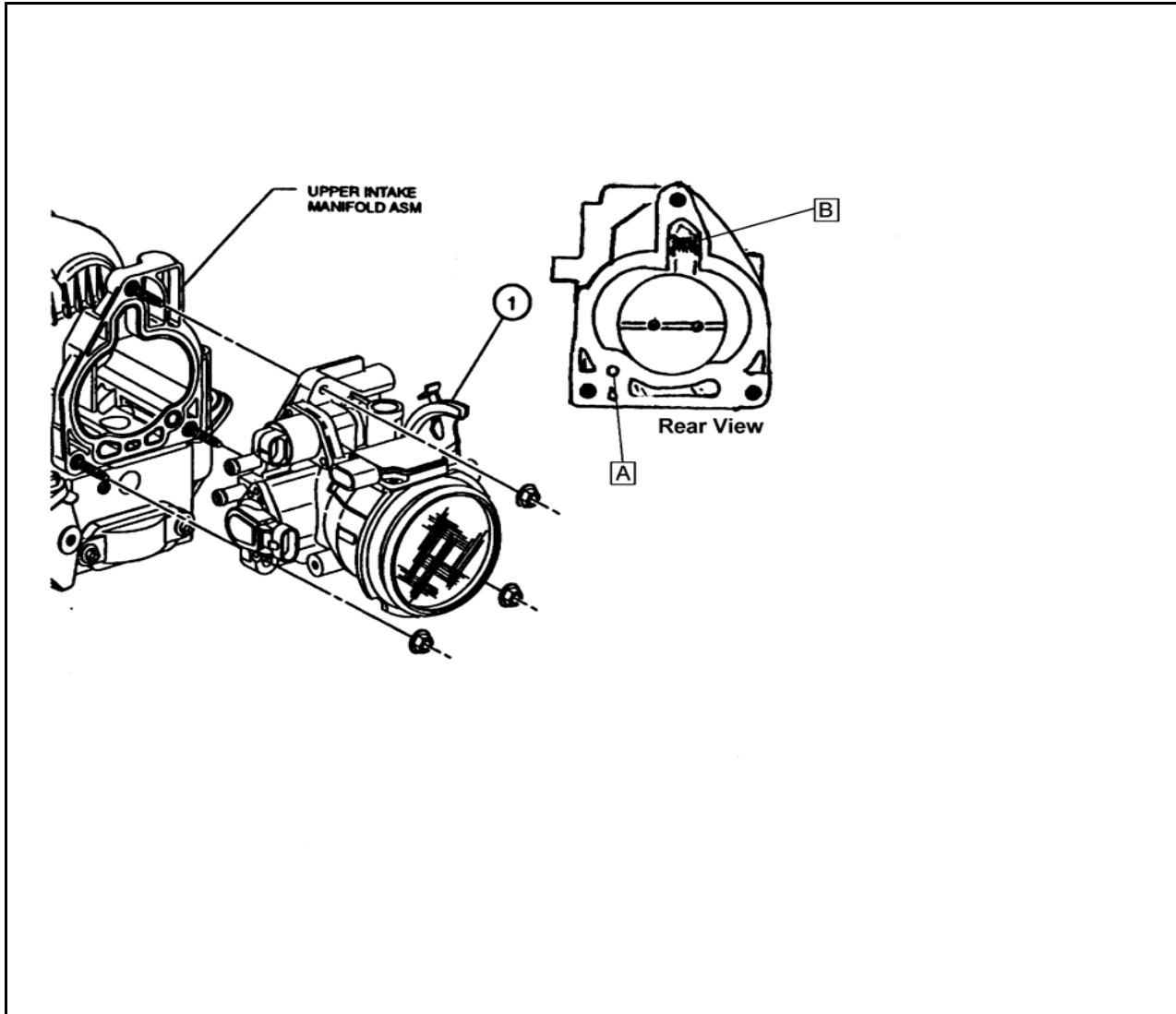
Specification	
1	OHT3F-020-2 Flywheel (Modified 24503285)
2	24505092 Bolt

REV	Date	Revision History
1	1/10/98	Block-55

View	
Flywheel	

Final Dress	Sequence III G
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Section	Sheet
7	5



**Description of Operation**

A Drill and tap to receive a hex head plug

B Use power to PCM with engine not running and throttle blade open to drive Idle Air Control motor closed. Disconnect harness connector and adjust idle screw to obtain 800 RPM base idle.

As an alternative, the IAC may be removed and both ports plugged using epoxy and welch type plugs.

**Specification**

1 24507235 Throttle Body  
 (2 bolt Mass Air Flow Sensor)  
 Use 12568877  
 or  
 May be superseded with  
 remanufactured part# 88961007

REV	Date	Revision History
1	11/13/99	Block-48
2	5/28/03	Add 12568877
3	6/23/03	Add 88961007 remanufactured from 12568877

**View**

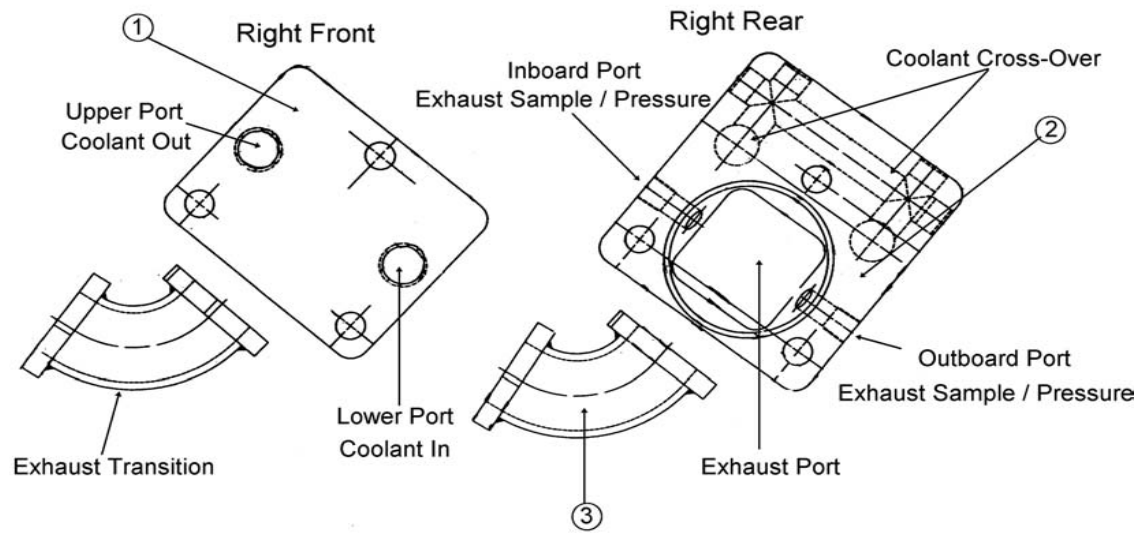
**Throttle Body Modification**

**Final Dress**

**Sequence III G**

## **Section 8**

### **OH Technologies Special Engine Dress**



**Description of Operation**

Water cooled exhaust manifold end plates and exhaust manifold transitions. Note: both views are right side showing the cooling water inlet is the lower port and the outlet is the higher port. Also, the inboard exhaust sample port is typically for the gas analysis and the outboard is for the back pressure connection.

The transition should be connected with shielded gaskets not shown but identified by part number. Two required per side.

Thermocouples for exhaust coolant in and out should be installed in the fittings attached to the front plate and centered in the coolant flow.

**Specification**

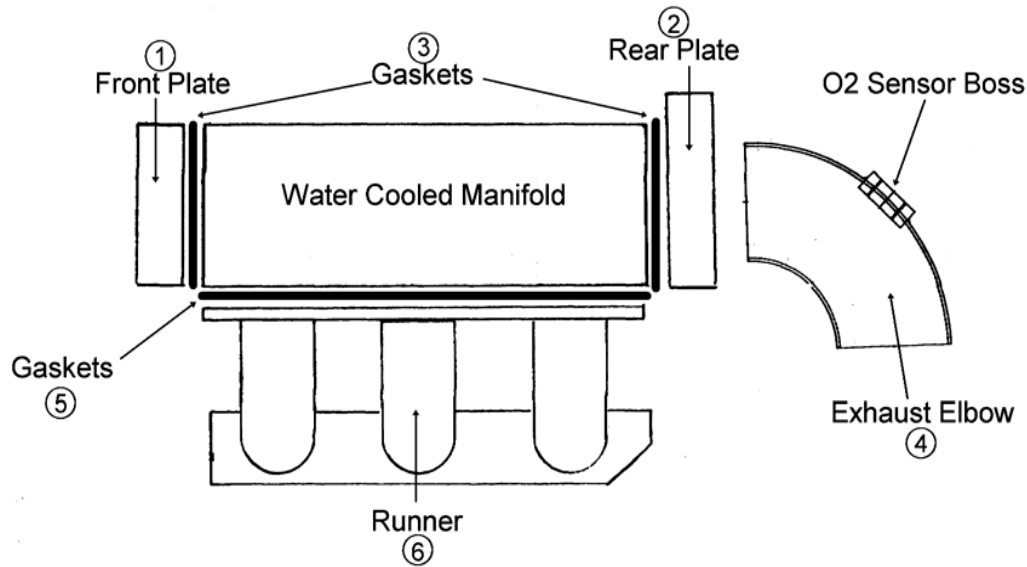
- 1 OHT3F-006-1 Plate, Rear Exhaust
- 2 OHT3F-005-1 Plate, Front Exhaust
- 3 OHT3F-004-1 Runner, Exh. Man.

REV	Date	Revision History
1	11/13/99	Block-60
2	2/22/02	Update View Exhaust sample / pressure locations

View	
<b>Water Cooled Exh. Man. End Plates</b>	

<b>OHT</b>	<b>Sequence III G</b>
------------	-----------------------

Section	Sheet
8	1



**Description of Operation**

Water cooled exhaust manifold

Not to scale

**Note: Do Not Use RTV Sealer on O2 sensor or other exhaust system components upstream of O2 sensor.**

**Specification**

- 1 OHT3F-005-1 Plate, Front Exhaust
- 2 OHT3F-006-1 Plate, Rear Exhaust
- 3 OHT3F-009-1 Gasket, End Plate
- 4 OHT3F-005A-1 Elbow, Exh. Modified
- 5 OHT3F-018-1 Gasket Flange, Metal
- 6 OHT3F-004-1 Runner, Exh. Man.

**View**

**Water Cooled Exh. Man. & Elbow**

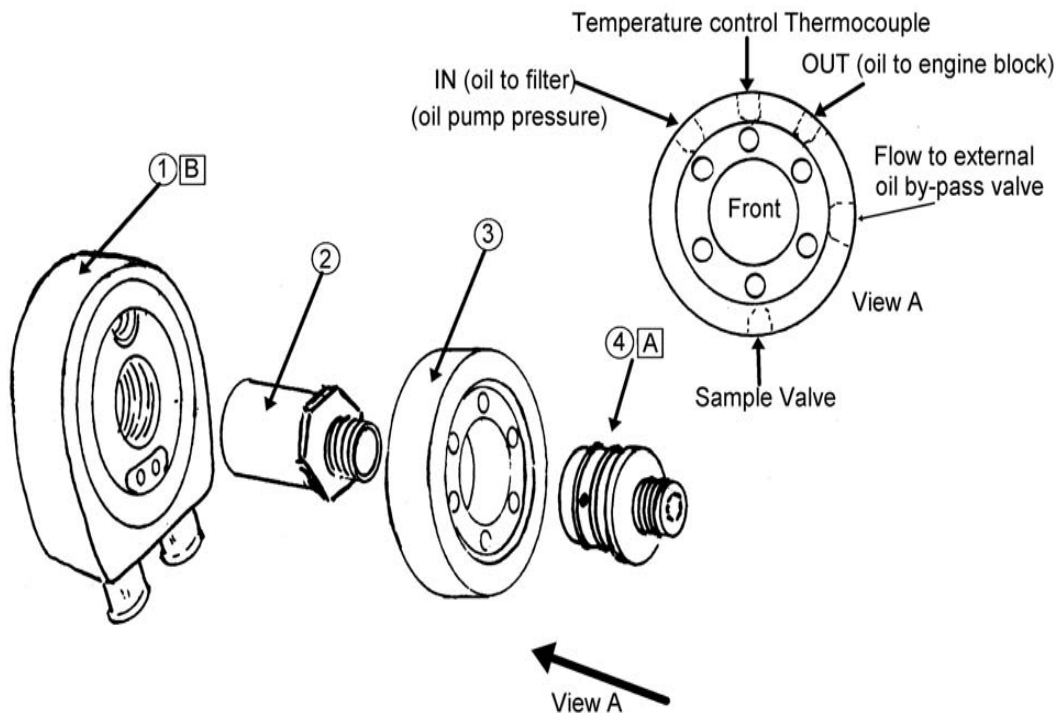
REV	Date	Revision History
1	11/13/99	Block-61
2	2/22/02	Update text, include warning on usage of RTV sealer

**OHT**

**Sequence III G**

Section	Sheet
8	2





Note: See section 8 sheet 3a & 3b for additional information

**Description of Operation**

- A Replace "O"-rings every test.
- Note: View A  
 Viewed from front or oil filter side, passages are, IN (oil pump pressure to filter), center port for temperature control thermocouple, OUT (oil flow out of filter in to engine block), Side outlet to external oil by-pass valve, and lower port is for oil sample valve.
- B Replace oil cooler every test

**Specification**

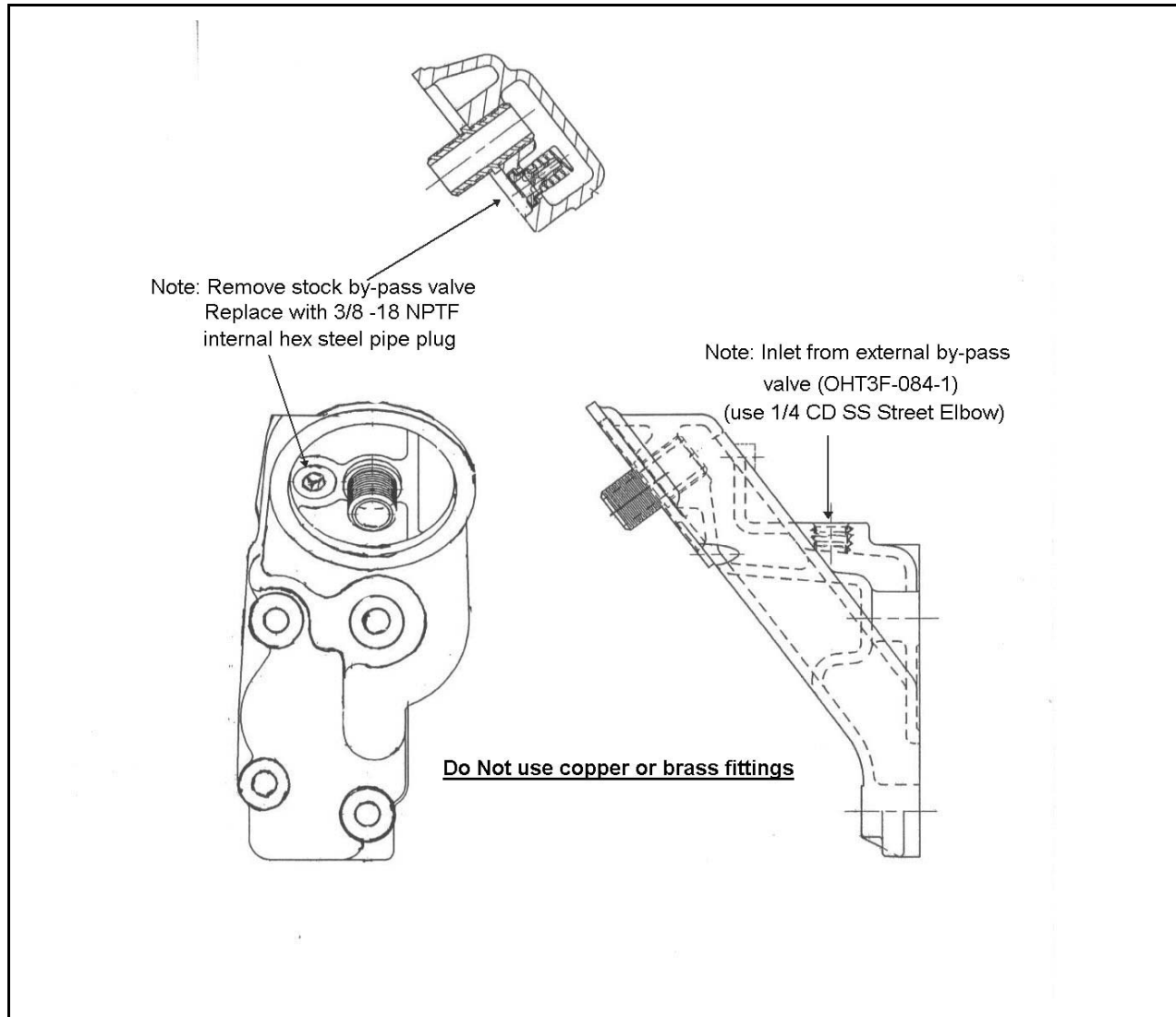
- 1 OHT3F-030-2 Cooler Nickel Plated
- 2 OHT3F-039-3 Connector Special Cut
- 3 OHT3F-035-2 Adapter, Oil Filter
- 4 OHT3F-043-2 Fitting, Oil Filter Adapter

REV	Date	Revision History
1	11/30/99	Block 62
2	6/17/02	Add notes, new part numbers and update view. See next sheet for further details

**View**  
**Oil Cooler Assembly**

**OHT** **Sequence III G**

Section	Sheet
8	3



**Description of Operation**

Special part modification information.

Modified part may be purchased direct from OHT (OHT3F-080-1)

**Specification**

1	24501300 Adapter, oil filter OHT3F-080-1 Modified
---	--

REV	Date	Revision History

**View**

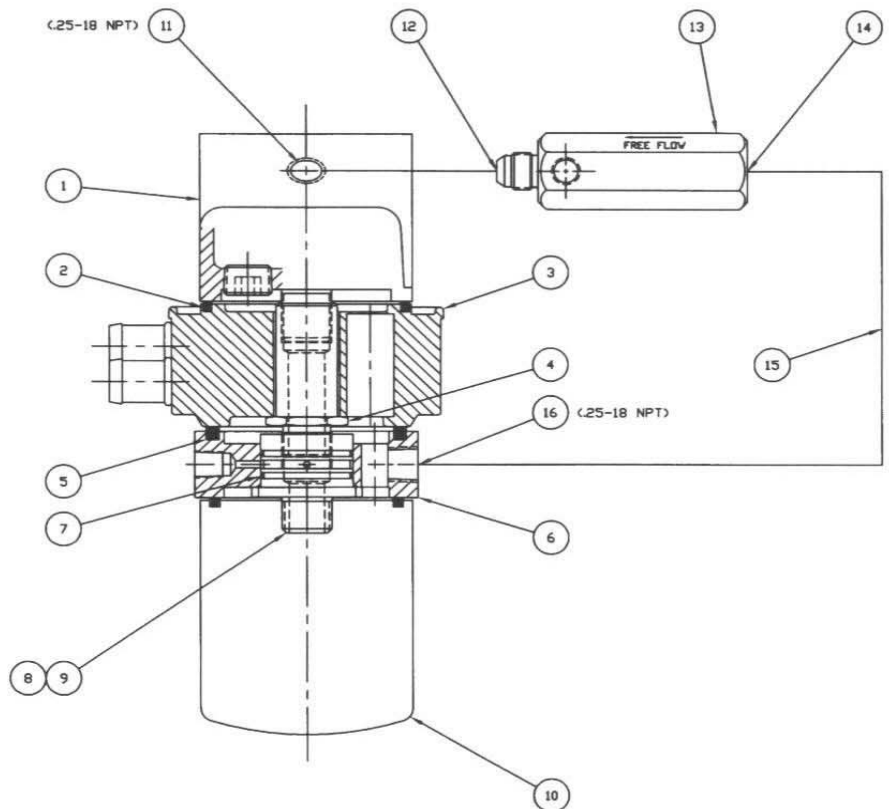
**Oil Filter Adapter Modification**

**OHT**

**Sequence III G**

**Section**  
8

**Sheet**  
3a



BILL OF MATERIAL		
ITEM	REQ'D	DESCRIPTION
1	1	BLOCK, OIL FILTER, MODIFIED W/BYPASS BLOCKED, DHT3F-080-1
2	1	SEAL, RECTANGULAR, DHT3F-074-1
3	1	COOLER, OIL, NICKEL PLATED, BYPASS CLOSED, DHT3F-030-2
4	1	CONNECTOR, MODIFIED, DHT3F-039-3
5	1	SEAL, RECTANGULAR, DHT3F-062-1
6	1	ADAPTER, OIL FILTER, DHT3F-035-2
7	2	SEAL, O-RING, #2-025-VITON PARKER
8	1	FITTING, OIL FILTER ADAPTER, .500" I.D., DHT3F-043-2
9	1	WRENCH, SPANNER, (FOR USE W/ITEM #8), DHT3F-083-1
10	1	FILTER, OIL (PF-47), DHT3F-057-1
11	1	ELBOW, STREET, #1/4 CD-SS PARKER
12	1	CONNECTOR, SWIVEL, #6 F6X-SS PARKER
13	1	HOUSING, ASS'Y, BYPASS VALVE, DHT3F-084-1
14	1	CONNECTOR, MALE, #6-BFTX-SS PARKER
15	1	(.31 I.D. X 12.00 LG.) BRAIDED TEFLON HOSE ASS'Y, #K9190606-060606C-012.0 PARKER
16	1	CONNECTOR, MALE, #6FTX-SS PARKER

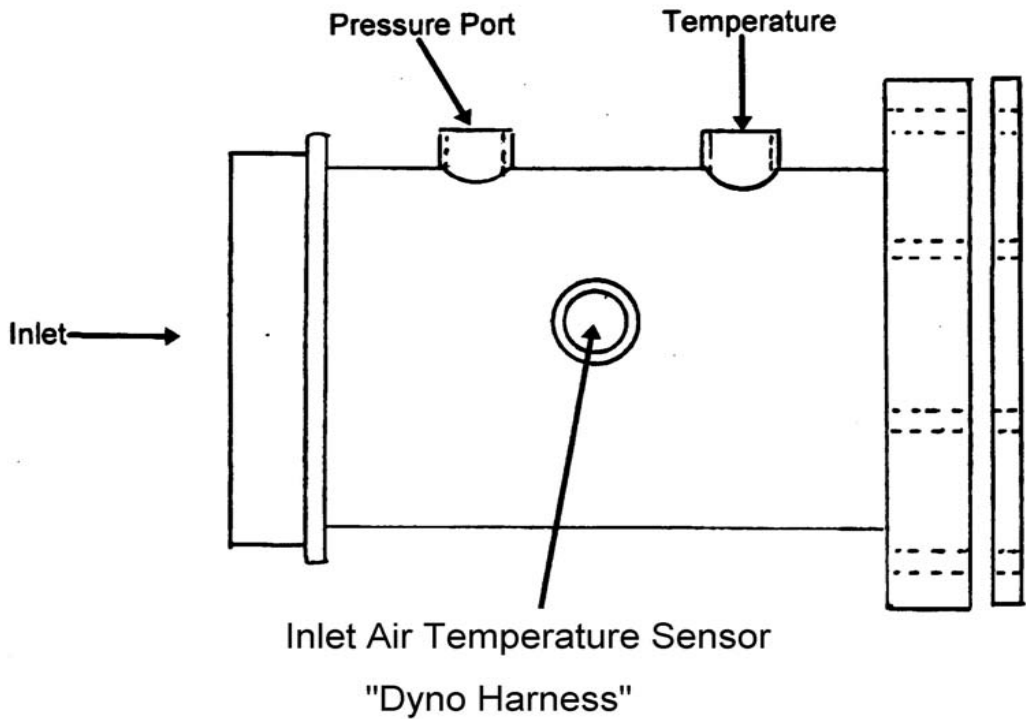
ASSEMBLE ALL SEALS WITH A LIGHT COATING OF #EF411 OIL

DIMENSIONS IN PARENTHESES ARE IN INCHES

METRIC		SYN	REVISES	DATE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS				
TOLERANCES UNLESS SPECIFIED	TITLE	ASS'Y, OIL FILTER, COOLER & BYPASS		
DECIMAL	MATERIAL	SEE B/M		
XX = .003	SCALE	FULL		
XXX = .010	DATE	6-6-02		
ANGULAR .1"	CHECKED BY	D.H.		
SURFACES 1/2	DRAWN BY	D.H.		
OH TECHNOLOGIES INC.		DVG. NO. DHT3G-XXX-1		
P.O. BOX 1007		MONTICELLO, TN 37130		

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REV	Date	Revision History	View	
1	6/17/02	OHT Print	OHT Oil Cooling & By-Pass	
			Printed by permission OH Technologies	
			Section	Sheet
			8	3b
OHT		Sequence III G		



**Description of Operation**

Inlre air adapter  
 Use pressure port for hookup to transducer, temperature for thermocouple (centered in flow), and inlet air pressure sensor port for Dyno Harness sensor.

**Specification**

OHT3F-001-2 Adapter, Throttle Body

REV	Date	Revision History
1	11/30/99	Block-63
2	2/22/02	Update View, Inlet Air Temp. Sensor

**View**

**Adapter, Throttle Body**

**Section**

8

**Sheet**

4

**OHT**

**Sequence III G**