

2008 Pontiac G5

2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5

2008 ENGINE**Engine Mechanical - 2.2L (L61) - Cobalt & G5****SPECIFICATIONS****FASTENER TIGHTENING SPECIFICATIONS**

Application	Specification	
	Metric	English
A/C Compressor to Block Bolt	20 N.m	15 lb ft
Balance Shaft Adjustable Chain Guide Bolt	15 N.m	11 lb ft
Balance Shaft Bearing Carrier to Block Bolt	10 N.m	89 lb in
Balance Shaft Fixed Chain Guide Bolt	15 N.m	11 lb ft
Balance Shaft Sprocket Bolt	50 N.m	37 lb ft
Block Heater Bolt	10 N.m	89 lb in
Cam Cover to Cylinder Head Bolt	10 N.m	89 lb in
Cam Cover to Ground Cable Bolt	10 N.m	89 lb in
Cam Cover to Ground Cable Stud	10 N.m	89 lb in
Camshaft Cap Bolt	10 N.m	89 lb in
Camshaft Sprocket Bolt		
• First Pass	85 N.m	63 lb ft
• Final Pass	30 degrees	
Camshaft Timing Chain Tensioner	75 N.m	55 lb ft
Chain Guide Plug	90 N.m	59 lb ft
Connecting Rod Bolt		
• First Pass	25 N.m	18 lb ft
• Final Pass	100 degrees	
Crankshaft Bearings - Lower Crankcase to Block - Bedplate		
• First Pass	20 N.m	15 lb ft
• Final Pass	70 degrees	
Crankshaft Balancer Bolt		
• First Pass	100 N.m	74 lb ft
• Final Pass	125 degrees	
Crankshaft Position Reluctor Ring	15 N.m	11 lb ft
Crankshaft Position Sensor Bolt	10 N.m	89 lb in
Cylinder Head Bolt		
• First Pass	30 N.m	22 lb ft
• Final Pass	155 degrees	

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Cylinder Head Front Chaincase Bolt	35 N.m	26 lb ft
Cylinder Head Oil Gallery Plug	35 N.m	26 lb ft
Drive Belt Tensioner Bolt	45 N.m	33 lb ft
EGR Cover Bolt	25 N.m	18 lb ft
Engine Coolant Temperature Sensor	22 N.m	16 lb ft
Engine Lift Bracket Front Bolt	25 N.m	18 lb ft
Engine Lift Bracket Rear Bolt	25 N.m	18 lb ft
EVAP Purge Solenoid Valve Nut	18 N.m	13 lb ft
Exhaust Manifold to Cylinder Head Nut	14 N.m	124 lb in
Exhaust Manifold to Cylinder Head Stud - 2 passes	10 N.m	89 lb in
Exhaust Manifold Pipe Flange Stud	16 N.m	12 lb ft
Flexplate (AMT) Bolt		
• First Pass	53 N.m	39 lb ft
• Final Pass	25 degrees	
Flywheel (SMT) Bolt		
• First Pass	53 N.m	39 lb ft
• Final Pass	25 degrees	
Front Cover to Block Bolt	25 N.m	18 lb ft
Front Lift Bracket Bolt	25 N.m	18 lb ft
Fuel Pipe Bracket Bolt	10 N.m	89 lb in
Fuel Rail Bracket Bolt	10 N.m	89 lb in
Generator to Block Bolt	23 N.m	17 lb ft
Heat Shield to Exhaust Manifold Bolt	23 N.m	17 lb ft
Ignition Coil Bolt	10 N.m	89 lb in
Intake Camshaft Rear Cap Bolt	25 N.m	18 lb ft
Intake Manifold to Cylinder Head Bolt	10 N.m	89 lb in
Intake Manifold to Cylinder Head Nut	10 N.m	89 lb in
Intake Manifold to Cylinder Head Stud	6 N.m	53 lb in
Knock Sensor Bolt	25 N.m	18 lb ft
Lower Crankcase to Block Perimeter Bolt	25 N.m	18 lb ft
Oil Filter Housing Cover	25 N.m	18 lb ft
Oil Gallery Gerotor Cover - Rear Bolt	6 N.m	53 lb in
Oil Gallery Plug	35 N.m	26 lb ft
Oil Gallery Plug - Rear	60 N.m	44 lb ft
Oil Level Indicator Tube to Intake Manifold Bolt	10 N.m	89 lb in
Oil Pan Drain Plug	25 N.m	18 lb ft
Oil Pan to Block Bolts	25 N.m	18 lb ft
Oil Pressure Switch	26 N.m	19 lb ft
Oil Pump Cover Bolt	6 N.m	53 lb in
Oil Pump Pressure Relief Valve Plug	40 N.m	30 lb ft

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Oxygen Sensor	42 N.m	31 lb ft
Power Steering Pump Bolt	25 N.m	18 lb ft
Spark Plug	20 N.m	15 lb ft
Starter Motor to Block Bolt	53 N.m	39 lb ft
Thermostat Housing to Block Bolts	10 N.m	89 lb in
Throttle Body Bolt	10 N.m	89 lb in
Timing Adjustable Chain Guide Bolt	10 N.m	89 lb in
Timing Chain Oil Nozzle Bolt	10 N.m	89 lb in
Timing Fixed Chain Guide Bolt	15 N.m	11 lb ft
Timing Upper Chain Guide Bolt	10 N.m	89 lb in
Vent Tube to Cylinder Head	15 N.m	11 lb ft
Water Jacket Drain Plug	20 N.m	15 lb ft
Water Pump Access Cover Bolt	7 N.m	62 lb in
Water Pump/Balance Shaft Chain Tensioner Bolt	10 N.m	89 lb in
Water Pump Bolts	25 N.m	18 lb ft
Water Pump Sprocket Bolt	10 N.m	89 lb in

ENGINE MECHANICAL SPECIFICATIONS**Engine Mechanical Specifications**

Application	Specification	
	Metric	English
General Data		
• Engine Type	Inline 4 Cylinder	
• Displacement	2.2 L	134 CID
• RPO	L61	
• Liter (VIN)	F	
• Bore	85.992-86.008 mm	3.3855-3.3861 in
• Stroke	94.6 mm	3.727 in
• Compression Ratio	10.0:1	
Balance Shaft		
• Bearing Clearance	0.030-0.060 mm	0.0012-0.0024 in
• Bearing Diameter - Inside - Carrier	20.050-20.063 mm	0.7894-0.7899 in
• Bearing Diameter - Outside - Carrier	41.975-41.995 mm	1.6526-1.6534 in
• Bearing Journal Diameter	20.000-20.020 mm	0.7874-0.7882 in
• Bushing Clearance	0.033-0.102 mm	0.0013-0.0040 in
• Bushing Diameter - Inside	36.776-36.825 mm	1.4479-1.4498 in
• Bushing Journal Diameter	36.723-36.743 mm	1.4458-1.4466 in

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• End Play	0.050-0.300 mm	0.0020-0.0118 in
Block		
• Balance Shaft Bearing Bore Diameter - Carrier	42.000-42.016 mm	1.6535-1.6542 in
• Balance Shaft Bushing Bore Diameter	40.763-40.776 mm	1.6048-1.6054 in
• Crankshaft Main Bearing Bore Diameter	64.068-64.082 mm	2.5224-2.5229 in
• Cylinder Bore Diameter	85.992-86.008 mm	3.3855-3.3861 in
• Cylinder Bore Out-of-Round - Maximum	0.010 mm	0.0004 in
• Cylinder Bore Taper - Maximum	0.010 mm	0.0004 in
• Cylinder Head Deck Surface Flatness - Transverse	0.030 mm	0.0012 in
• Cylinder Head Deck Surface Flatness - Longitude	0.050 mm	0.002 in
• Cylinder Head Deck Surface Flatness - Overall	0.08 mm	0.0031 in
Camshaft		
• Camshaft End Play	0.040-0.144 mm	0.0016-0.0057 in
• Camshaft Journal Diameter	26.935-26.960 mm	1.0604-1.0614 in
• Camshaft Thrust Surface	21.000-21.052 mm	0.8268-0.8252 in
Connecting Rod		
• Connecting Rod Bearing Clearance	0.029-0.073 mm	0.0011-0.0029 in
• Connecting Rod Bore Diameter - Bearing End	52.118-52.134 mm	2.0519-2.05252 in
• Connecting Rod Bore Diameter - Pin End	20.007-20.021 mm	0.7877-0.7882 in
• Connecting Rod Side Clearance	0.070-0.370 mm	0.0028-0.0146 in
• Connecting Rod Straightness - Bend - Maximum	0.021 mm	0.0083 in
• Connecting Rod Straightness - Twist - Maximum	0.04 mm	0.0157 in
Crankshaft		
• Connecting Rod Journal Diameter	49.000-49.014 mm	1.9291-1.9297 in
• Crankshaft End Play	0.050-0.380 mm	0.0012-0.0150 in
• Crankshaft Main Bearing Clearance	0.031-0.067 mm	0.0012-0.0026 in
• Crankshaft Main Journal Diameter	55.994-56.008 mm	2.2045-2.2050 in
Cylinder Head		
• Surface Flatness - Block Deck - Transverse	0.030 mm	0.0012 in
• Surface Flatness - Block Deck - Longitude	0.050 mm	0.002 in
• Surface Flatness - Block Deck - Overall	0.1 mm	0.004 in
• Valve Guide Bore - Exhaust	6.000-6.012 mm	0.2362-0.2367 in
• Valve Guide Bore - Intake	6.000-6.012 mm	0.2362-0.2367 in
• Valve Lifter Bore Diameter - Stationary Lash	12.013-12.037 mm	0.4730-0.4739 in

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Adjusters		
Lubrication System		
• Oil Pressure - Minimum - @1000 RPM	344.75-551.60 kPa	50-80 psi
• Oil Capacity	4.8L	5.0 quarts
Piston Rings		
• Piston Ring End Gap - First Compression Ring	0.20-0.40 mm	0.008-0.016 in
• Piston Ring End Gap - Second Compression Ring	0.35-0.55 mm	0.014-0.022 in
• Piston Ring End Gap - Oil Control Ring - Rails	0.25-0.76 mm	0.010-0.030 in
• Piston Ring to Groove Clearance - First Compression Ring	0.04-0.08 mm	0.0015-0.0031 in
• Piston Ring to Groove Clearance - Second Compression Ring	0.030-0.069 mm	0.0012-0.0027 in
• Piston Ring to Groove Clearance - Oil Control Ring	0.043-0.192 mm	0.0017-0.0076 in
• Piston Ring Thickness - First Compression Ring	1.170-1.190 mm	0.0461-0.0469 in
• Piston Ring Thickness - Second Compression Ring	1.471-1.490 mm	0.0579-0.0587 in
• Piston Ring Thickness - Oil Control Ring - Rail - Maximum	0.43 mm	0.0169 in
• Piston Ring Thickness - Oil Control Ring - Spacer	1.574-1.651 mm	0.0620-0.0650 in
Pistons and Pins		
• Pin - Piston Pin Clearance to Connecting Rod Bore	0.007-0.026 mm	0.0003-0.0010 in
• Pin - Piston Pin Clearance to Piston Pin Bore	0.002-0.012 mm	0.0001-0.0005 in
• Pin - Piston Pin Diameter	19.995-20.000 mm	0.7872-0.7874 in
• Pin - Piston Pin End Play	0.210-1.266 mm	0.0083-0.0498 in
• Piston - Piston Diameter - @14.5 mm up	85.967-85.982 mm	3.3845-3.3851 in
• Piston - Piston Pin Bore Diameter	20.002-20.007 mm	0.07875-0.07877 in
• Piston - Piston Ring Groove Width - Top	1.23-1.25 mm	0.0484-0.0492 in
• Piston - Piston Ring Groove Width - Second	1.52-1.54 mm	0.0598-0.0606 in
• Piston - Piston Ring Groove Width - Oil Control	2.52-2.54 mm	0.0992-0.1000 in
• Piston - Piston To Bore Clearance	0.010-0.041 mm	0.0004-0.0016 in
Valve System		
• Valve Lifters - Valve Lifter Diameter - Stationary Lash Adjuster	11.986-12.000 mm	0.0005-0.0020 in
• Valve Lifters - Valve Lifter-to-Bore Clearance - Stationary Lash Adjuster	0.013-0.051 mm	3.2210-3.2299 in
• Valve Springs - Valve Spring Load - Closed - @32.5 mm	245.0-271.0 N. - Eng Spec.	

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• Valve Springs - Valve Spring Load - Open - @22.5 mm	525.0-575.0 N. - Eng Spec.	
• Valves - Valve Face Runout - Maximum	0.04 mm	0.0016 in
• Valves - Valve Seat Runout - Maximum	0.05 mm	0.0020 in
• Valves - Valve Stem Diameter - Intake	5.955-5.970 mm	0.2344-0.2355 in
• Valves - Valve Stem Diameter - Exhaust	5.935-5.950 mm	0.2337-0.2343 in
• Valves - Valve Stem to Guide Clearance - Intake	0.030-0.057 mm	0.0012-0.0022 in
• Valves - Valve Stem to Guide Clearance - Exhaust	0.050-0.077 mm	0.0020-0.0026 in

ADHESIVES, FLUIDS, LUBRICANTS, AND SEALERS

Application	Type of Material	GM Part Number	
		United States	Canada
# 6 Intake Rear Camshaft Cap	Sealant	12378521	88901148
Balance Shaft Bearings	Engine Oil	12345610	993193
Cam Lobes	Engine Oil	12345610	993193
Crank Sensor O-ring	Engine Oil	12345610	993193
Cylinder Bores	Engine Oil	12345610	993193
Cylinder Head Plugs	Sealant	12345382	10953489
Engine Block Threaded Plugs	Sealant	12346004	10953480
Engine Block to Bedplate	Sealant	12378521	88901148
Engine Oil Level Indicator Tube O-ring	Lubricant	12345501	992704
Fuel Injector O-rings	Engine Oil	12345610	993193
Fuel Injector Tip Insulators	Engine Oil	12345610	993193
Intake and Exhaust Valve Stems	Lubricant	12345501	992704
Main Bearings	Lubricant	12345501	992704
Oil Filter Cap - Threads and O-ring Lead-in Chamfers	Engine Oil	12345610	993193
Oil Pan to Bedplate Joint	Sealant	12378521	88901148
Oil Pump - Pump Elements	Engine Oil	12345610	993193
Oxygen Sensor Threads	Anti-seize	12397953	-
Piston Pin to Piston/Rod - Pin Bores of Piston and Rod	Engine Oil	12345610	993193
Rod Bearings - Rod Pins of Crankshaft	Engine Oil	12345610	993193
Stationary Hydraulic Lash Adjusters	Lubricant	12345501	992704
Timing Chain Guide Bolt Access Hole Plug	Sealant	12345382	10953489
Valve Rocker Arm/Valve Tip	Lubricant	12345501	992704
Water Feed Tube O-rings	Lubricant	12345579	1974984
Water Pump Drain Plug	Sealant	12346004	10953480

THREAD REPAIR SPECIFICATIONS

Engine Block - Front View

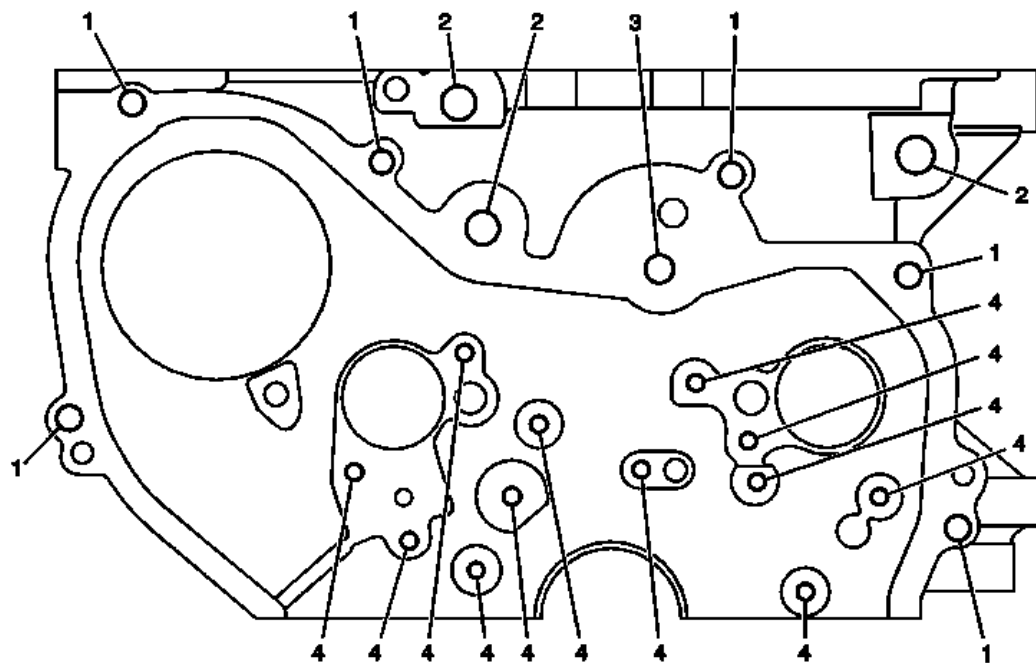


Fig. 1: Identifying Bolt Size & Locations On Engine Block - Front View
Courtesy of GENERAL MOTORS CORP.

Engine Block - Front View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	23.5	0.93	18.5	0.73
2	M12 x 1.75	855	856	857	858	859	33.5	1.32	26.5	1.04
3	M10 x 1.5	215	211	212	213	214	24.5	0.96	19.5	0.77
4	M6 x 1	205	201	202	203	204	20	0.787	16	0.63

Engine Block - Back View

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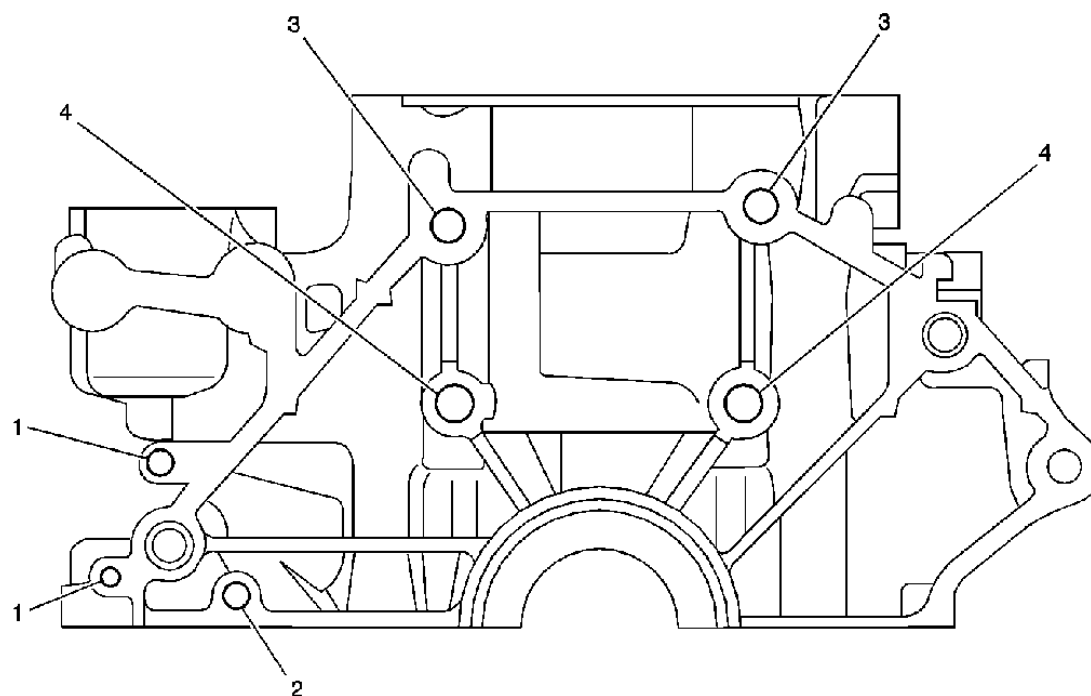


Fig. 2: Identifying Bolt Size & Locations On Engine Block - Back View
 Courtesy of GENERAL MOTORS CORP.

Engine Block - Back View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	18	0.709	THRU	
2	M10 x 1.5	215	211	212	213	214	29	1.161	THRU	
3	M12 x 1.75	855	856	857	858	859	39	1.535	33.5	1.32
4	M16 x 1.5	860	861	862	863	864	21	0.827	15	0.59

Engine Block - Left Side View

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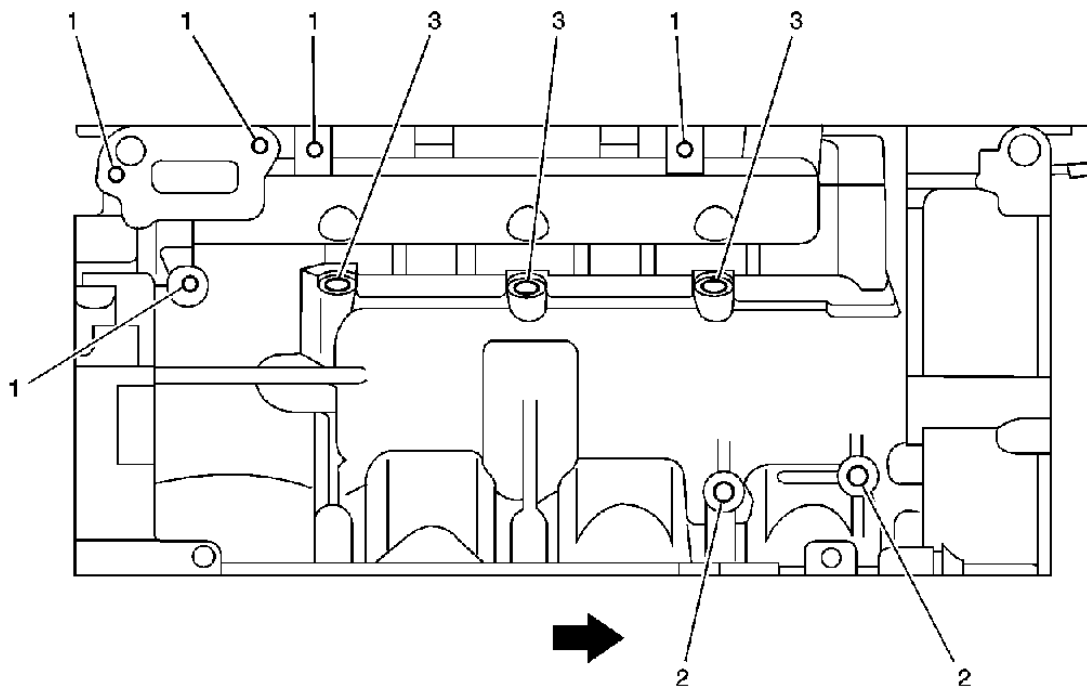


Fig. 3: Identifying Bolt Size & Locations On Engine Block - Left Side
Courtesy of GENERAL MOTORS CORP.

Engine Block - Left Side View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M6 x 1	205	201	202	203	204	20.5	0.807	16	0.63
2	M10 x 1.5	215	211	212	213	214	23.5	0.925	18.5	0.73
3	M12 x 1.75	865	856	857	858	859	19.5	0.768	12.5	0.49

Engine Block - Bottom View

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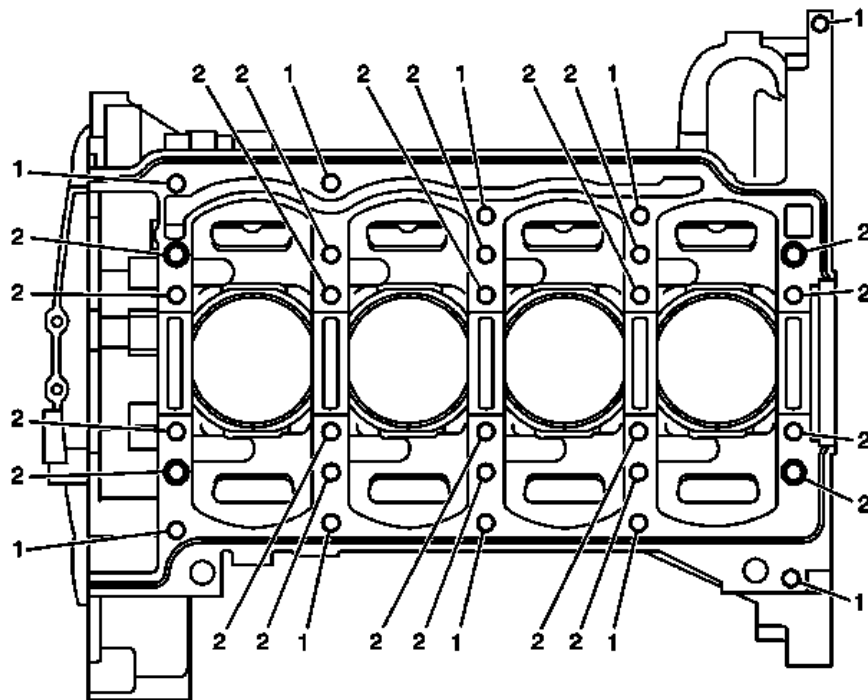


Fig. 4: Identifying Bolt Size & Locations On Engine Block - Bottom
Courtesy of GENERAL MOTORS CORP.

Engine Block - Bottom View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
							MM	(IN)	MM	(IN)
		J 42385-850								
1	M8 x 1.25	210	206	207	208	209	28	1.102	22	0.87
2	M10 x 1.5	514	511	N/A	512	513	60	2.362	53.5	2.11

Engine Block - Right Side View

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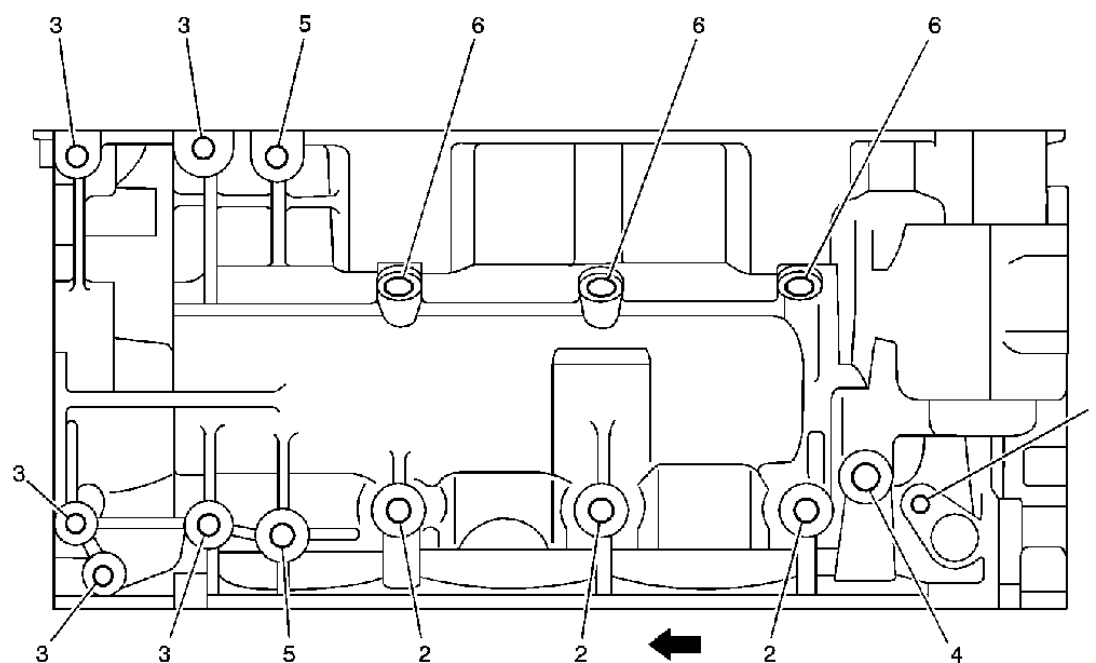


Fig. 5: Identifying Bolt Size & Locations On Engine Block - Right Side
 Courtesy of GENERAL MOTORS CORP.

Engine Block - Right Side View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M6 x 1	205	201	202	203	204	20.5	0.807	16.5	0.65
2	M8 x 1.25	210	206	207	208	209	23.5	0.925	18	0.71
3	M8 x 1.25	210	206	207	208	209	30.5	1.201	22.5	0.89
4	M12 x 1.75	865	856	857	858	859	15.5	0.61	12.5	0.49
5	M12 x 1.75	855	856	857	858	859	33.5	1.319	26.5	1.04
6	M12 x 1.75	865	856	857	858	859	19.5	0.778	12.5	0.49

Engine Block - Top View

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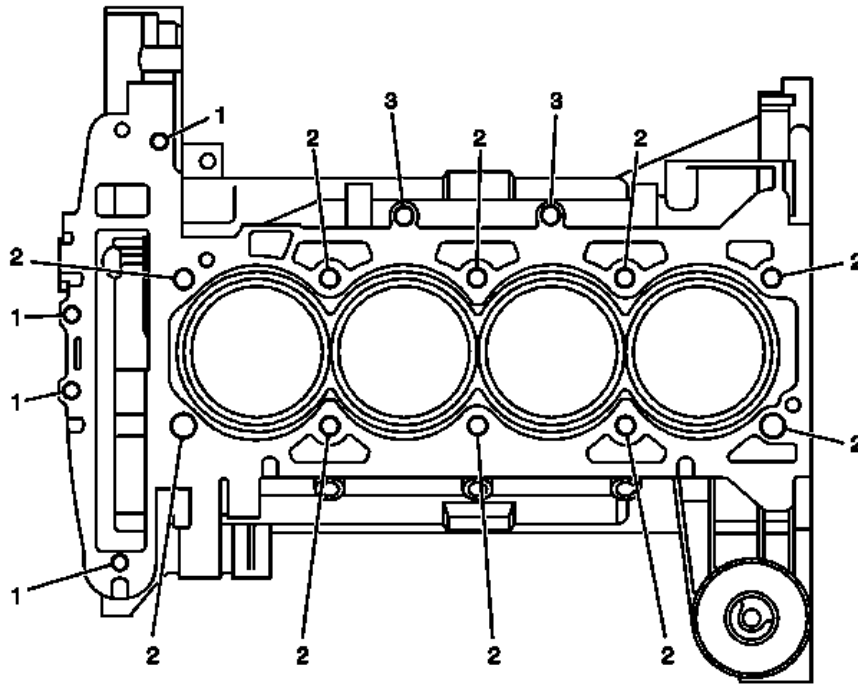


Fig. 6: Identifying Bolt Size & Locations On Engine Block - Top
Courtesy of GENERAL MOTORS CORP.

Engine Block - Top View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	23.5	0.925	18.5	0.73
2	M11 x 1.5	507	504	N/A	505	506	113.3	4.461	107.3	4.22
3	M12 x 1.75	865	856	857	858	859	13.5	0.531	12.5	0.49

Lower Crankcase - Front View

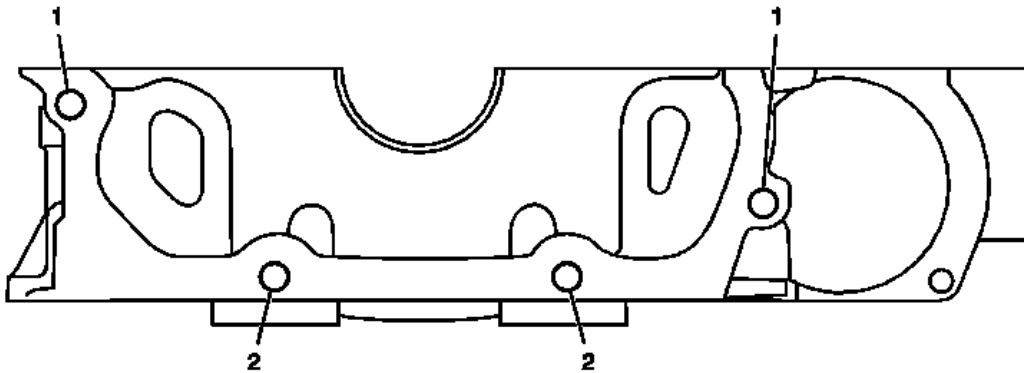


Fig. 7: Identifying Bolt Size & Locations On Engine Block - Top
Courtesy of GENERAL MOTORS CORP.

Lower Crankcase - Front View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	23.5	0.925	18.5	0.73
2	M8 x 1.25	210	206	207	208	209	30.5	1.201	25.5	1.00

Lower Crankcase - Back View

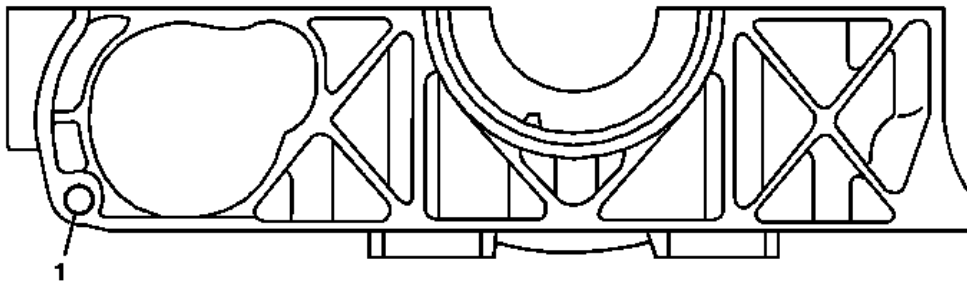


Fig. 8: Identifying Bolt Size & Locations On Lower Crankcase - Back
Courtesy of GENERAL MOTORS CORP.

Lower Crankcase - Back View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)	Tap Depth (Maximum)
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J 42385-850							MM	(IN)	MM	(IN)
1	M10 x 1.5	215	211	212	213	214	29.5	1.161	THRU	

Lower Crankcase - Bottom View

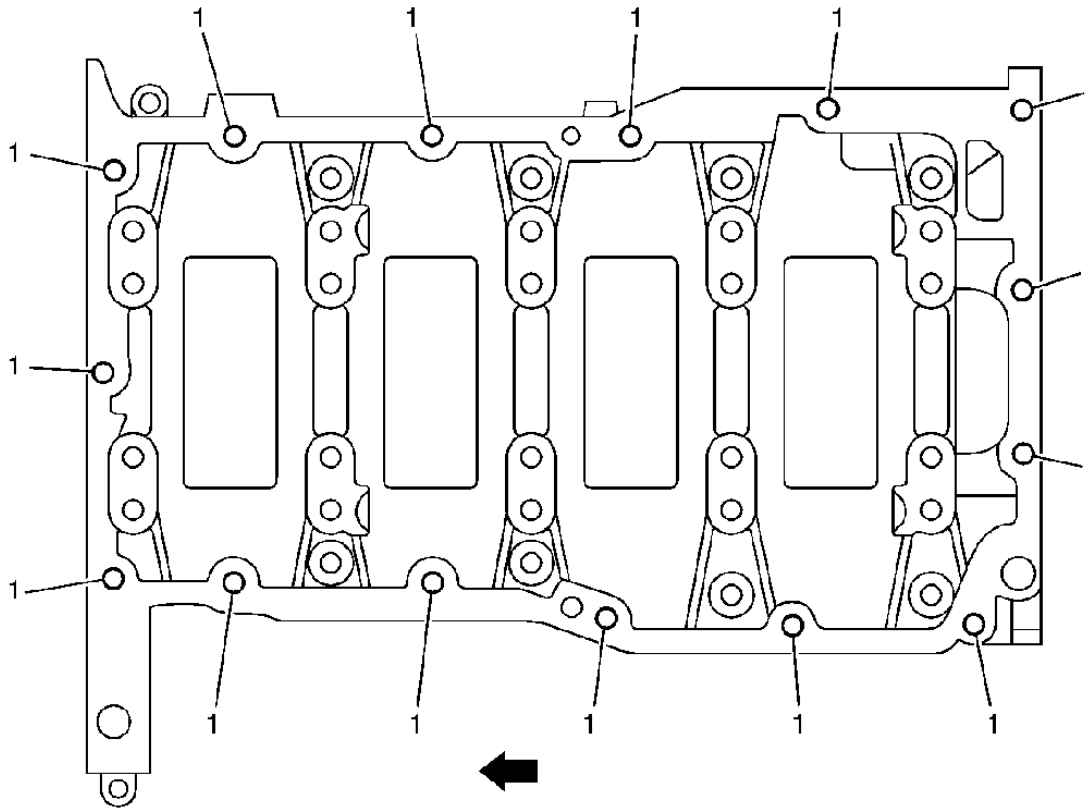


Fig. 9: Identifying Bolt Size & Locations On Lower Crankcase - Bottom
Courtesy of GENERAL MOTORS CORP.

Lower Crankcase - Bottom View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	23.5	0.925	18.5	0.73

Lower Crankcase - Left View

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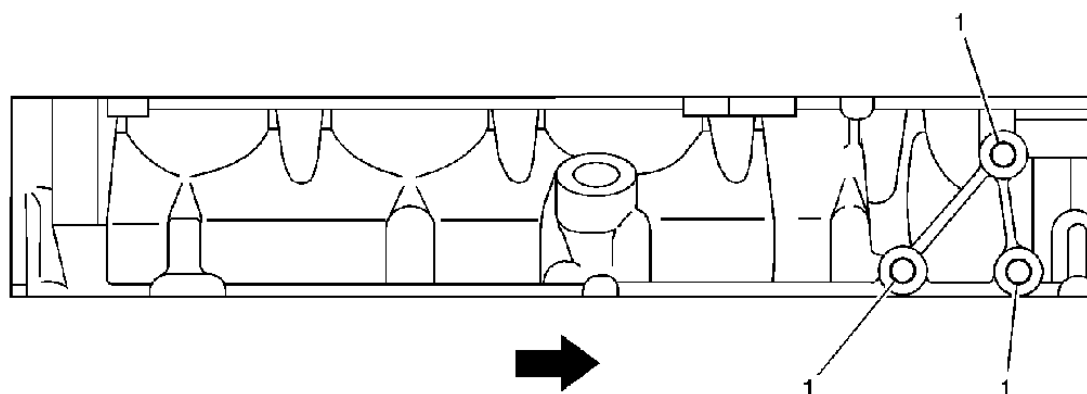


Fig. 10: Identifying Bolt Size & Locations On Lower Crankcase - Bottom
Courtesy of GENERAL MOTORS CORP.

Lower Crankcase - Left View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M10 x 1.5	215	211	212	213	214	28.5	1.122	22.5	0.89

Lower Crankcase - Right View

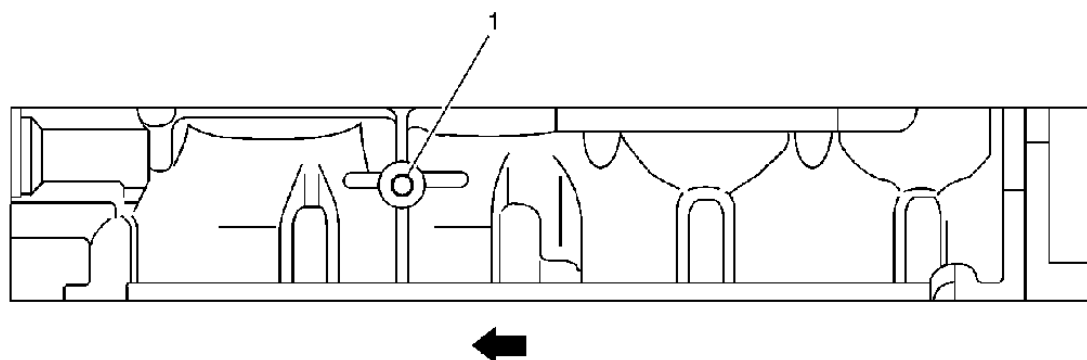


Fig. 11: Identifying Bolt Size & Locations On Lower Crankcase - Right
Courtesy of GENERAL MOTORS CORP.

Lower Crankcase - Right View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	211	212	213	214	30.5	1.201	22.5	0.886

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Cylinder Head - Top View

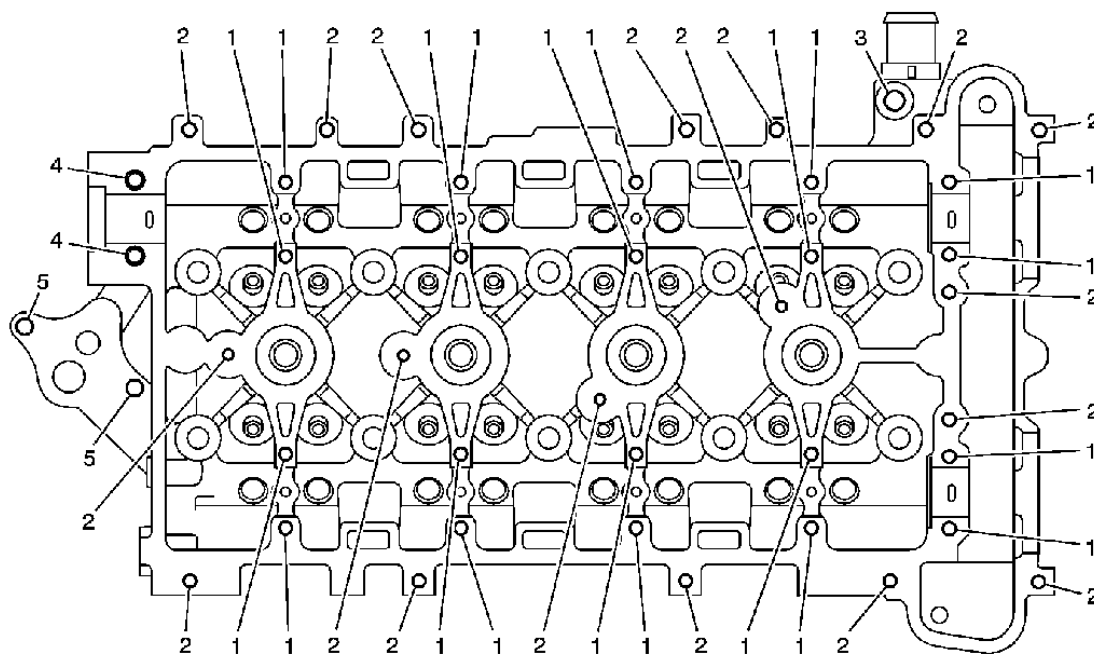


Fig. 12: Identifying Bolt Sizes & Locations On Cylinder Head - Top
Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Top View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M6 x 1	205	852	N/A	203	204	24	0.945	20	0.787
2	M6 x 1	205	201	202	203	204	20	0.787	16	0.63
3	M8 x 1.25	854	206	207	208	209	THRU		THRU	
4	M8 x 1.25	854	853	N/A	208	209	25	0.984	20	0.787
5	M8 x 1.25	210	206	207	208	209	25	0.984	20	0.787

Cylinder Head - Intake Manifold Deck View

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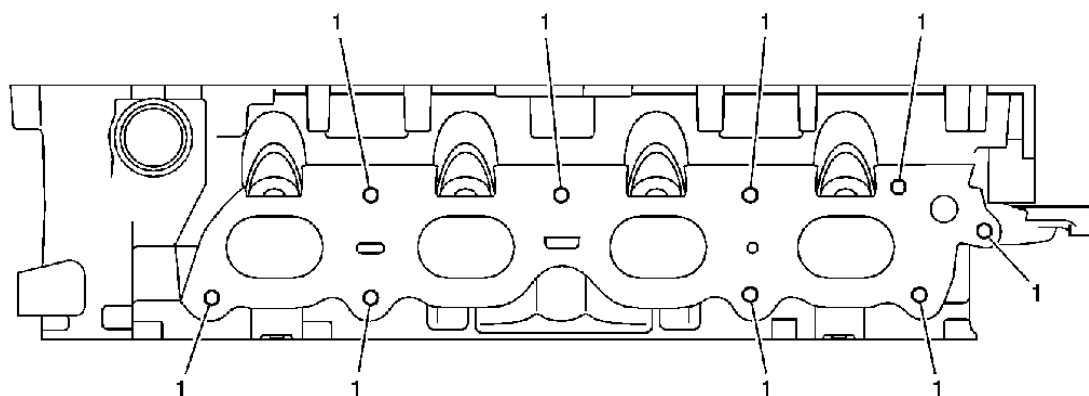


Fig. 13: Identifying Bolt Size & Locations On Cylinder Head - Intake Manifold Deck
Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Intake Manifold Deck View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M6 x 1	205	201	202	203	204	20	0.787	16	0.63

Cylinder Head - Exhaust Manifold Deck View

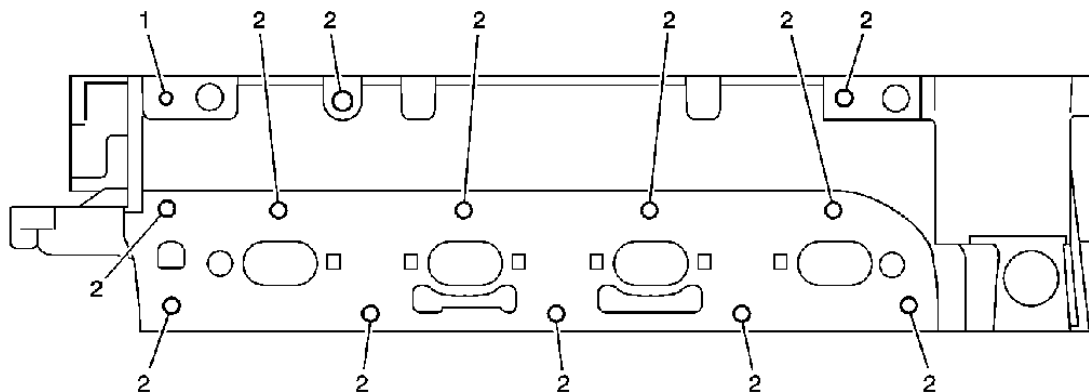


Fig. 14: Identifying Bolt Size & Locations On Cylinder Head - Exhaust Manifold Deck
Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Exhaust Manifold Deck View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)

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1	M6 x 1	205	201	202	203	204	20	0.78	16	0.63
2	M8 x 1.25	210	206	207	208	209	25	0.984	20	0.78

Cylinder Head - Front View

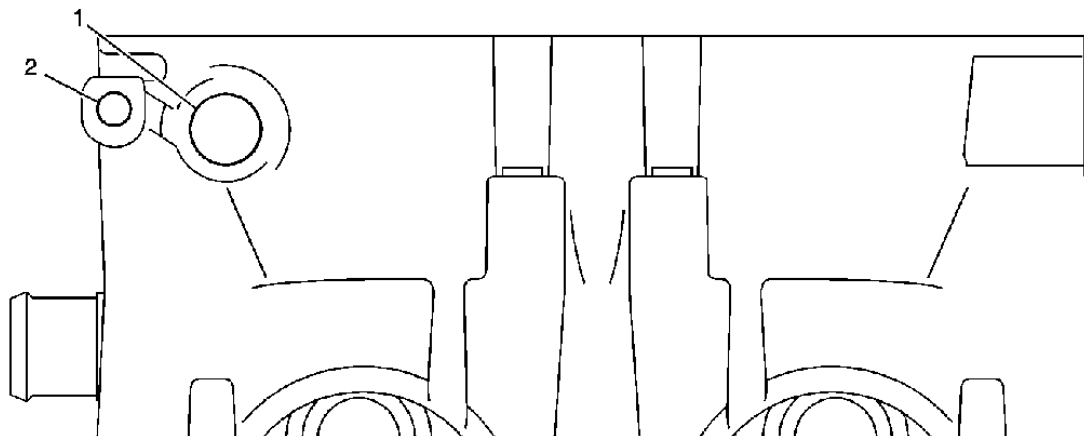


Fig. 15: Identifying Bolt Size & Locations On Cylinder Head - Front
Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Front View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M6 x 1	205	201	202	203	204	20	0.787	16	0.63
2	M8 x 1.25	210	206	207	208	209	25	0.984	20	0.787

Cylinder Head - Back View

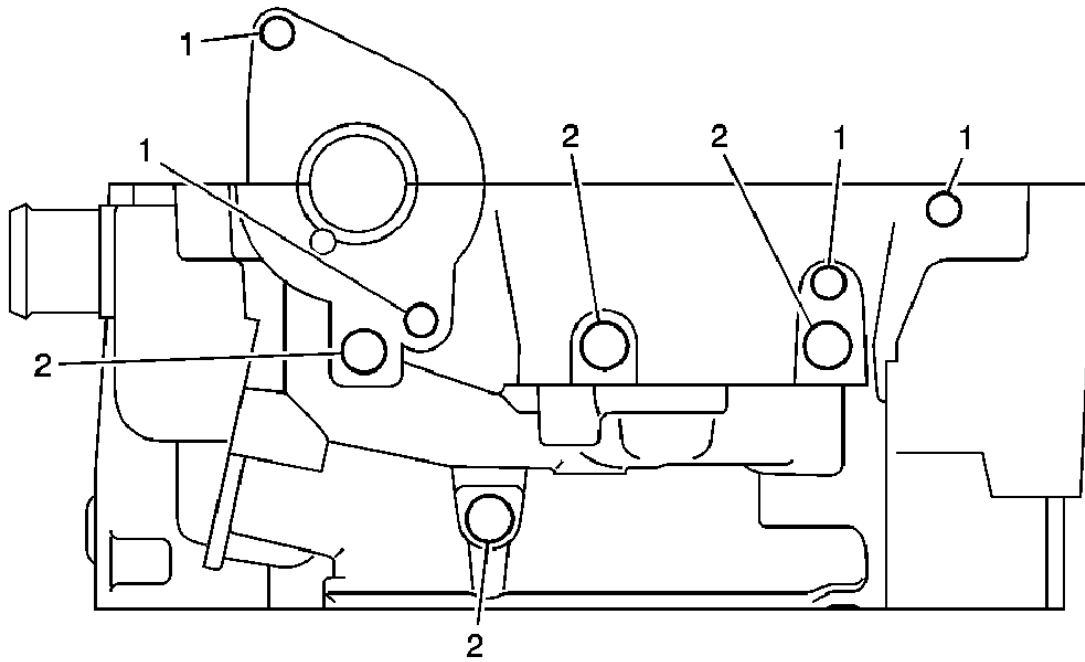


Fig. 16: Identifying Bolt Size & Locations On Cylinder Head - Back
 Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Back View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M8 x 1.25	210	206	207	208	209	25	0.984	20	0.787
2	M12 x 1.75	865	856	857	858	859	17	0.67	14	0.551

Cylinder Head - Bottom View

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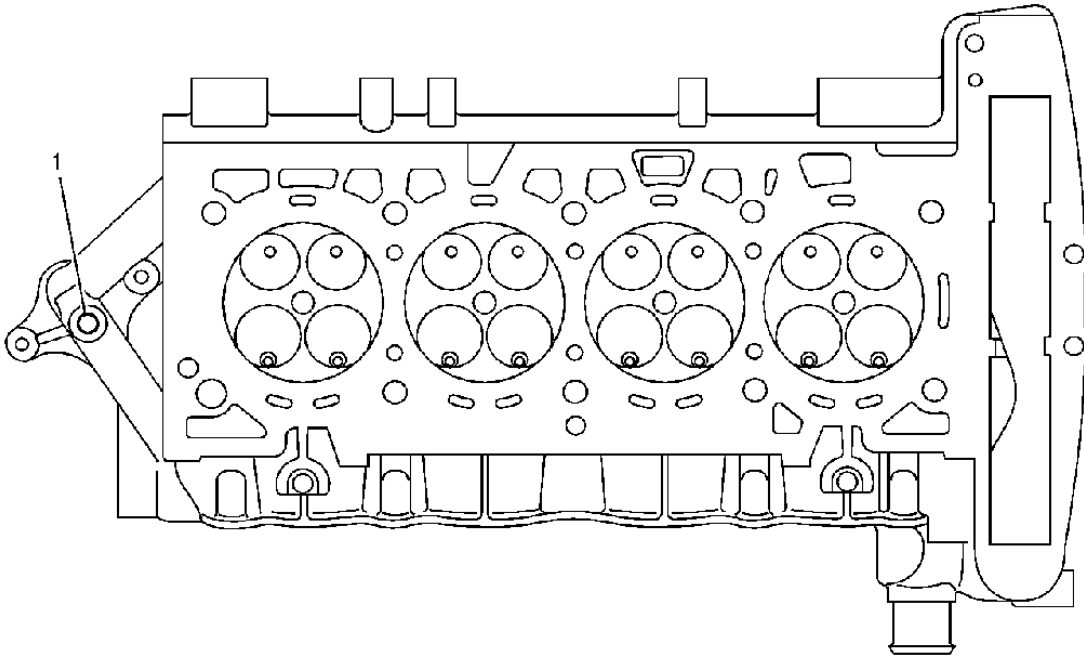


Fig. 17: Identifying Bolt Size & Locations On Cylinder Head - Bottom
Courtesy of GENERAL MOTORS CORP.

Cylinder Head - Bottom View

Service Call Out	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth (Maximum)		Tap Depth (Maximum)	
J 42385-850							MM	(IN)	MM	(IN)
1	M12 x 1.75	865	856	857	858	859	17	0.67	14	0.551

COMPONENT LOCATOR

DISASSEMBLED VIEWS

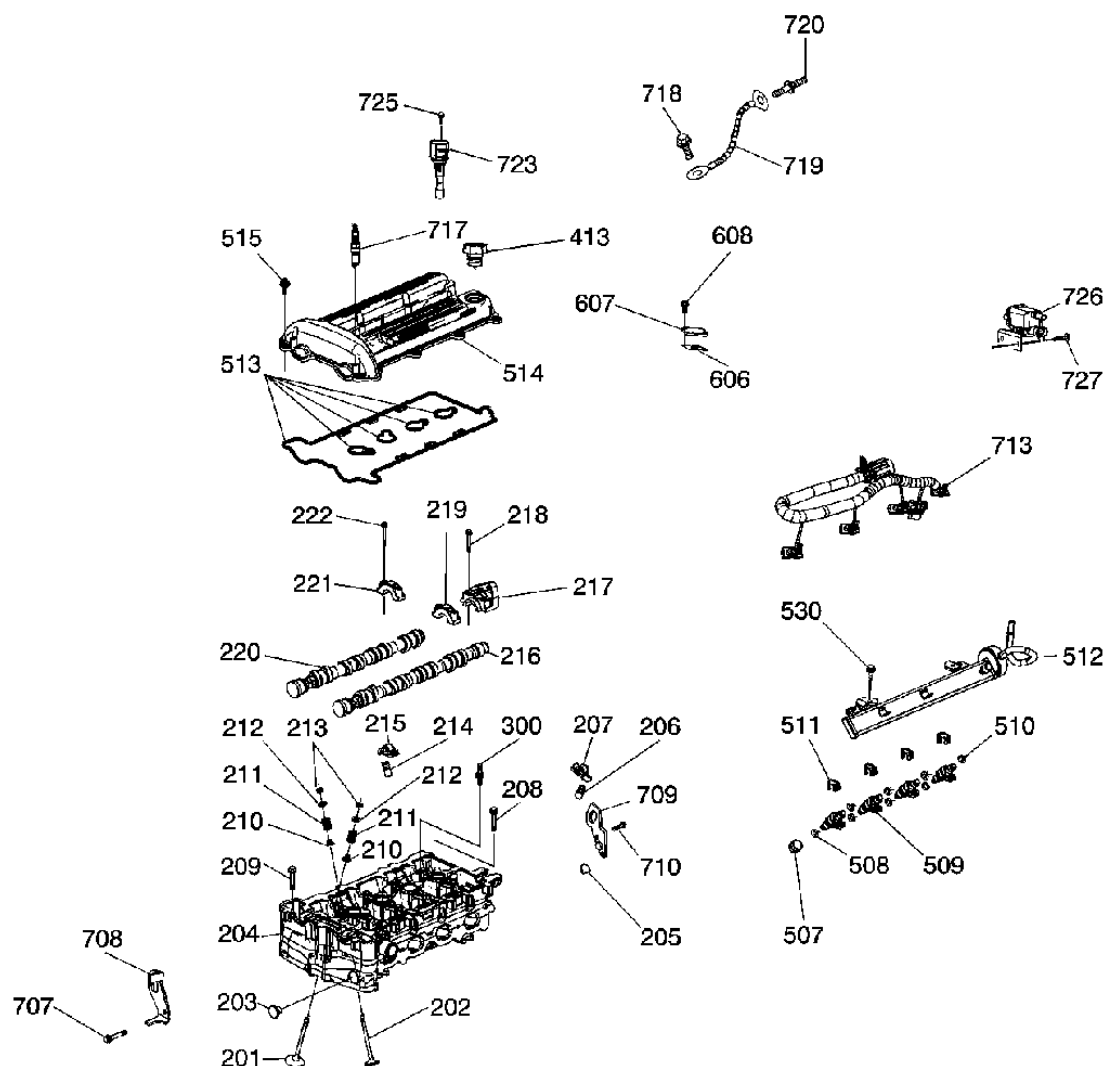


Fig. 18: Cylinder Head and Components
Courtesy of GENERAL MOTORS CORP.

Callout	Component Name
201	Exhaust Valve
202	Intake Valve
203	Timing Chain Guide Bolt Access Hole
204	Cylinder Head
205	Cylinder Head Gallery Plug
206	Hydraulic Lash Adjuster
207	Roller Finger Follower
208	Cylinder Head Bolt
209	Small Cylinder Head Bolt
210	Valve Stem Seal

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210	Valve Stem Seal
211	Valve Spring
211	Valve Spring
212	Valve Spring Retainer
212	Valve Spring Retainer
213	Valve Keys
214	Hydraulic Lash Adjuster
215	Roller Finger Follower
216	Intake Camshaft
217	Camshaft Rear Cap
218	Camshaft Rear Cap Bolt
219	Camshaft Cap
220	Exhaust Camshaft
221	Camshaft Cap
222	Camshaft Cap Bolt
300	Coolant Air Bleed Fitting
413	Engine Oil Fill Cap
507	Fuel Injector Rotator Cup
508	Fuel Injector O-Ring
509	Fuel Injector
510	Fuel Injector O-Ring
511	Fuel Injector Clip
512	Fuel Rail
513	Camshaft Cover Gasket
514	Camshaft Cover
515	Camshaft Cover Bolt
530	Fuel Rail Bolt
606	EGR Port Cover Gasket
607	EGR Port Cover
608	EGR Port Cover Bolt
707	Front Lift Bracket Bolt
708	Front Lift Bracket
709	Rear Lift Bracket
710	Rear Lift Bracket Bolt
713	Fuel Injector Wiring Harness
717	Spark Plug
718	Ground Strap Bolt
719	Ground Strap
720	Ground Strap Bolt Stud
723	Ignition Coil
725	Ignition Coil Bolt
726	

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	EVAP Purge Valve
727	EVAP Purge Valve Bolt

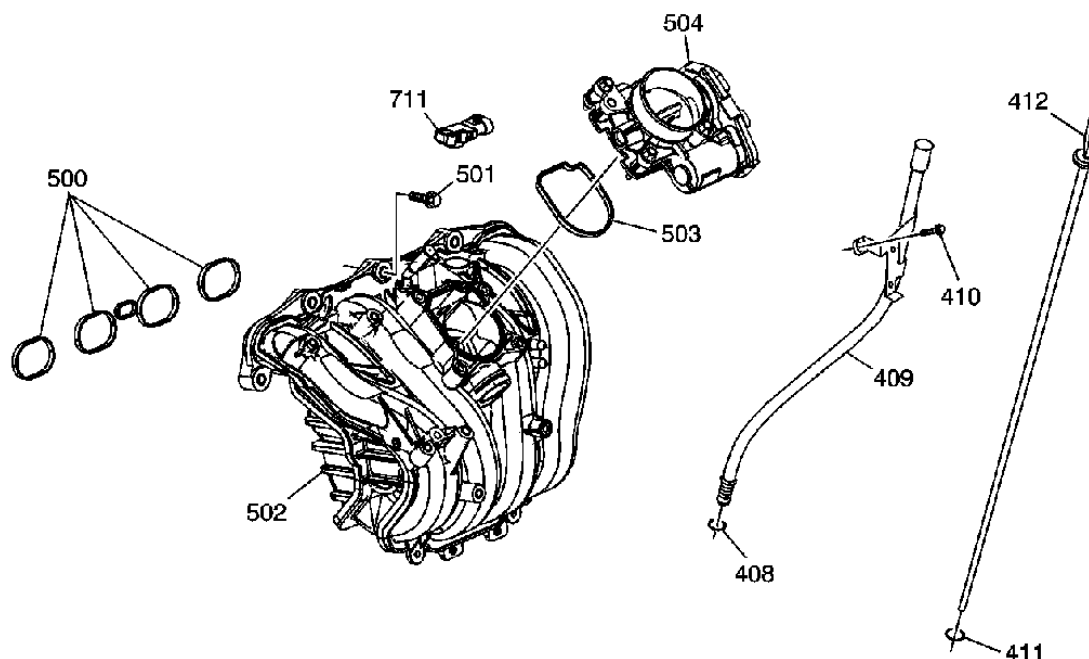


Fig. 19: Intake Manifold and Components
Courtesy of GENERAL MOTORS CORP.

Callout	Component Name
408	Oil Indicator Tube O-Ring
409	Oil Indicator Tube
410	Oil Indicator Tube Bolt
411	Oil Indicator O-Ring
412	Oil Indicator
500	Intake Manifold Gasket
501	Intake Manifold Bolt
502	Intake Manifold
503	Throttle Body Gasket
504	Throttle Body
711	Map Sensor

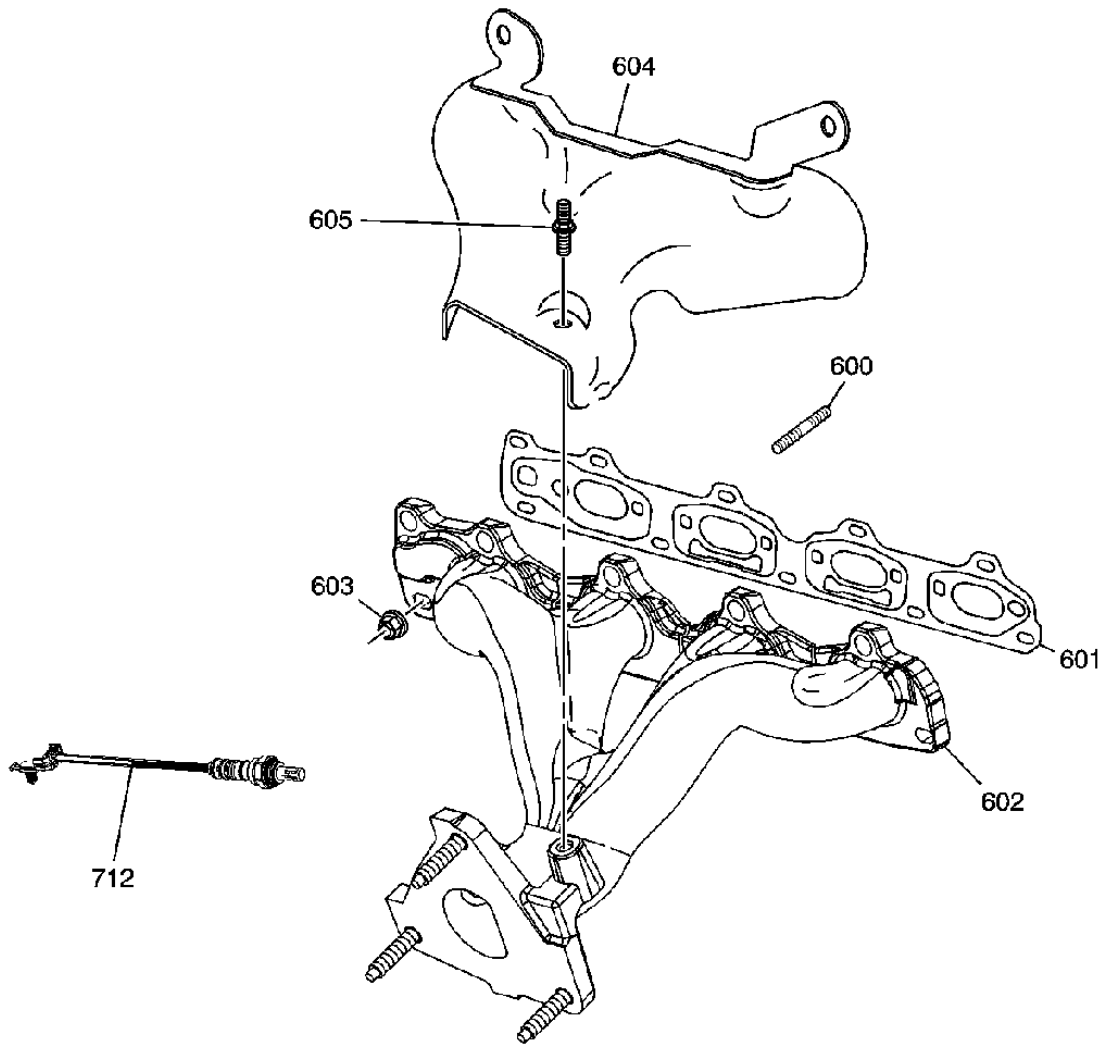


Fig. 20: Exhaust Manifold and Components
Courtesy of GENERAL MOTORS CORP.

Callout	Component Name
600	Exhaust Manifold Stud
601	Exhaust Manifold Gasket
602	Exhaust Manifold and Catalytic Converter Assembly
603	Exhaust Manifold Nut
604	Exhaust Manifold Heat Shield
605	Exhaust Manifold Heat Shield Stud
712	Oxygen Sensor

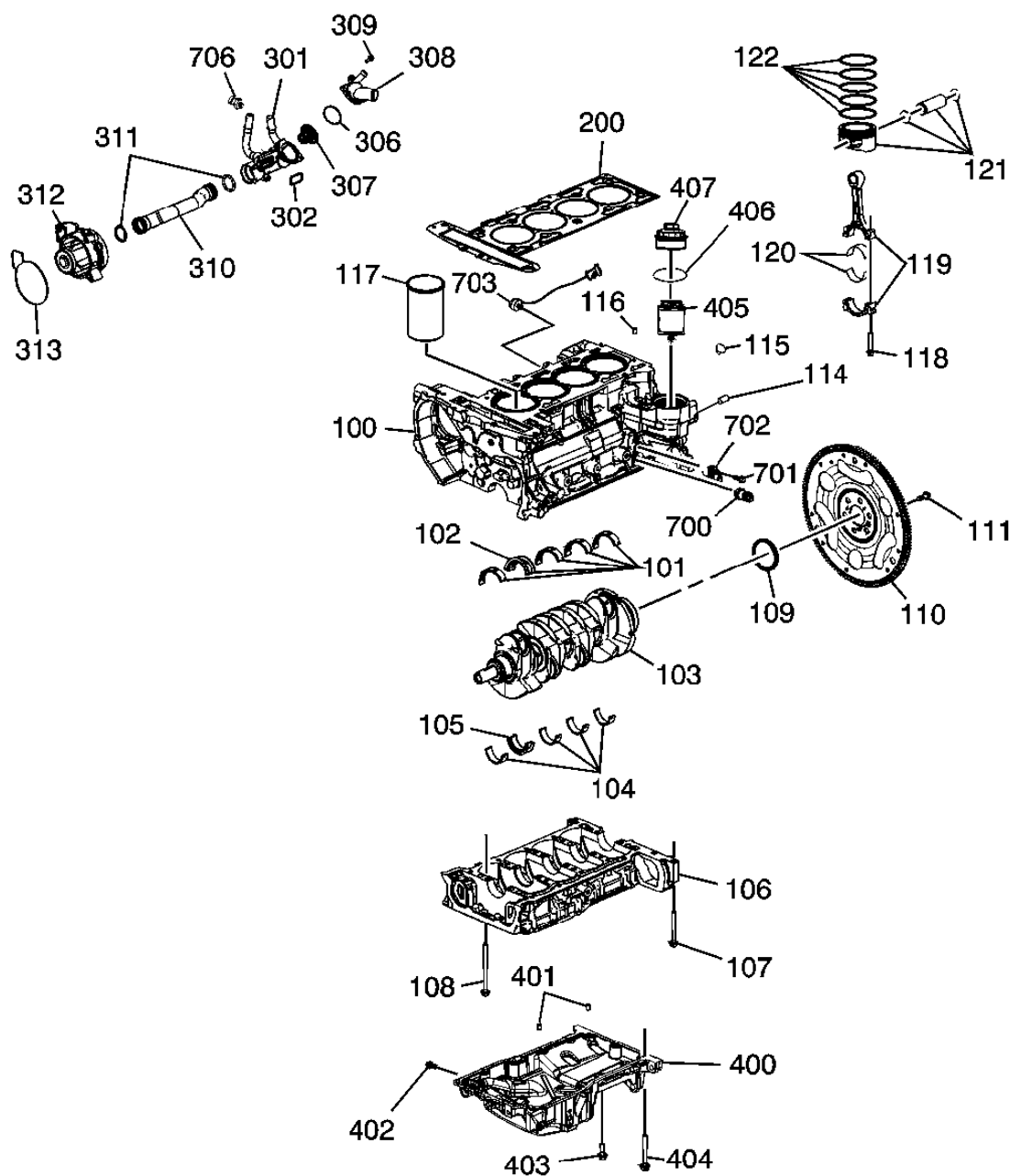


Fig. 21: Engine Block and Components
Courtesy of GENERAL MOTORS CORP.

Callout	Component Name
100	Engine Block
101	Crankshaft Bearing - Upper
102	Crankshaft Thrust Bearing - Upper
103	Crankshaft
104	Crankshaft Bearing - Lower

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105	Crankshaft Thrust Bearing - Lower
106	Lower Crankcase
107	Lower Crankcase Perimeter Bolt
108	Lower Crankcase Main Bearing Bolt
109	Crankshaft Rear Seal
110	Flywheel - Automatic Transmission
111	Automatic Transaxle Flywheel to Crankshaft Bolt
114	Engine Block to Transaxle Alignment Pin
115	Engine Block Gallery Plug
116	Cylinder Head Alignment Pin
117	Cylinder Bore Sleeve
118	Connecting Rod Cap Bolt
119	Connecting Rod
120	Connecting Rod Bearing
121	Piston Assembly
122	Piston Ring Assembly
200	Cylinder Head Gasket
301	Thermostat Housing
302	Thermostat Housing to Block Gasket
306	Thermostat Gasket
307	Thermostat
308	Thermostat Housing Cap
309	Thermostat Housing Cap Bolt
310	Water Transfer Pipe
311	Water Transfer Pipe O-Ring Seals
312	Water Pump
313	Water Pump to Engine Block Seal
400	Engine Oil Pan
401	Engine Oil Pan Alignment Pins
402	Engine Oil Pan Drain Plug
403	Engine Oil Pan Bolt
404	Engine Oil Pan Long Bolt
405	Oil Filter
406	Oil Filter Cap O-Ring
407	Oil Filter Cap
700	Oil Pressure Switch
701	Crankshaft Position Sensor Bolt
702	Crankshaft Position Sensor
703	Knock Sensor
706	Coolant Temperature Sensor

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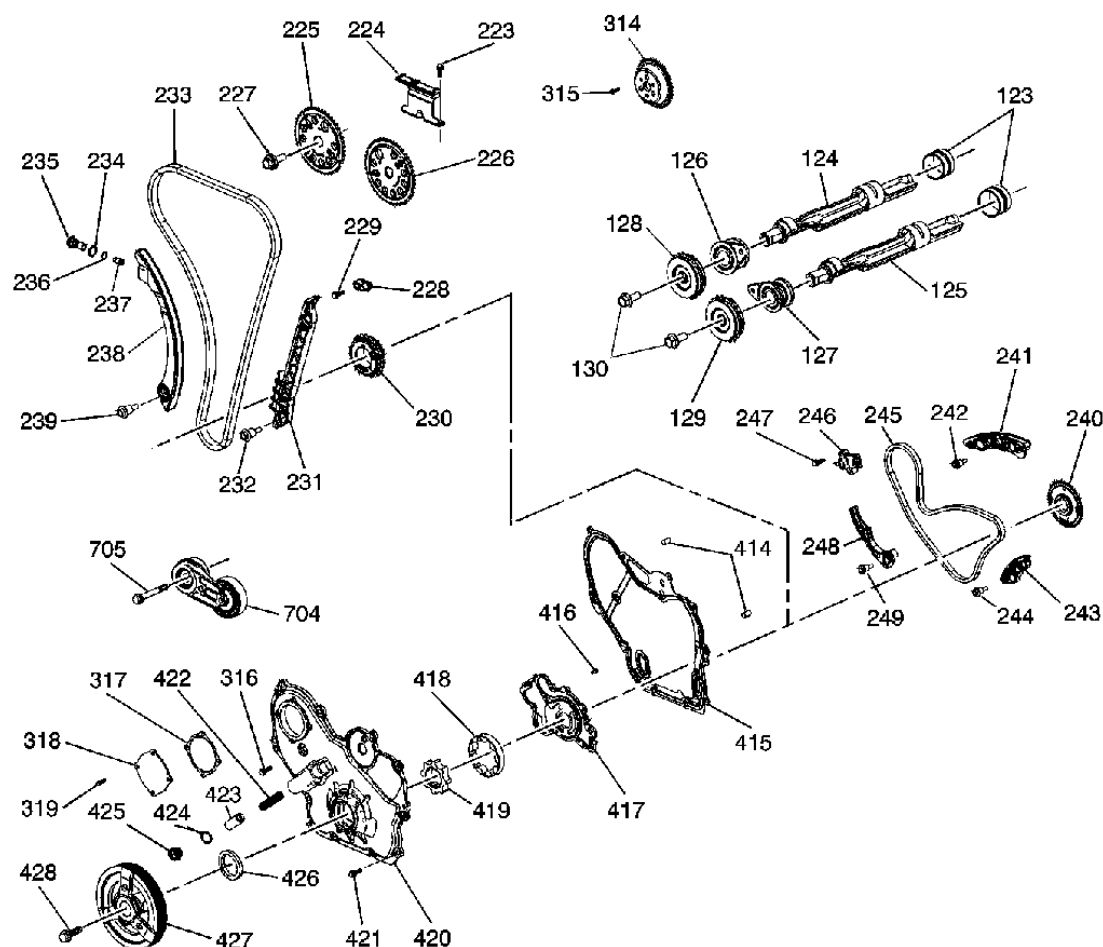


Fig. 22: Timing Chain & Components
Courtesy of GENERAL MOTORS CORP.

Callout	Component Name
123	Balance Shaft Rear Bearing
124	Exhaust Balance Shaft
125	Intake Balance Shaft
126	Exhaust Balance Shaft Bearing Carrier
127	Intake Balance Shaft Bearing Carrier
128	Exhaust Balance Shaft Drive Sprocket
129	Intake Balance Shaft Drive Sprocket
130	Balance Shaft Drive Sprocket Bolts
223	Upper Timing Chain Guide Bolt
224	Upper Timing Chain Guide
225	Exhaust Camshaft Sprocket
226	Intake Camshaft Sprocket
227	Camshaft Sprocket to Camshaft Bolt

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228	Timing Chain Oil Nozzle
229	Timing Chain Oil Nozzle Bolt
230	Timing Chain Drive Sprocket
231	Fixed Timing Chain Guide
232	Fixed Timing Chain Guide Bolt
233	Timing Chain
234	Timing Chain Tensioner Washer
235	Timing Chain Tensioner Body
236	Timing Chain Tensioner O-Ring Seal
237	Timing Chain Tensioner Plunger
238	Adjustable Timing Chain Guide
239	Adjustable Timing Chain Guide Bolt
240	Balance Shaft Drive Sprocket
241	Balance Shaft Drive Chain Guide
242	Balance Shaft Drive Chain Guide Bolt
243	Balance Shaft Drive Chain Guide
244	Balance Shaft Drive Chain Guide Bolt
245	Balance Shaft Drive Chain
246	Balance Shaft Drive Chain Tensioner Assembly
247	Balance Shaft Drive Chain Tensioner Assembly Bolt
248	Adjustable Balance Shaft Drive Chain Guide
249	Adjustable Balance Shaft Drive Chain Guide Bolt
314	Water Pump Drive Sprocket
315	Water Pump Drive Sprocket Bolt
316	Water Pump Bolt
317	Engine Front Cover Access Plate Gasket
318	Engine Front Cover Access Plate
319	Engine Front Cover Access Plate Bolt
414	Engine Front Cover Alignment Pins
415	Engine Front Cover Gasket
416	Oil Pump Cover Bolt
417	Oil Pump Cover
418	Oil Pump Outer Gerotor
419	Oil Pump Inner Gerotor
420	Engine Front Cover
421	Engine Front Cover Bolt
422	Oil Pressure Relief Valve Spring
423	Oil Pressure Relief Valve Plunger
424	Oil Pressure Relief Valve O-Ring Seal
425	Oil Pressure Relief Valve Plug
426	Crankshaft Front Seal

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	Crankshaft Dampener
428	Crankshaft Dampener Bolt
704	Belt Tensioner
705	Belt Tensioner Bolt

ENGINE IDENTIFICATION

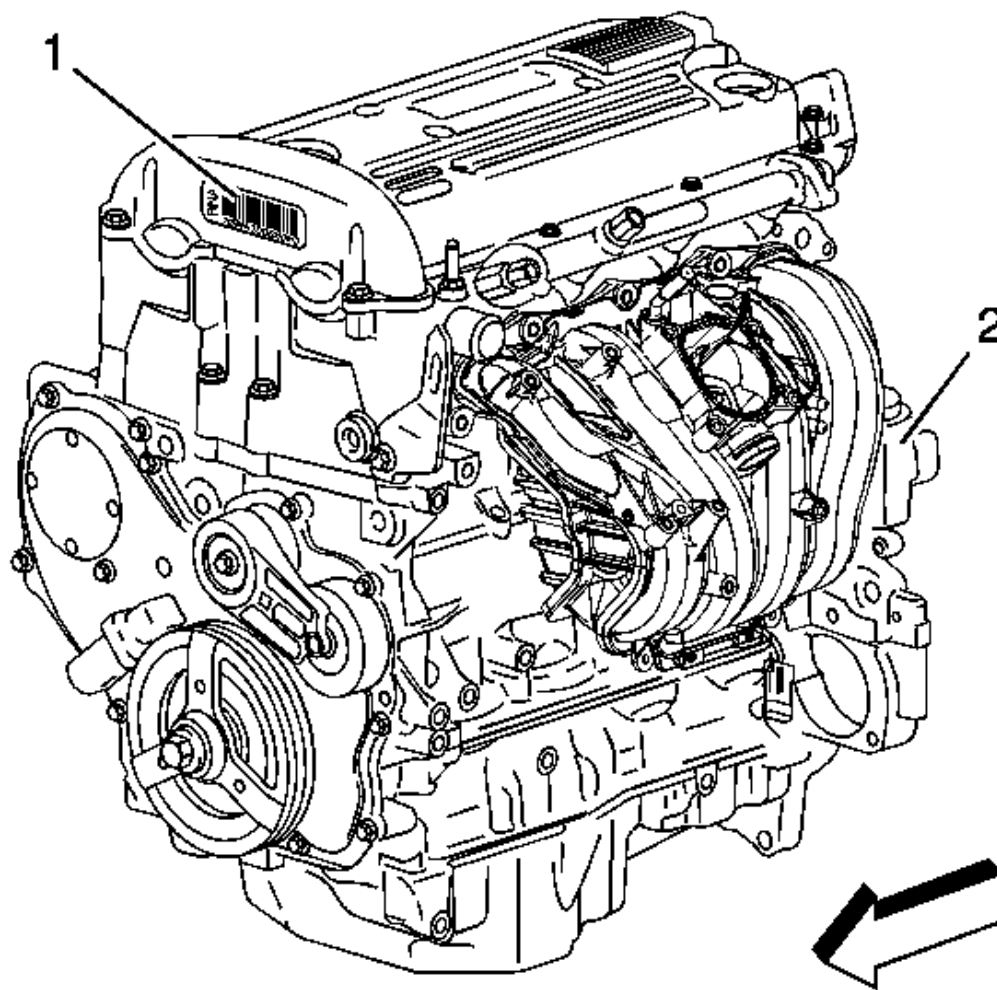


Fig. 23: Locating Broadcast Code Label & VIN
Courtesy of GENERAL MOTORS CORP.

Identification can be made through the use of the Broadcast Code label on the engine front cover (1) and the use of the partial VIN etched on the oil filter bowl (2).

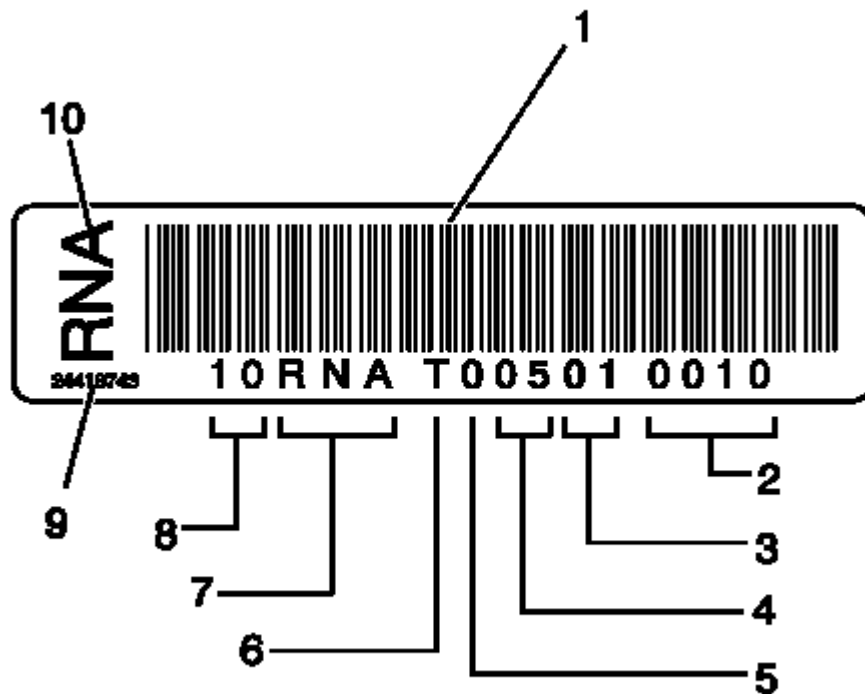


Fig. 24: View Of Broadcast Code Label
Courtesy of GENERAL MOTORS CORP.

- Barcode (1)
- Sequence Number (2)
- Day (3)
- Month (4)
- Year (5)
- Engine Assembly Plant (6)
- Broadcast Code (7)
- Part Designation (8)
- Engine Assembly Number (9)
- Broadcast Code (10)

The partial VIN identifies the specific vehicle by sequence number.

DIAGNOSTIC INFORMATION AND PROCEDURES

DIAGNOSTIC STARTING POINT - ENGINE MECHANICAL

Begin the system diagnosis by reviewing the **Disassembled Views**, **Engine Component Description**, **Lubrication Description** , and the **Drive Belt System Description**. Reviewing the description and operation information will help you determine the correct symptom diagnostic procedure when a malfunction exists. Reviewing the description and operation information will also help you determine if the condition described by the customer is normal operation. Refer to **Symptoms - Engine Mechanical** in order to identify the correct procedure for diagnosing the system and where the procedure is located.

SYMPTOMS - ENGINE MECHANICAL

Strategy Based Diagnostics

1. Perform the **Diagnostic System Check - Vehicle** before using the symptom tables, if applicable.
2. Review the system operations in order to familiarize yourself with the system functions. Refer to **Disassembled Views**, **Engine Component Description**, and **Lubrication Description** .

All diagnosis on a vehicle should follow a logical process. Strategy based diagnostics is a uniform approach for repairing all systems. The diagnostic flow may always be used in order to resolve a system condition. The diagnostic flow is the place to start when repairs are necessary.

Visual/Physical Inspection

- Inspect for aftermarket devices which could affect the operation of the engine.
- Inspect the easily accessible or visible system components for obvious damage or conditions which could cause the symptom.
- Check for the correct oil level, proper oil viscosity, and correct filter application.
- Verify the exact operating conditions under which the concern exists. Note factors such as engine RPM, ambient temperature, engine temperature, amount of engine warm-up time, and other specifics.
- Compare the engine sounds, if applicable, to a known good engine and make sure you are not trying to correct a normal condition.

Intermittent

Test the vehicle under the same conditions that the customer reported in order to verify the system is operating properly.

Symptom List

Refer to a symptom diagnostic procedure from the following list in order to diagnose the symptom:

- **Base Engine Misfire without Internal Engine Noises**
- **Base Engine Misfire with Abnormal Internal Lower Engine Noises**
- **Base Engine Misfire with Abnormal Valve Train Noise**
- **Base Engine Misfire with Coolant Consumption**
- **Base Engine Misfire with Excessive Oil Consumption**
- **Engine Noise on Start-Up, but Only Lasting a Few Seconds**

- Upper Engine Noise, Regardless of Engine Speed
- Lower Engine Noise, Regardless of Engine Speed
- Engine Noise Under Load
- Engine Will Not Crank - Crankshaft Will Not Rotate
- Engine Compression Test
- Oil Consumption Diagnosis
- Oil Pressure Diagnosis and Testing
- Oil Leak Diagnosis
- Drive Belt Chirping, Squeal, and Whine Diagnosis
- Drive Belt Rumbling and Vibration Diagnosis
- Drive Belt Falls Off and Excessive Wear Diagnosis
- Drive Belt Tensioner Diagnosis

BASE ENGINE MISFIRE WITHOUT INTERNAL ENGINE NOISES

Cause	Correction
Abnormalities, severe cracking, bumps, or missing areas in the accessory drive belt Abnormalities in the accessory drive system and/or components may cause engine RPM variations and lead to a misfire DTC. A misfire code may be present without an actual misfire condition.	Replace the drive belt.
Worn, damaged, or mis-aligned accessory drive components or excessive pulley runout may lead to a misfire DTC. A misfire code may be present without an actual misfire condition.	Inspect the components, and repair or replace as required.
A loose or improperly installed engine flywheel or crankshaft balancer A misfire code may be present without an actual misfire condition.	Repair or replace the flywheel and/or balancer as required.
Restricted exhaust system A severe restriction in the exhaust flow can cause significant loss of engine performance and may set a DTC. Possible causes of restrictions include collapsed or dented pipes or plugged mufflers and/or catalytic converters.	Repair or replace as required.
Improperly installed or damaged vacuum hoses	Repair or replace as required.
Improper sealing between the intake manifold and cylinder head or throttle body.	Replace the intake manifold, gaskets, cylinder head, and/or throttle body as required.
Improperly installed or damaged MAP sensor The sealing grommet of the MAP sensor should not be torn or damaged.	Repair or replace the MAP sensor as required.

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Damage to the MAP sensor housing	Replace the intake manifold.
Worn or loose rocker arms The rocker arm bearing end caps and/or needle bearings should be intact and in the proper position.	Replace the valve rocker arms as required.
Stuck valves Carbon buildup on the valve stem can cause the valve not to close properly.	Repair or replace as required.
Excessively worn or mis-aligned timing chain	Replace the timing chain and sprockets as required.
Worn camshaft lobes	Replace the camshaft and valve lash adjusters.
Excessive oil pressure A lubrication system with excessive oil pressure may lead to excessive valve lifter pump up and loss of compression.	• Perform an oil pressure test. Refer to <u>Oil Pressure Diagnosis and Testing</u>. • Repair or replace the oil pump as required.
Faulty cylinder head gasket and/or cracking or other damage to the cylinder head and engine block cooling system passages Coolant consumption may or may not cause the engine to overheat.	• Inspect for spark plugs saturated by coolant. • Inspect the cylinder head, engine block, and/or head gasket. • Repair or replace as required.
Worn piston rings Oil consumption may or may not cause the engine to misfire.	• Inspect the spark plugs for oil deposits. • Inspect the cylinders for a loss of compression. Refer to <u>Engine Compression Test</u>. • Perform cylinder leak down and compression testing to identify the cause. • Repair or replace as required.
A damaged crankshaft reluctor wheel A damaged crankshaft reluctor wheel can result in different symptoms depending on the severity and location of the damage. • Systems with electronic communications, DIS or coil per cylinder, and severe reluctor ring damage may exhibit periodic loss of crankshaft position, stop delivering a signal, and then re-sync the crankshaft position. • Systems with electronic communication, DIS or coil per cylinder, and slight reluctor ring damage may exhibit no loss of crankshaft position and no misfire may occur. However, a P0300 DTC may be set. • Systems with mechanical communications, high voltage switch, and severe reluctor ring damage may cause additional pulses and effect fuel and spark delivery to the point of generating a P0300 DTC or P0336.	Replace the sensor and/or crankshaft reluctor wheel as required.

BASE ENGINE MISFIRE WITH ABNORMAL INTERNAL LOWER ENGINE NOISES

Cause	Correction
Abnormalities, severe cracking, bumps or missing areas in the accessory drive belt Abnormalities in the accessory drive system and/or components may cause engine RPM variations, noises similar to a faulty lower engine, and also lead to a misfire condition. A misfire code may be present without an actual misfire condition.	Replace the drive belt.
Worn, damaged, or mis-aligned accessory drive components or excessive pulley runout A misfire code may be present without an actual misfire condition.	Inspect the components, repair or replace as required.
Loose or improperly installed engine flywheel or crankshaft balancer A misfire code may be present without an actual misfire condition.	Repair or replace the flywheel and/or balancer as required.
Worn piston rings Oil consumption may or may not cause the engine to misfire.	• Inspect the spark plugs for oil deposits. • Inspect the cylinders for a loss of compression. Refer to <u>Engine Compression Test</u>. • Perform cylinder leak down and compression testing to determine the cause. • Repair or replace as required.
Worn crankshaft thrust bearings Severely worn thrust surfaces on the crankshaft and/or thrust bearing may permit fore and aft movement of the crankshaft, and create a DTC without an actual misfire condition.	Replace the crankshaft and bearings as required.

BASE ENGINE MISFIRE WITH ABNORMAL VALVE TRAIN NOISE

Cause	Correction
Worn or loose rocker arms The rocker arm bearing end caps and/or needle bearings should intact within the rocker arm assembly.	Replace the valve rocker arms as required.
Stuck valves Carbon buildup on the valve stem can cause the valve to not close properly.	Repair or replace as required.
Excessively worn or mis-aligned timing chain	Replace the timing chain and sprockets as required.
Worn camshaft lobes	Replace the camshaft and valve lash adjusters.
Sticking lifters	Replace as required.

BASE ENGINE MISFIRE WITH COOLANT CONSUMPTION

Cause	Correction
Faulty cylinder head gasket and/or cracking, or other damage to the cylinder head and engine block cooling system passages. Coolant consumption may or may not cause the engine to overheat.	- Inspect for spark plugs saturated by coolant. - Perform a cylinder leak down test. - Inspect the cylinder head and engine block for damage to the coolant passages and/or a faulty head gasket. - Repair or replace as required.

BASE ENGINE MISFIRE WITH EXCESSIVE OIL CONSUMPTION

Cause	Correction
Worn valves, valve guides and/or valve stem oil seals	- Inspect the spark plugs for oil deposits. - Repair or replace as required.
Worn piston rings Oil consumption may or may not cause the engine to misfire.	- Inspect the spark plugs for oil deposits. - Inspect the cylinders for a loss of compression. Refer to <u>Engine Compression Test</u>. - Perform cylinder leak down and compression testing to determine the cause. - Repair or replace as required.

ENGINE NOISE ON START-UP, BUT ONLY LASTING A FEW SECONDS

Cause	Correction
Incorrect oil filter without anti-drainback feature	Install the correct oil filter.
Incorrect oil viscosity	- Drain the oil. - Install the correct viscosity oil.
High valve lash adjuster leak down rate	Replace the lash adjusters as required.
Worn crankshaft thrust bearing	- Inspect the thrust bearing and crankshaft. - Repair or replace as required.
Damaged or faulty oil filter by-pass valve	- Inspect the oil filter by-pass valve for proper operation. - Repair or replace as required.

UPPER ENGINE NOISE, REGARDLESS OF ENGINE SPEED

Cause	Correction
Low oil pressure	Perform an oil pressure test. Refer to <u>Oil</u>

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	<u>Pressure Diagnosis and Testing.</u>
	2. Repair or replace as required.
Loose and/or worn valve rocker arm attachments	1. Inspect the valve rocker arm stud, nut or bolt. 2. Repair or replace as required.
Worn valve rocker arm	Replace the valve rocker arm.
Improper lubrication to the valve rocker arms	Inspect the following components, and repair or replace as required: • The valve rocker arm • The valve lash adjuster • The oil filter bypass valve • The oil pump and pump screen • The engine block oil galleries
Broken valve spring	Replace the valve spring.
Worn or dirty valve lash adjusters	Replace the valve lash adjusters.
Stretched or broken timing chain and/or damaged sprocket teeth	Replace the timing chain and sprockets.
Worn, damaged, or faulty timing chain tensioners	Replace tensioners
Worn engine camshaft lobes	1. Inspect the engine camshaft lobes. 2. Replace the camshaft and valve lash adjusters as required.
Worn valve guides or valve stems	Inspect the following components, and repair as required: • The valves • The valve guides
Stuck valves Carbon on the valve stem or valve seat may cause the valve to stay open.	Inspect the following components, and repair as required: • The valves • The valve guides

LOWER ENGINE NOISE, REGARDLESS OF ENGINE SPEED

Cause	Correction
Low oil pressure	• Perform an oil pressure test. Refer to <u>Oil Pressure Diagnosis and Testing.</u> • Repair or replace damaged components as required.
Worn accessory drive components Abnormalities, such as severe cracking, bumps, or missing areas in the accessory drive belt and/or	• Inspect the accessory drive system. • Repair or replace as required.

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misalignment of system components	
Loose or damaged crankshaft balancer	• Inspect the crankshaft balancer. • Repair or replace as required.
Detonation or spark knock	Verify the correct operation of the ignition system. Refer to <u>Symptoms - Engine Controls</u> .
Loose torque converter bolts	• Inspect the torque converter bolts and flywheel. • Repair or replace as required.
Loose or damaged flywheel	Repair or replace the flywheel.
Damaged oil pan, contacting the oil pump screen An oil pan that has been damaged, may improperly position the oil pump screen, preventing proper oil flow to the oil pump.	• Inspect the oil pan. • Inspect the oil pump screen. • Repair or replace as required.
Oil pump screen loose, damaged or restricted	• Inspect the oil pump screen. • Repair or replace as required.
Excessive piston-to-cylinder bore clearance	• Inspect the piston and cylinder bore. • Repair as required.
Excessive piston pin-to-bore clearance	• Inspect the piston, piston pin, and the connecting rod. • Repair or replace as required.
Excessive connecting rod bearing clearance	Inspect the following components, and repair as required: • The connecting rod bearings • The connecting rods • The crankshaft • The crankshaft journals
Excessive crankshaft bearing clearance	Inspect the following components, and repair as required: • The crankshaft bearings • The crankshaft journals
Incorrect piston, piston pin, and connecting rod installation Pistons must be installed with the mark or dimple on the top of the piston, facing the front of the engine. Piston pins must be centered in the connecting rod pin bore.	• Verify the pistons, piston pins and connecting rods are installed correctly. • Repair as required.

ENGINE NOISE UNDER LOAD

Cause	Correction
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Low oil pressure	• Perform an oil pressure test. Refer to <u>Oil Pressure Diagnosis and Testing</u>. • Repair or replace as required.
Detonation or spark knock	Verify the correct operation of the ignition. Refer to <u>Symptoms - Engine Controls</u> .
Loose torque converter bolts	• Inspect the torque converter bolts and flywheel. • Repair as required.
Cracked flywheel, automatic transmission	• Inspect the flywheel bolts and flywheel. • Repair as required.
Excessive connecting rod bearing clearance	Inspect the following components, and repair as required: • The connecting rod bearings • The connecting rods • The crankshaft
Excessive crankshaft bearing clearance	Inspect the following components, and repair as required: • The crankshaft bearings • The crankshaft journals • The cylinder block crankshaft bearing bore

ENGINE WILL NOT CRANK - CRANKSHAFT WILL NOT ROTATE

Cause	Correction
Seized accessory drive system component	1. Remove accessory drive belts. 2. Rotate crankshaft by hand at the balancer or flywheel location.
Hydraulically locked cylinder • Coolant/antifreeze in cylinder • Oil in cylinder • Fuel in cylinder	1. Remove spark plugs and check for fluid. 2. Inspect for broken head gasket. 3. Inspect for cracked engine block or cylinder head. 4. Inspect for a sticking fuel injector. 5. Inspect for cracked cylinder wall.
Seized automatic transmission torque converter	1. Remove the torque converter bolts. 2. Rotate crankshaft by hand at the balancer or flywheel location.
Seized manual transmission	1. Disengage the clutch. 2. Rotate crankshaft by hand at the balancer or

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	flywheel location.
Broken timing chain and/or gears	• Inspect timing chain and gears. • Repair as required.
Seized balance shaft	• Inspect balance shaft. • Repair as required.
Material in cylinder • Broken valve • Piston material • Foreign material • Cracked cylinder wall	• Inspect cylinder for damaged components and/or foreign materials. • Inspect for fallen cylinder wall. • Repair or replace as required.
Seized crankshaft or connecting rod bearings	• Inspect crankshaft and connecting rod bearings. • Inspect for fallen cylinder wall. • Repair as required.
Bent or broken connecting rod	• Inspect connecting rods. • Repair as required.
Broken crankshaft	• Inspect crankshaft. • Repair as required.

COOLANT IN COMBUSTION CHAMBER

Cause	Correction
DEFINITION: Excessive white smoke and/or coolant type odor coming from the exhaust pipe may indicate coolant in the combustion chamber. Low coolant levels, an inoperative cooling fan, or a faulty thermostat may lead to an "overtemperature" condition which may cause engine component damage.	
1. A slower than normal cranking speed may indicate coolant entering the combustion chamber. Refer to <u>Engine Will Not Crank - Crankshaft Will Not Rotate</u>. 2. Remove the spark plugs and inspect for spark plugs saturated by coolant or coolant in the cylinder bore. 3. Inspect by performing a cylinder leak-down test. During this test, excessive air bubbles within the coolant may indicate a faulty gasket or damaged component. 4. Inspect by performing a cylinder compression test. Two cylinders "side-by-side" on the engine block, with low compression, may indicate a failed cylinder head gasket. Refer to <u>Engine Compression Test</u>.	
Faulty cylinder head gasket	Replace the head gasket and components as required. Refer to <u>Cylinder Head Cleaning and Inspection</u> and <u>Cylinder Head Replacement</u> .
Warped cylinder head	Replace the cylinder head and gasket. Refer to <u>Cylinder Head Cleaning and Inspection</u> .

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Cracked cylinder head	Replace the cylinder head and gasket.
Cracked cylinder sleeve	Replace the components as required.
Cylinder head or block porosity	Replace the components as required.

COOLANT IN ENGINE OIL

Cause	Correction
DEFINITION: Foamy or discolored oil or an engine oil "overfill" condition may indicate coolant entering the engine crankcase. Low coolant levels, an inoperative cooling fan, or a faulty thermostat may lead to an "overtemperature" condition which may cause engine component damage. Contaminated engine oil and oil filter should be changed.	
1. Inspect the oil for excessive foaming or an overfill condition. Oil diluted by coolant may not properly lubricate the crankshaft bearings and may lead to component damage. Refer to <u>Lower Engine Noise, Regardless of Engine Speed.</u> 2. Inspect by performing a cylinder leak-down test. During this test, excessive air bubbles within the cooling system may indicate a faulty gasket or damaged component. 3. Inspect by performing a cylinder compression test. Two cylinders "side-by-side" on the engine block with low compression may indicate a failed cylinder head gasket. Refer to <u>Engine Compression Test .</u>	
Faulty cylinder head gasket	Replace the head gasket and components as required. Refer to <u>Cylinder Head Cleaning and Inspection</u> and <u>Cylinder Head Replacement.</u>
Warped cylinder head	Replace the cylinder head and gasket. Refer to <u>Cylinder Head Cleaning and Inspection.</u>
Cracked cylinder head	Replace the cylinder head and gasket.
Cracked cylinder sleeve	Replace the components as required.
Cylinder head or block porosity	Replace the components as required.

ENGINE COMPRESSION TEST

1. Charge the battery if the battery is not fully charged.
2. Disable the ignition system.
3. Disable the fuel injection system.
4. Remove all spark plugs.
5. Turn the ignition to the ON position.
6. Depress the accelerator pedal to position the throttle plate wide open.
7. Start with the compression gage at zero and crank the engine through 4 compression strokes, 4 puffs.
8. Measure the compression for each cylinder. Record the readings.
9. If a cylinder has low compression, inject approximately 15 ml (1 tablespoon) of engine oil into the combustion chamber through the spark plug hole. Measure the compression again and record the reading.
10. The minimum compression in any 1 cylinder should not be less than 70 percent of the highest cylinder. No cylinder should read less than 690 kPa (100 psi). For example, if the highest pressure in any 1

cylinder is 1 035 kPa (150 psi), the lowest allowable pressure for any other cylinder would be 725 kPa (105 psi). ($1\ 035 \times 70\% = 725$) ($150 \times 70\% = 105$).

- Normal - Compression builds up quickly and evenly to the specified compression for each cylinder.
- Piston Rings Leaking - Compression is low on the first stroke. Compression builds up with the following strokes, but does not reach normal. Compression improves considerably when you add oil.
- Valves Leaking - Compression is low on the first stroke. Compression usually does not build up on the following strokes. Compression does not improve much when you add oil.
- If 2 adjacent cylinders have lower than normal compression, and injecting oil into the cylinders does not increase the compression, the cause may be a head gasket leaking between the cylinders.

CYLINDER LEAKAGE TEST

Tools Required

J 35667-A Cylinder Head Leakdown Tester or equivalent

IMPORTANT: A leakage test may be performed in order to measure cylinder/combustion chamber leakage. High leakage may indicate one or more of the following:

- Worn or burnt valves
- Broken valve springs
- Stuck valve lifters
- Incorrect valve lash/adjustment
- Damaged piston
- Worn piston rings
- Worn or scored cylinder bore
- Damaged cylinder head gasket
- Cracked or damaged cylinder head
- Cracked or damaged engine block

CAUTION: Unless directed otherwise, the ignition and start switch must be in the OFF or LOCK position, and all electrical loads must be OFF before servicing any electrical component. Disconnect the negative battery cable to prevent an electrical spark should a tool or equipment come in contact with an exposed electrical terminal. Failure to follow these precautions may result in personal injury and/or damage to the vehicle or its components.

1. Disconnect the battery ground negative cable.
2. Remove the spark plugs. Refer to **Spark Plug Replacement**.
3. Rotate the crankshaft to place the piston in the cylinder being tested at Top Dead Center (TDC) of the compression stroke.

4. Install the **J 35667-A** or equivalent.

IMPORTANT: It may be necessary to hold the crankshaft balancer bolt to prevent the engine from rotating.

5. Apply shop air pressure to the **J 35667-A** and adjust according to the manufacturers instructions.
6. Record the cylinder leakage value. Cylinder leakage that exceeds 25 percent is considered excessive and may require component service. In excessive leakage situations, inspect for the following conditions:
 - Air leakage sounds at the throttle body or air inlet hose that may indicate a worn or burnt intake valve or a broken valve spring.
 - Air leakage sounds at the exhaust system tailpipe that may indicate a worn or burnt exhaust valve or a broken valve spring.
 - Air leakage sounds from the crankcase, oil level indicator tube, or oil fill tube that may indicate worn piston rings, a damaged piston, a worn or scored cylinder bore, a damaged engine block or a damaged cylinder head.
 - Air bubbles in the cooling system may indicate a damaged cylinder head or a damaged cylinder head gasket.
7. Perform the leakage test on the remaining cylinders and record the values.

OIL CONSUMPTION DIAGNOSIS

Excessive oil consumption, not due to leaks, is the use of 0.9 L (1 qt) or greater of engine oil within 3 200 kilometers (2,000 miles). The causes of excessive oil consumption include the following conditions:

- External oil leaks

Tighten bolts and/or replace gaskets and oil seals as necessary.

- Incorrect oil level or improper reading of oil level indicator

With the vehicle on a level surface, allow adequate drain down time and inspect for the correct oil level.

- Improper oil viscosity

Use recommended SAE viscosity for the prevailing temperatures.

- Continuous high speed driving and/or severe usage
- Crankcase ventilation system restrictions or malfunctioning components
- Valve guides and/or valve stem oil seals worn, or the seal omitted

Ream guides and install oversize service valves and/or new valve stem oil seals.

- Piston rings broken, improperly installed, worn, or not seated properly

Allow adequate time for rings to seat. Replace broken or worn rings, as necessary.

- Piston improperly installed or mis-fitted

OIL PRESSURE DIAGNOSIS AND TESTING

Tools Required

J-21867-850 Oil Pressure Gage Adapter. See **Special Tools**.

- With the vehicle on a level surface, allow adequate drain down time of 2-3 minutes and measure for a low oil level.

Add the recommended grade engine oil and fill the crankcase until the oil level measures full on the oil level indicator.

- Run the engine, and verify low, or no oil pressure on the vehicle gage or light. Listen for a noisy valve train or a knocking noise.
- Inspect for the following:
 - Oil diluted by moisture or unburned fuel mixtures
 - Improper oil viscosity for the expected temperature
 - Incorrect or malfunctioning oil pressure sender
 - Incorrect or malfunctioning oil pressure gage
 - Plugged oil filter
 - Malfunctioning oil bypass valve
- Remove the oil pressure sender or another engine block oil gallery plug.
- Install **J-21867-850** and an oil pressure gage and measure the engine oil pressure. See **Special Tools**.
- Compare the readings to specifications. Refer to **Engine Mechanical Specifications**.
- If the engine oil pressure is below specifications, inspect the engine for one or more of the following:
 - Oil pump worn or dirty

Refer to **Oil Pump Disassemble** .

- Oil pump-to-engine front cover bolts loose

Refer to **Engine Front Cover and Oil Pump Installation** .

- Oil pump screen loose, plugged, or damaged
- Oil pump screen O-ring seal missing or damaged
- Malfunctioning oil pump pressure regulator valve
- Excessive bearing clearance

Refer to **Crankshaft and Bearing Cleaning and Inspection** .

- Cracked, porous or restricted oil galleries

- Oil gallery plugs missing or incorrectly installed

Refer to Engine Block Assemble .

- Broken lash adjusters

OIL LEAK DIAGNOSIS

Step	Action	Yes	No
DEFINITION: You can repair most fluid leaks by first, visually locating the leak, repairing or replacing the component, or by resealing the gasket surface. Once the leak is identified, determine the cause of the leak. Repair the cause of the leak as well as the leak itself.			
1	1. Operate the vehicle until it reaches normal operating temperature. Refer to <u>Engine Mechanical Specifications</u>. 2. Park the vehicle on a level surface, over a large sheet of paper or other clean surface. 3. Wait 15 minutes. 4. Check for drippings. Are drippings present?	Go to Step 2	System OK
2	Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 3
3	1. Visually inspect the suspected area. Use a small mirror to assist in looking at hard to see areas. 2. Check for leaks at the following locations: • Sealing surfaces • Fittings • Cracked or damaged components Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 4
4	1. Completely clean the entire engine and surrounding components. 2. Operate the vehicle for several miles at normal operating temperature and at varying speeds. 3. Park the vehicle on a level surface, over a large sheet of paper or other clean surface. 4. Wait 15 minutes. 5. Identify the type of fluid, and the approximate location of the leak.		

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	Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 5
5	1. Visually inspect the suspected area. Use a small mirror to assist in looking at hard to see areas. 2. Check for leaks at the following locations: • Sealing surfaces • Fittings • Cracked or damaged components Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 6
6	1. Completely clean the entire engine and surrounding components. 2. Apply an aerosol-type powder, for example, baby powder or foot powder, to the suspected area. 3. Operate the vehicle for several miles at normal operating temperature and at varying speeds. 4. Identify the type of fluid, and the approximate location of the leak, from the discolorations in the powder surface. Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 7
7	1. Visually inspect the suspected area. Use a small mirror to assist in looking at hard to see areas. 2. Check for leaks at the following locations: • Sealing surfaces • Fittings • Cracked or damaged components Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 8
8	Use J 28428-E , High Intensity Black Light Kit in order to identify the type of fluid, and the approximate location of the leak. Refer to the manufacturer's instructions when using the tool. Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	Go to Step 9
	1. Visually inspect the suspected area. Use a small mirror to assist in looking at hard to see areas. 2. Check for leaks at the following locations: • Sealing surfaces		

9	• Fittings • Cracked or damaged components Can you identify the type of fluid and the approximate location of the leak?	Go to Step 10	System OK
10	1. Inspect the engine for mechanical damage. Special interest should be shown to the following areas: • Higher than recommended fluid levels • Higher than recommended fluid pressures • Plugged or malfunctioning fluid filters or pressure bypass valves • Plugged or malfunctioning engine ventilation system • Improperly tightened or damaged fasteners • Cracked or porous components • Improper sealants or gaskets where required • Improper sealant or gasket installation • Damaged or worn gaskets or seals • Damaged or worn sealing surfaces 2. Inspect the engine for customer modifications. Is there mechanical damage, or customer modifications to the engine?	Go to Step 11	System OK
11	Repair or replace all damaged or modified components. Did you complete the repair?	Go to Step 1	-

CRANKCASE VENTILATION SYSTEM INSPECTION/DIAGNOSIS

Special Tools

J 23951 Valve Manometer

1. Remove the oil level indicator. Install a **J 23951** or equivalent.
2. Start the engine.
3. Check for slight vacuum. The vacuum level should be less than 3.377 kPa (1 in Hg).
4. If vacuum is higher, inspect and verify that the clean air hose from cam cover to air intake is not blocked or kinked.
5. If vacuum is in the normal range, block or pinch off the clean air hose. The clean air hose is the hose between the cam cover and air intake system. Vacuum should increase on the manometer. If held too long, vacuum will be drawn through the crankshaft seals creating a sucking sound.

6. If vacuum does not increase, the orifice in the intake manifold could be plugged.
7. If there is zero vacuum or pressure, verify compression of the engine.
8. If compression is normal, check for a blocked orifice at the intake manifold. Clean the orifice.

DRIVE BELT CHIRPING, SQUEAL, AND WHINE DIAGNOSIS

Diagnostic Aids

- A chirping or squeal noise may be intermittent due to moisture on the drive belts or the pulleys. It may be necessary to spray a small amount of water on the drive belts in order to duplicate the customers concern. If spraying water on the drive belt duplicates the symptom, cleaning the belt pulleys may be the probable solution.
- If the noise is intermittent, verify the accessory drive components by varying their loads making sure they are operated to their maximum capacity. An overcharged A/C system, power steering system with a pinched hose or wrong fluid, or a generator failing are suggested items to inspect.
- A chirping, squeal or whine noise may be caused by a loose or improper installation of a body or suspension component. Other items of the vehicle may also cause the noise.
- The drive belts will not cause a whine noise.

Test Description

The numbers below refer to the step numbers on the diagnostic table.

2: The noise may not be engine related. This step is to verify that the engine is making the noise. If the engine is not making the noise do not proceed further with this table.

3: The noise may be an internal engine noise. Removing the drive belts one at a time and operating the engine for a brief period will verify the noise is related to the drive belt. When removing the drive belt the water pump may not be operating and the engine may overheat. Also DTCs may set when the engine is operating with the drive belts removed.

4: Inspect all drive belt pulleys for pilling. Pilling is the small balls or pills or it can be strings in the drive belt grooves from the accumulation of rubber dust.

6: Misalignment of the pulleys may be caused from improper mounting of the accessory drive component, incorrect installation of the accessory drive component pulley, or the pulley bent inward or outward from a previous repair. Test for a misaligned pulley using a straight edge in the pulley grooves across two or three pulleys. If a misaligned pulley is found refer to that accessory drive component for the proper installation procedure for that pulley.

10: Inspecting of the fasteners can eliminate the possibility that a wrong bolt, nut, spacer, or washer was installed.

12: Inspecting the pulleys for being bent should include inspecting for a dent or other damage to the pulleys that would prevent the drive belt from not seating properly in all of the pulley grooves or on the smooth surface of a pulley when the back side of the belt is used to drive the pulley.

14: This test is to verify that the drive belt tensioner operates properly. If the drive belt tensioner is not operating properly, proper belt tension may not be achieved to keep the drive belt from slipping which could cause a squeal noise.

15: This test is to verify that the drive belt is not too long, which would prevent the drive belt tensioner

from working properly. Also if an incorrect length drive belt was installed, it may not be routed properly and may be turning an accessory drive component in the wrong direction.

16: Misalignment of the pulleys may be caused from improper mounting of the accessory drive component, incorrect installation of the accessory drive component pulley, or the pulley bent inward or outward from a previous repair. Test for a misaligned pulley using a straight edge in the pulley grooves across two or three pulleys. If a misaligned pulley is found refer to that accessory drive component for the proper installation procedure for that pulley.

17: This test is to verify that the pulleys are the correct diameter or width. Using a known good vehicle compare the pulley sizes.

19: Replacing the drive belt when it is not damaged or there is not excessive pilling will only be a temporary repair.

Step	Action	Yes	No
NOTE: Refer to <u>Belt Dressing Notice</u> .			
DEFINITION: The following items are indications of chirping: • A high pitched noise that is heard once per revolution of the drive belt or a pulley. • Chirping may occur on cold damp start-ups and will subside once the vehicle reaches normal operating temp.			
DEFINITION: The following items are indications of drive belt squeal: • A loud screeching noise that is caused by a slipping drive belt. This is unusual for a drive belt with multiple ribs. • The noise occurs when a heavy load is applied to the drive belt, such as an air conditioning compressor engagement snapping the throttle, or slipping on a seized pulley or a faulty accessory drive component.			
DEFINITION: The following items are indications of drive belt whine: • A high pitched continuous noise. • The noise may be caused by an accessory drive component failed bearing.			
1	Did you review the Drive Belt Symptom operation and perform the necessary inspections?	Go to Step 2	Go to <u>Symptoms - Engine Mechanical</u>
2	Verify that there is a chirping, squeal or whine noise. Does the engine make the chirping squeal or whine noise?	Go to Step 3	Go to Diagnostic Aids
	1. Remove the drive belt. If the engine has multiple drive belts, remove the belts one at a time and perform the test below each time a belt is removed.		

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3	2. Operate the engine for no longer than 30-40 seconds. 3. Repeat this test if necessary by removing the remaining belt(s). Does the chirping, squeal or whine noise still exist?	Go to Symptoms - Engine Mechanical	Go to Step 4
4	If diagnosing a chirping noise, inspect for severe pilling exceeding 1/3 of the belt groove depth. If diagnosing a squeal or whine noise, proceed to step 13. Do the belt grooves have pilling?	Go to Step 5	Go to Step 6
5	Clean the drive belt pulleys with a suitable wire brush. Did you complete the repair?	Go to Step 20	Go to Step 6
6	Inspect for misalignment of the pulleys. Are any of the pulleys misaligned?	Go to Step 7	Go to Step 8
7	Replace or repair any misaligned pulleys. Did you complete the repair?	Go to Step 20	Go to Step 8
8	Inspect for bent or cracked brackets. Did you find any bent or cracked brackets?	Go to Step 9	Go to Step 10
9	Replace any bent or cracked brackets. Did you complete the repair?	Go to Step 20	Go to Step 10
10	Inspect for improper, loose or missing fasteners. Did you find the condition?	Go to Step 11	Go to Step 12
11	NOTE: Refer to <u>Fastener Notice</u> . 1. Tighten any loose fasteners. Refer to <u>Fastener Tightening Specifications</u>. 2. Replace any improper or missing fasteners. Did you complete the repair?	Go to Step 20	Go to Step 12
12	Inspect for a bent pulley. Did you find the condition?	Go to Step 18	Go to Step 19
13	Inspect for an accessory drive component seized bearing or a faulty accessory drive component. Did you find and correct the condition? If diagnosing a whine noise and the condition still exist, proceed to Diagnostic Aids.	Go to Step 20	Go to Step 14
14	Test the drive belt tensioner for proper operation. Refer to <u>Drive Belt Tensioner Diagnosis</u> . Did you find and correct the condition?	Go to Step 20	Go to Step 15
15	Inspect for the correct drive belt length. Did you find and correct the condition?	Go to Step 20	Go to Step 16
16	Inspect for misalignment of a pulley.		

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	Did you find and correct the condition?	Go to Step 20	Go to Step 17
17	Inspect for the correct pulley size. Did you find and correct the condition?	Go to Step 20	Go to Diagnostic Aids
18	Replace the bent pulley. Did you complete the repair?	Go to Step 20	Go to Step 19
19	Replace the drive belt. Refer to <u>Drive Belt Replacement</u> . Did you complete the repair?	Go to Step 20	Go to <u>Diagnostic Aids</u>
20	Operate the system in order to verify the repair. Did you correct the condition?	System OK	Go to Step 3

DRIVE BELT RUMBLING AND VIBRATION DIAGNOSIS**Diagnostic Aids**

The accessory drive components can have an affect on engine vibration. Vibration from the engine operating may cause a body component or another part of the vehicle to make rumbling noise. Vibration can be caused by, but not limited to the A/C system over charged, the power steering system restricted or the incorrect fluid, or an extra load on the generator. To help identify an intermittent or an improper condition, vary the loads on the accessory drive components.

The drive belt may have a rumbling condition that can not be seen or felt. Sometimes replacing the drive belt may be the only repair for the symptom.

If replacing the drive belt, completing the diagnostic table, and the noise is only heard when the drive belts are installed, there might be an accessory drive component with a failure. Varying the load on the different accessory drive components may aid in identifying which component is causing the rumbling noise.

Test Description

The numbers below refer to the step numbers on the diagnostic table.

2: This test is to verify that the symptom is present during diagnosing. Other vehicle components may cause a similar symptom.

3: This test is to verify that one of the drive belts is causing the rumbling noise or vibration. Rumbling noise may be confused with an internal engine noise due to the similarity in the description. Remove only one drive belt at a time if the vehicle has multiple drive belts. When removing the drive belts the water pump may not be operating and the engine may overheat. Also DTCs may set when the engine is operating with the drive belts removed.

4: Inspecting the drive belts is to ensure that they are not causing the noise. Small cracks across the ribs of the drive belt will not cause the noise. Belt separation is identified by the plys of the belt separating and may be seen at the edge of the belt or felt as a lump in the belt.

5: Small amounts of pilling is normal condition and acceptable. When the pilling is severe the drive belt does not have a smooth surface for proper operation.

9: Inspecting of the fasteners can eliminate the possibility that the wrong bolt, nut, spacer, or washer was installed.

11: This step should only be performed if the water pump is driven by the drive belt. Inspect the water pump shaft for being bent. Also inspect the water pump bearings for smooth operation and excessive play. Compare the water pump with a known good water pump.

12: Accessory drive component brackets that are bent, cracked, or loose may put extra strain on that accessory component causing it to vibrate.

Step	Action	Yes	No
NOTE: Refer to <u>Belt Dressing Notice</u> .			
DEFINITION: The following items are indications of drive belt rumbling: • A low pitch tapping, knocking, or thumping noise heard at or just above idle. • Heard once per revolution of the drive belt or a pulley. • Rumbling may be caused from: ○ Pilling, the accumulation of rubber dust that forms small balls (pills) or strings in the drive belt pulley groove ○ The separation of the drive belt ○ A damaged drive belt			
DEFINITION: The following items are indications of drive belt vibration: • The vibration is engine-speed related. • The vibration may be sensitive to accessory load.			
1	Did you review the Drive Belt Symptom operation and perform the necessary inspections?	Go to Step 2	Go to <u>Symptoms - Engine Mechanical</u>
2	Verify that there is a rumbling noise or that the vibration is engine related. Does the engine make the rumbling noise or vibration?	Go to Step 3	Go to <u>Diagnostic Aids</u>
3	1. Remove the drive belt. If the engine has multiple drive belts, remove the belts one at a time and perform the test below each time a belt is removed. 2. Operate the engine for no longer than 30-40 seconds. 3. Repeat this test if necessary by removing the remaining belt(s). Does the rumbling or vibration still exist?	Go to <u>Symptoms - Engine Mechanical</u> or Go to <u>Vibration Analysis - Engine</u>	Go to Step 4
4	Inspect the drive belts for wear, damage, separation, sections of missing ribs, and debris build-up. Did you find any of these conditions?	Go to Step 7	Go to Step 5

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5	Inspect for severe pilling of more than 1/3 of the drive belt pulley grooves. Did you find severe pilling?	Go to Step 6	Go to Step 7
6	1. Clean the drive belt pulleys using a suitable wire brush. 2. Reinstall the drive belts. Refer to <u>Drive Belt Replacement</u> . Did you correct the condition?	Go to Step 8	Go to Step 7
7	Install a new drive belt. Refer to <u>Drive Belt Replacement</u> . Did you complete the replacement?	Go to Step 8	Go to Step 9
8	Operate the system in order to verify the repair. Did you correct the condition?	System OK	Go to Step 9
9	Inspect for improper, loose or missing fasteners. Did you find any of these conditions?	Go to Step 10	Go to Step 11
10	NOTE: Refer to <u>Fastener Notice</u> . 1. Tighten any loose fasteners. Refer to <u>Fastener Tightening Specifications</u> . 2. Replace improper or missing fasteners. Did you complete the repair?	Go to Step 13	Go to Step 11
11	Inspect for a bent water pump shaft. Refer to <u>Water Pump Replacement (L61/LE5)</u> . Did you find and correct the condition?	Go to Step 13	Go to Step 12
12	Inspect for bent or cracked brackets. Did you find and correct the condition?	Go to Step 13	Go to <u>Diagnostic Aids</u>
13	Operate the system in order to verify the repair. Did you correct the condition?	System OK	Go to Step 3

DRIVE BELT FALLS OFF AND EXCESSIVE WEAR DIAGNOSIS**Diagnostic Aids**

If the drive belt repeatedly falls off the drive belt pulleys, this is because of pulley misalignment.

An extra load that is quickly applied on released by an accessory drive component may cause the drive belt to fall off the pulleys. Verify the accessory drive components operate properly.

If the drive belt is the incorrect length, the drive belt tensioner may not keep the proper tension on the drive belt.

Excessive wear on a drive belt is usually caused by an incorrect installation or the wrong drive belt for the application.

Minor misalignment of the drive belt pulleys will not cause excessive wear, but will probably cause the drive belt to make a noise or to fall off.

Excessive misalignment of the drive belt pulleys will cause excessive wear but may also make the drive belt fall off.

Test Description

The numbers below refer to the step numbers on the diagnostic table.

2: This inspection is to verify the condition of the drive belt. Damage may of occurred to the drive belt when the drive belt fell off. The drive belt may of been damaged, which caused the drive belt to fall off. Inspect the belt for cuts, tears, sections of ribs missing, or damaged belt plys.

4: Misalignment of the pulleys may be caused from improper mounting of the accessory drive component, incorrect installation of the accessory drive component pulley, or the pulley bent inward or outward from a previous repair. Test for a misaligned pulley using a straight edge in the pulley grooves across two or three pulleys. If a misaligned pulley is found refer to that accessory drive component for the proper installation procedure of that pulley.

5: Inspecting the pulleys for being bent should include inspecting for a dent or other damage to the pulleys that would prevent the drive belt from not seating properly in all of the pulley grooves or on the smooth surface of a pulley when the back side of the belt is used to drive the pulley.

6: Accessory drive component brackets that are bent or cracked will let the drive belt fall off.

7: Inspecting of the fasteners can eliminate the possibility that a wrong bolt, nut, spacer, or washer was installed. Missing, loose, or the wrong fasteners may cause pulley misalignment from the bracket moving under load. Over tightening of the fasteners may cause misalignment of the accessory component bracket.

13: The inspection is to verify the drive belt is correctly installed on all of the drive belt pulleys. Wear on the drive belt may be caused by mis-positioning the drive belt by one groove on a pulley.

14: The installation of a drive belt that is too wide or too narrow will cause wear on the drive belt. The drive belt ribs should match all of the grooves on all of the pulleys.

15: This inspection is to verify the drive belt is not contacting any parts of the engine or body while the engine is operating. There should be sufficient clearance when the drive belt accessory drive components load varies. The drive belt should not come in contact with an engine or a body component when snapping the throttle.

Step	Action	Yes	No
NOTE: Refer to <u>Belt Dressing Notice</u> .			
DEFINITION: The drive belt falls off the pulleys or may not ride correctly on the pulleys. DEFINITION: Wear at the outside ribs of the drive belt due to an incorrectly installed drive belt.			
1	Did you review the Drive Belt Symptom operation and perform the necessary inspections?	Go to Step 2	Go to <u>Symptoms - Engine Mechanical</u>
2	If diagnosing excessive wear, proceed to step 13. If diagnosing a drive belt that falls off, inspect for a damaged drive belt.		

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	Did you find the condition?	Go to Step 3	Go to Step 4
3	Install a new drive belt. Refer to <u>Drive Belt Replacement</u> . Does the drive belt continue to fall off?	Go to Step 4	System OK
4	Inspect for misalignment of the pulleys. Did you find and repair the condition?	Go to Step 12	Go to Step 5
5	Inspect for a bent or dented pulley. Did you find and repair the condition?	Go to Step 12	Go to Step 6
6	Inspect for a bent or a cracked bracket. Did you find and repair the condition?	Go to Step 12	Go to Step 7
7	Inspect for improper, loose or missing fasteners. Did you find loose or missing fasteners?	Go to Step 8	Go to Step 9
8	NOTE: Refer to <u>Fastener Notice</u> . 1. Tighten any loose fasteners. Refer to <u>Fastener Tightening Specifications</u>. 2. Replace improper or missing fasteners. Does the drive belt continue to fall off?	Go to Step 9	System OK
9	Test the drive belt tensioner for operating correctly. Refer to <u>Drive Belt Tensioner Diagnosis</u> . Does the drive belt tensioner operate correctly?	Go to Step 11	Go to Step 10
10	Replace the drive belt tensioner. Refer to <u>Drive Belt Tensioner Replacement</u> . Does the drive belt continue to fall off?	Go to Step 11	System OK
11	Inspect for failed drive belt idler and drive belt tensioner pulley bearings. Did you find and repair the condition?	Go to Step 12	Go to <u>Diagnostic Aids</u>
12	Operate the system in order to verify the repair. Did you correct the condition?	System OK	Go to Step 2
13	Inspect the drive belt for the proper installation. Refer to <u>Drive Belt Replacement</u> . Did you find this condition?	Go to Step 16	Go to Step 14
14	Inspect for the proper drive belt. Did you find this condition?	Go to Step 16	Go to Step 15
15	Inspect for the drive belt rubbing against a bracket, hose, or wiring harness. Did you find and repair the condition?	Go to Step 17	Go to <u>Diagnostic Aids</u>
16	Replace the drive belt. Refer to <u>Drive Belt Replacement</u> . Did you complete the replacement?	Go to Step 17	-
17	Operate the system in order to verify the repair. Did you correct the condition?	System OK	-

DRIVE BELT TENSIONER DIAGNOSIS

Step	Action	Yes	No
1	Remove the drive belt. Inspect the drive belt tensioner pulley. Is the drive belt tensioner pulley loose or misaligned?	Go to Step 4	Go to Step 2
2	Rotate the drive belt tensioner. Does the tensioner rotate without any unusual resistance or binding?	Go to Step 3	Go to Step 4
3	1. Use a torque wrench in order to measure the torque required to move the tensioner off of the stop. 2. Use a torque wrench on a known good tensioner in order to measure the torque required to move the tensioner off of the stop. Is the first torque reading within 10 percent of the second torque reading?	System OK	Go to Step 4
4	Replace the drive belt tensioner. Refer to <u>Drive Belt Tensioner Replacement</u> . Is the repair complete?	System OK	-

REPAIR INSTRUCTIONS - ON VEHICLE**INTAKE MANIFOLD COVER REPLACEMENT****Removal Procedure**

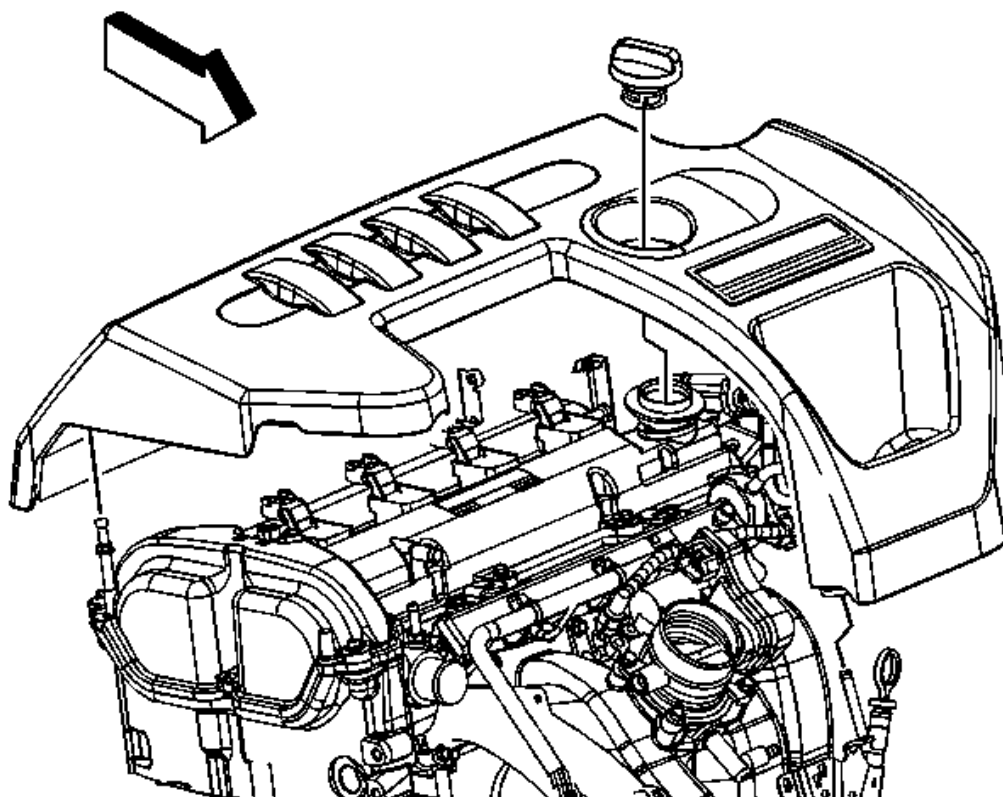


Fig. 25: View Of Intake Manifold Cover
Courtesy of GENERAL MOTORS CORP.

1. Remove the engine oil fill cap.
2. Grasp the intake manifold cover by the lower right inboard corner and pull up to disengage the cover from the stud.
3. Grasp the intake manifold cover by the upper left corner and pull up to disengage the cover from the stud.
4. Remove the intake manifold cover.

Installation Procedure

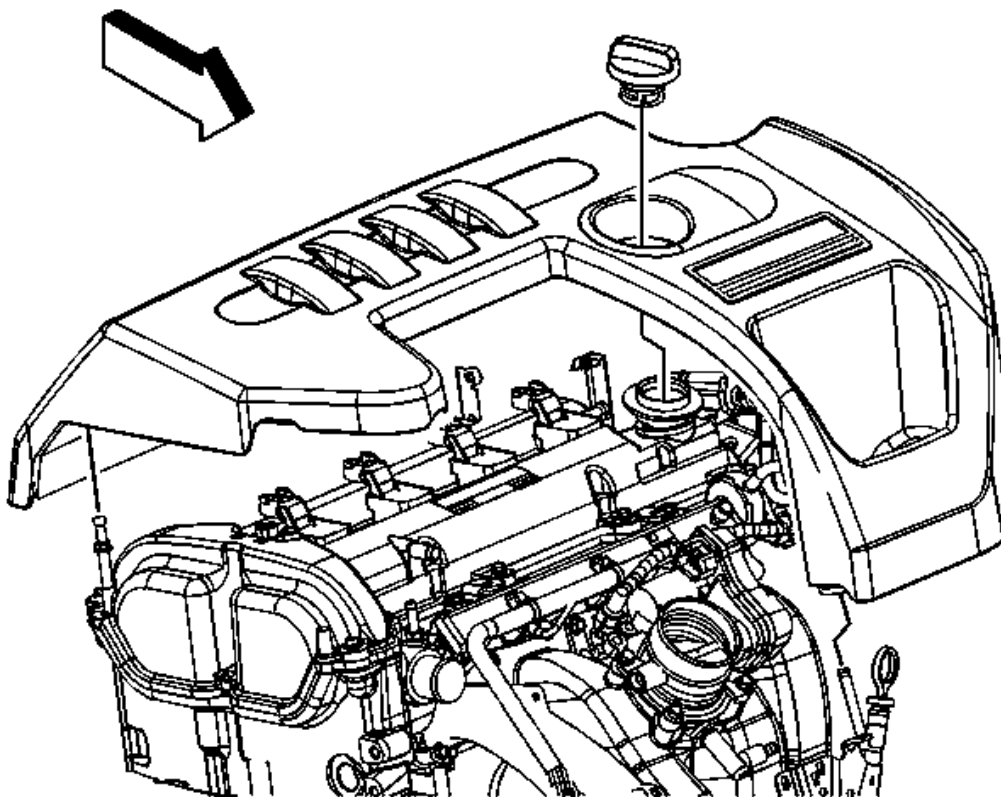


Fig. 26: View Of Intake Manifold Cover
Courtesy of GENERAL MOTORS CORP.

1. Place the intake manifold cover onto the engine over the studs.
2. Push down on the intake manifold cover directly over the lower right stud in order to engage the cover to the stud.
3. Push down on the intake manifold cover directly over the upper left stud in order to engage the cover to the stud.
4. Install the engine oil fill cap.

DRIVE BELT REPLACEMENT

Tools Required

J 44811 Accessory Belt Tensioner Unloader. See **Special Tools**.

Removal Procedure

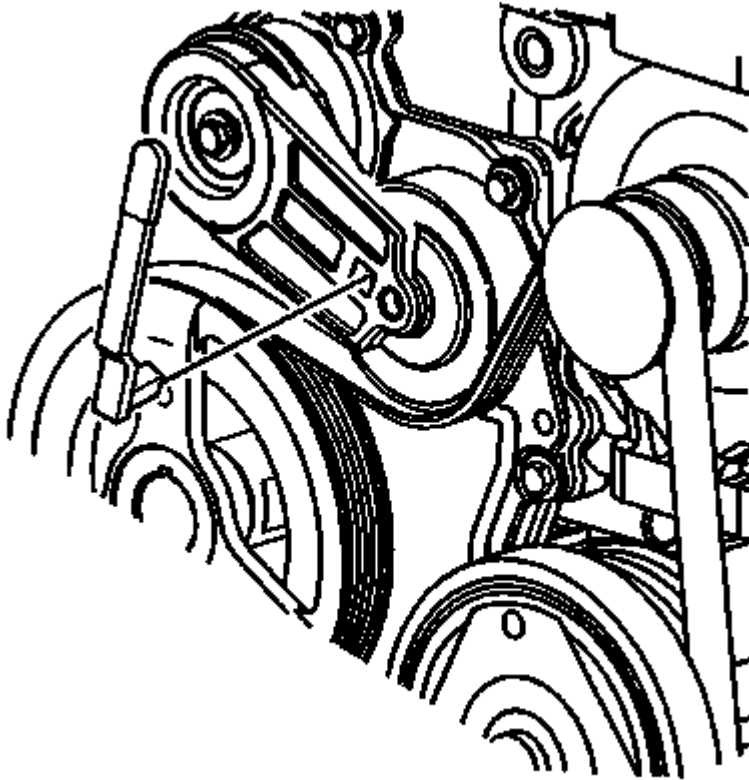


Fig. 27: View Of Drive Belt Tensioner And Special Tool
Courtesy of GENERAL MOTORS CORP.

1. Remove the engine splash shield. Refer to **Engine Splash Shield Replacement** .
2. Install the **J 44811** to the drive belt tensioner. See **Special Tools**.
3. Using the **J 44811** , rotate the tensioner counterclockwise in order to release the tensioner from the drive belt. See **Special Tools**.

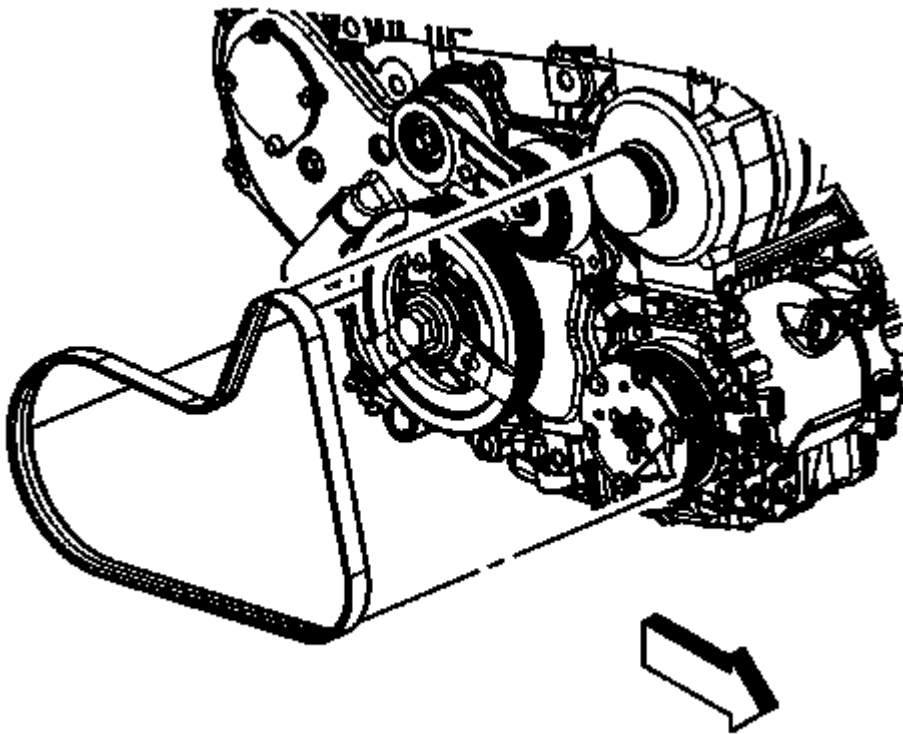


Fig. 28: View Of Drive Belt Routing
Courtesy of GENERAL MOTORS CORP.

4. Remove the drive belt.
5. Slowly rotate the **J 44811** and the tensioner clockwise in order to allow the tensioner to rest. See **Special Tools**.
6. Remove the **J 44811** from the drive belt tensioner. See **Special Tools**.

Installation Procedure

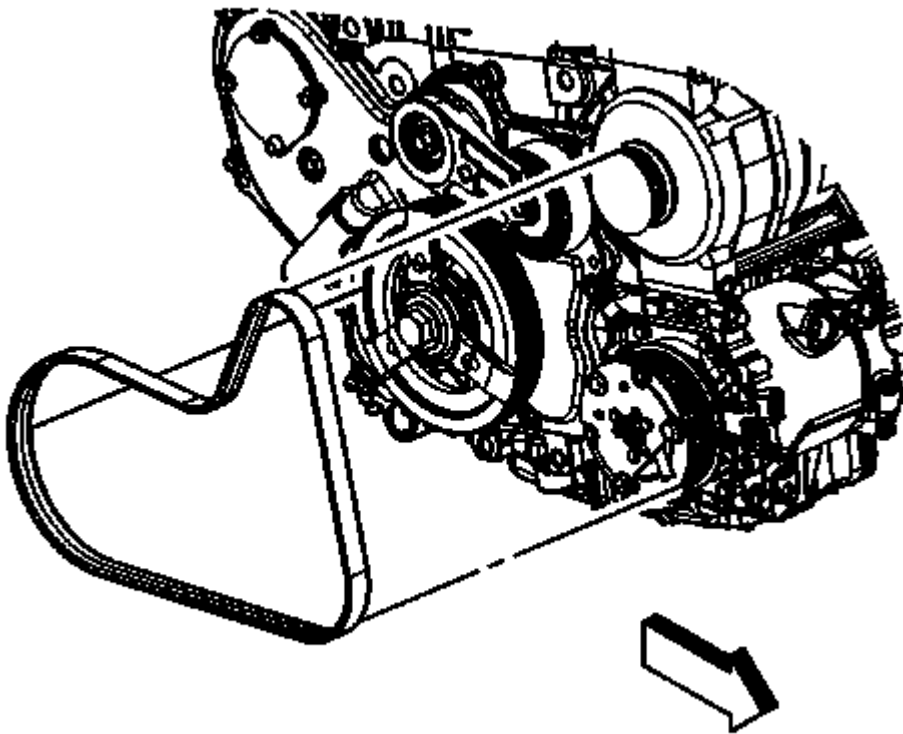


Fig. 29: View Of Drive Belt Routing
Courtesy of GENERAL MOTORS CORP.

1. Install and position the drive belt around all of the pulleys except for the drive belt tensioner.
2. Install the **J 44811** to the drive belt tensioner. See **Special Tools**.
3. Using the **J 44811** , rotate the tensioner counterclockwise. See **Special Tools**.
4. Position the drive belt under the tensioner pulley.

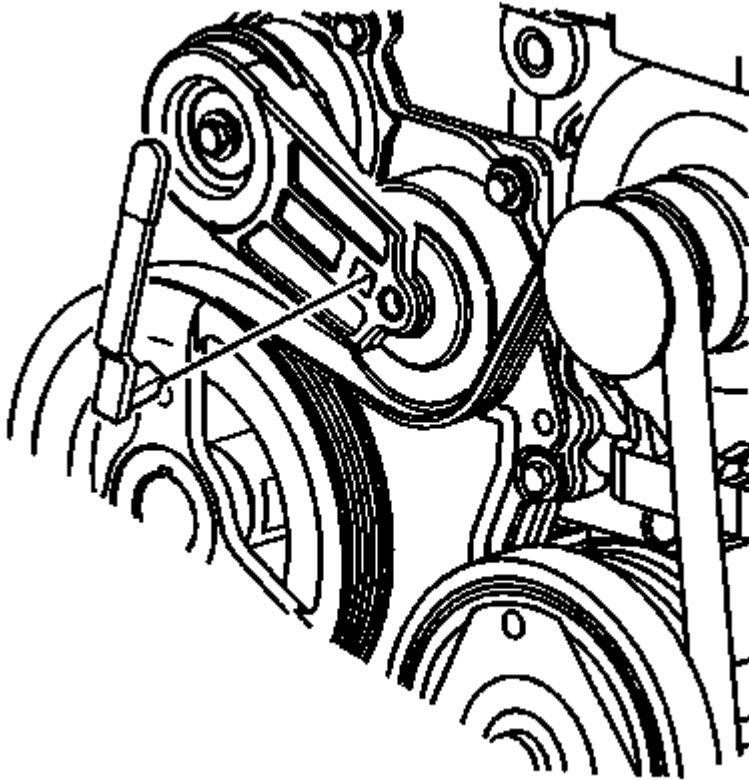


Fig. 30: View Of Drive Belt Tensioner And Special Tool
Courtesy of GENERAL MOTORS CORP.

5. Using the **J 44811** , rotate the tensioner clockwise in order to seat the tensioner pulley onto the drive belt. See **Special Tools**.
6. Install the engine splash shield. Refer to **Engine Splash Shield Replacement** .

DRIVE BELT TENSIONER REPLACEMENT

Removal Procedure

1. Remove the drive belt. Refer to **Drive Belt Replacement**.

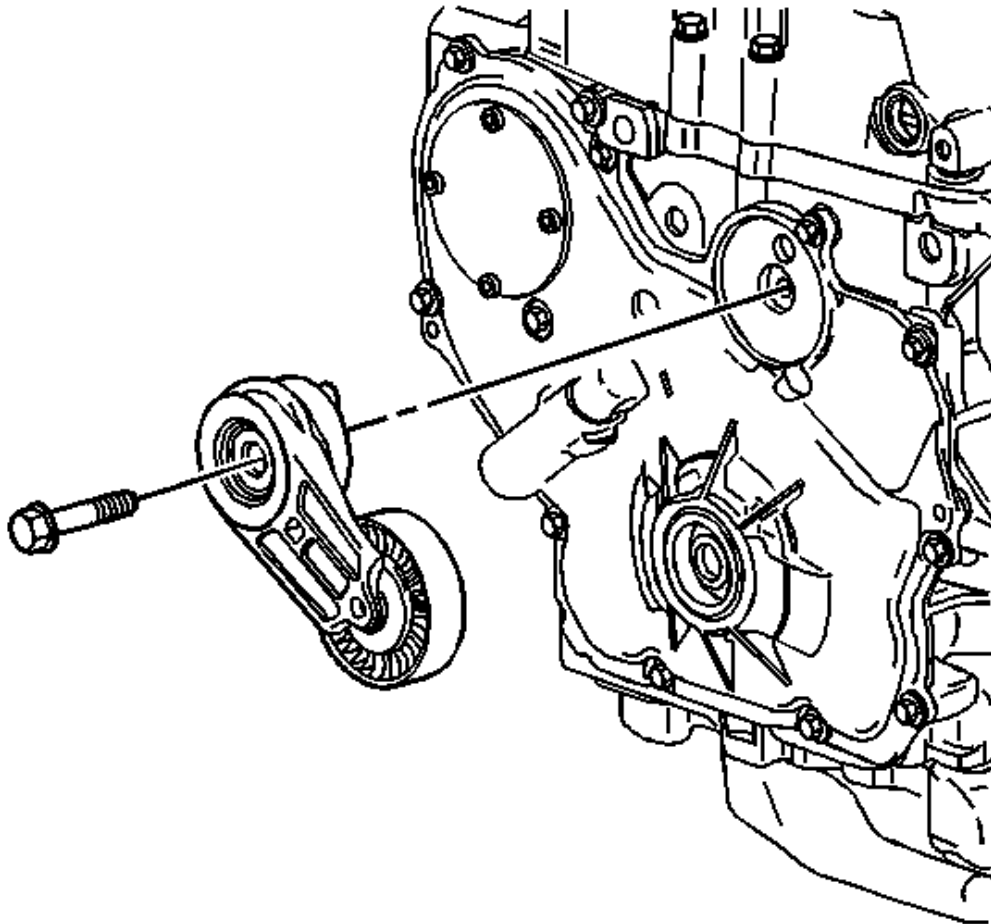


Fig. 31: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: To remove the tensioner bolt, an access hole has been provided through the inner and outer engine rail.

2. Remove the drive belt tensioner bolt.
3. Remove the drive belt tensioner.

Installation Procedure

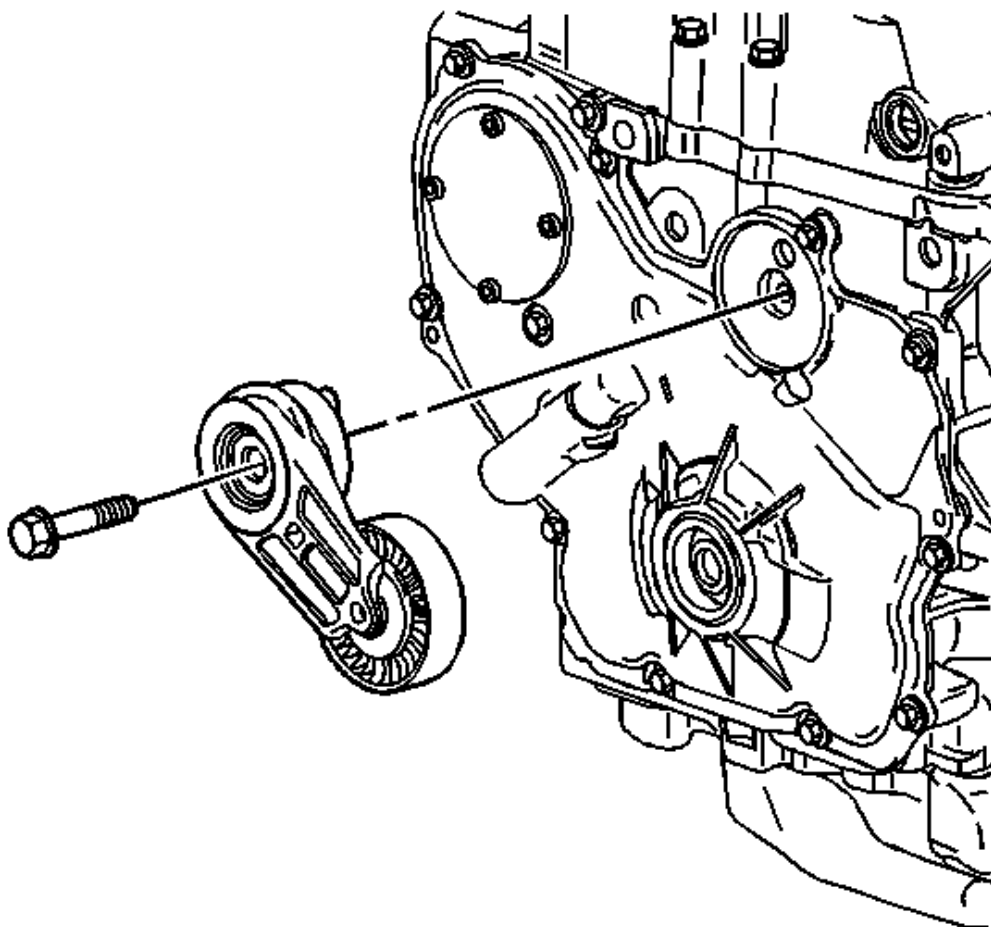


Fig. 32: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

1. Install the drive belt tensioner.

NOTE: Refer to **FASTENER NOTICE** .

2. Install the drive belt tensioner bolt.

Tighten: Tighten the drive belt tensioner bolt to 45 N.m (33 lb ft).

3. Install the drive belt. Refer to **Drive Belt Replacement**.

ENGINE OIL PRESSURE SENSOR AND/OR SWITCH REPLACEMENT

Removal Procedure

1. Disconnect the negative battery cable. Refer to **Battery Negative Cable Disconnection and Connection** .
2. Raise and support the vehicle. Refer to **Lifting and Jacking the Vehicle** .
3. Disconnect the engine oil pressure sensor electrical connector.

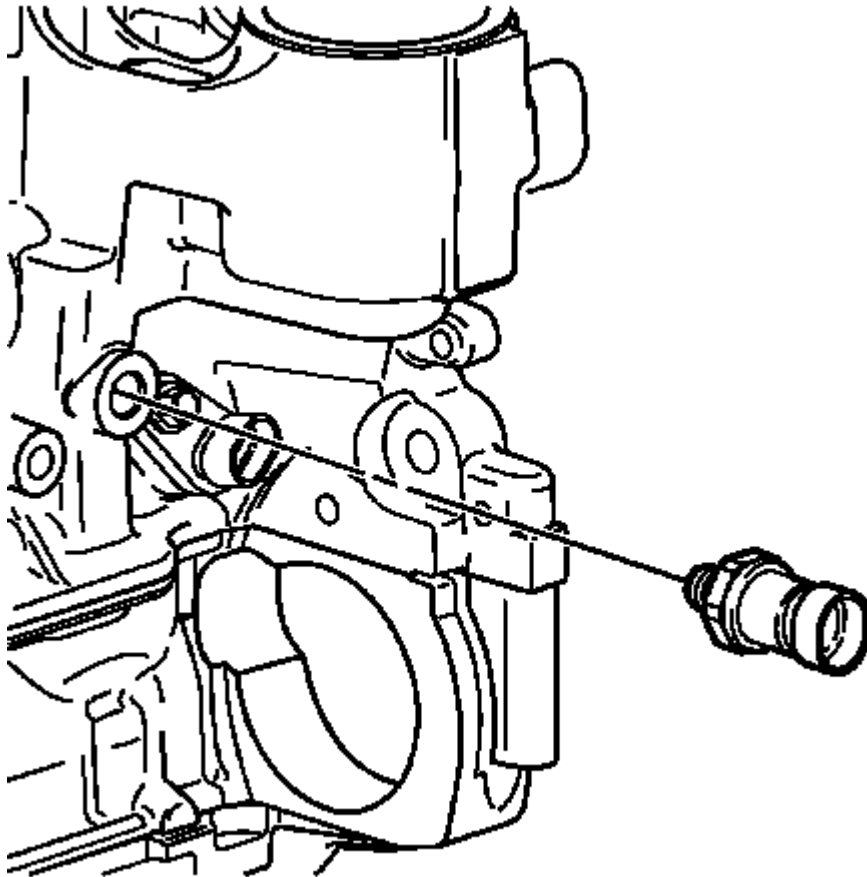


Fig. 33: View Of Engine Oil Pressure Sensor
Courtesy of GENERAL MOTORS CORP.

4. Remove the engine oil pressure sensor.

Installation Procedure

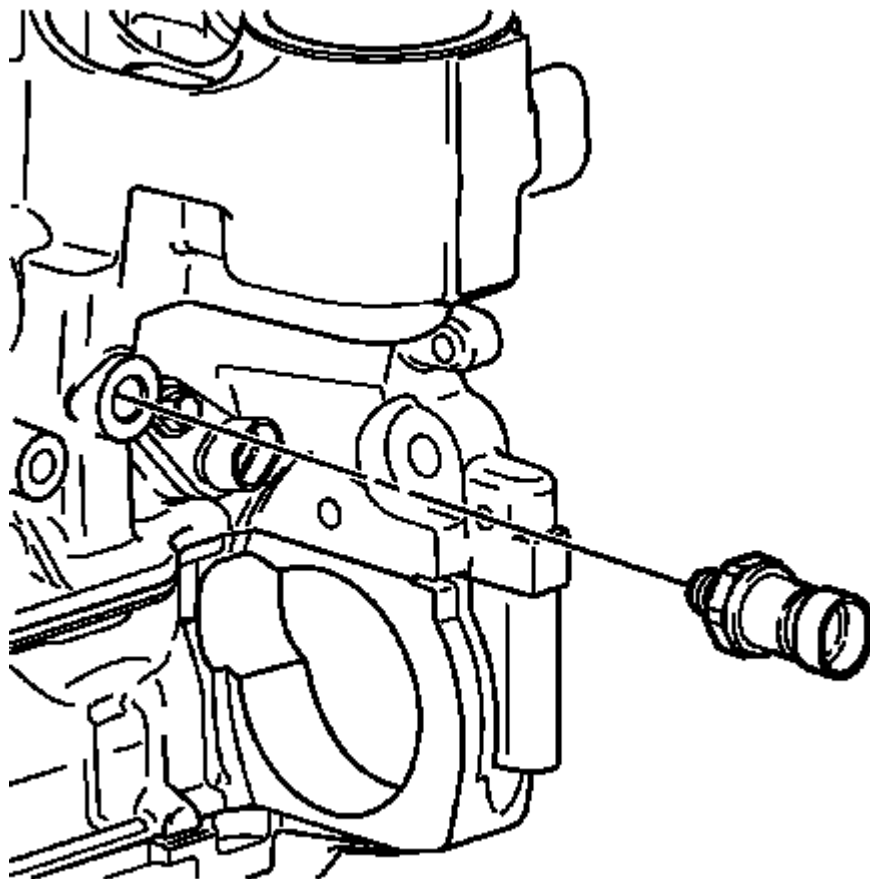


Fig. 34: View Of Engine Oil Pressure Sensor
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

1. Install the engine oil pressure sensor.

Tighten: Tighten the oil pressure switch to 22 N.m (16 lb ft).

2. Connect the engine oil pressure sensor electrical connector.
3. Lower the vehicle.
4. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection .

ENGINE MOUNT INSPECTION

IMPORTANT: Before replacing any engine mount due to suspected fluid loss, verify that the source of the fluid is the engine mount, not the engine or accessories.

1. Install the engine support fixture. Refer to Engine Support Fixture.
2. Observe the engine mount while raising the engine. Raising the engine removes the weight from the

engine mount and creates slight tension on the rubber.

3. Replace the engine mount if the engine mount exhibits any of the following conditions:
 - The hard rubber is covered with heat check cracks.
 - The rubber is separated from the metal plate of the engine mount.
 - The rubber is split through the center of the engine mount.
 - The engine mount itself is leaking fluid.
4. For engine mount replacement. Refer to **Engine Mount Replacement**.

ENGINE MOUNT REPLACEMENT

Removal Procedure

1. Remove the air cleaner assembly. Refer to **Air Cleaner Assembly Replacement** .

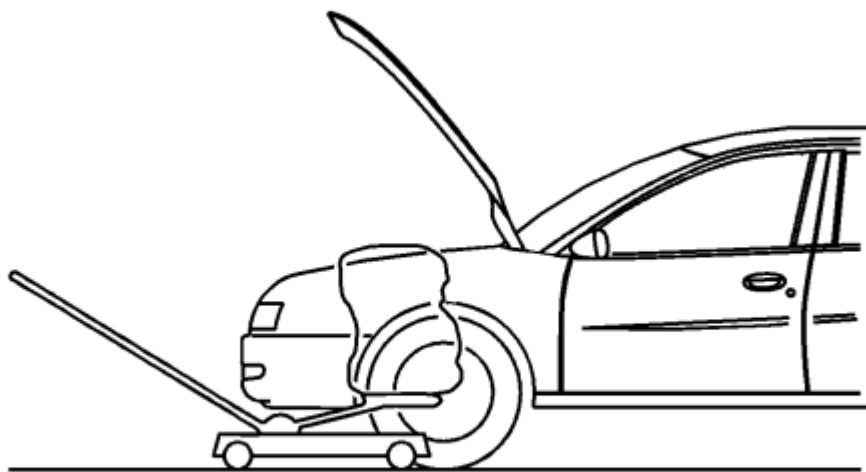


Fig. 35: Supporting Engine/Transmission With Hydraulic Floor Jack
Courtesy of GENERAL MOTORS CORP.

2. Support the engine with a hydraulic floor jack. Use a piece of wood between the jack and the oil pan.

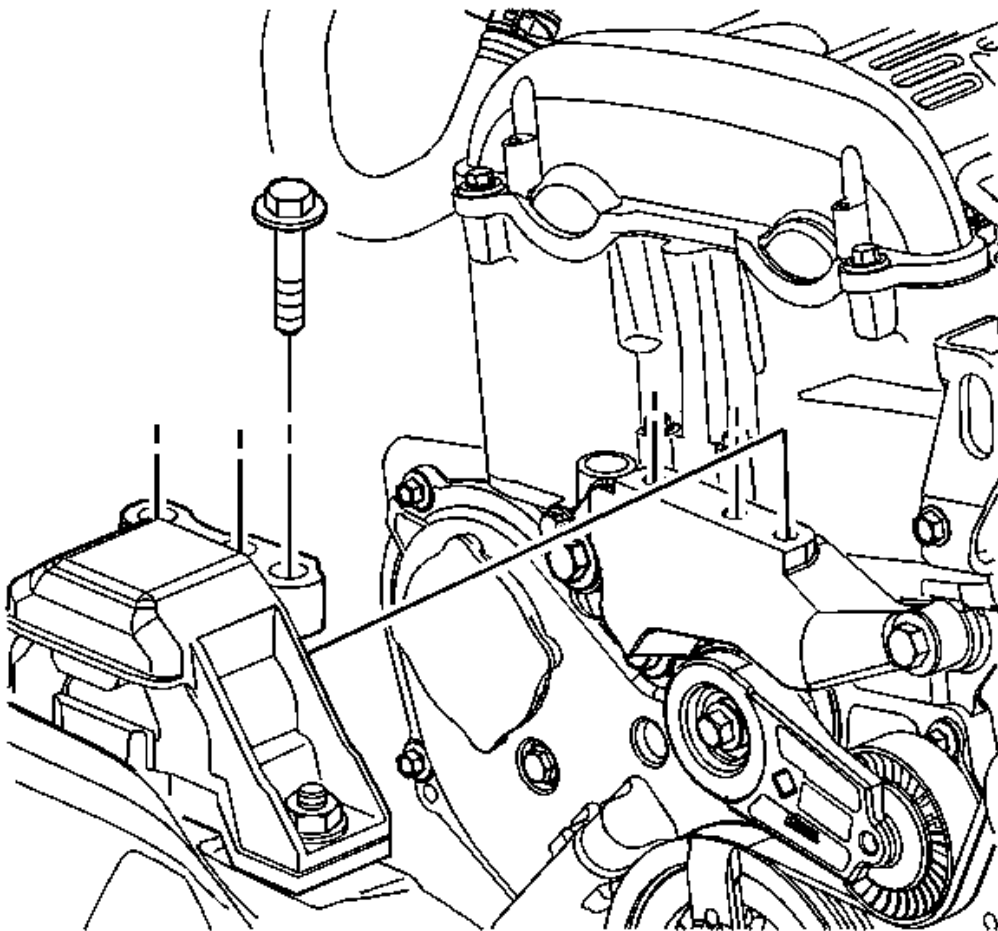
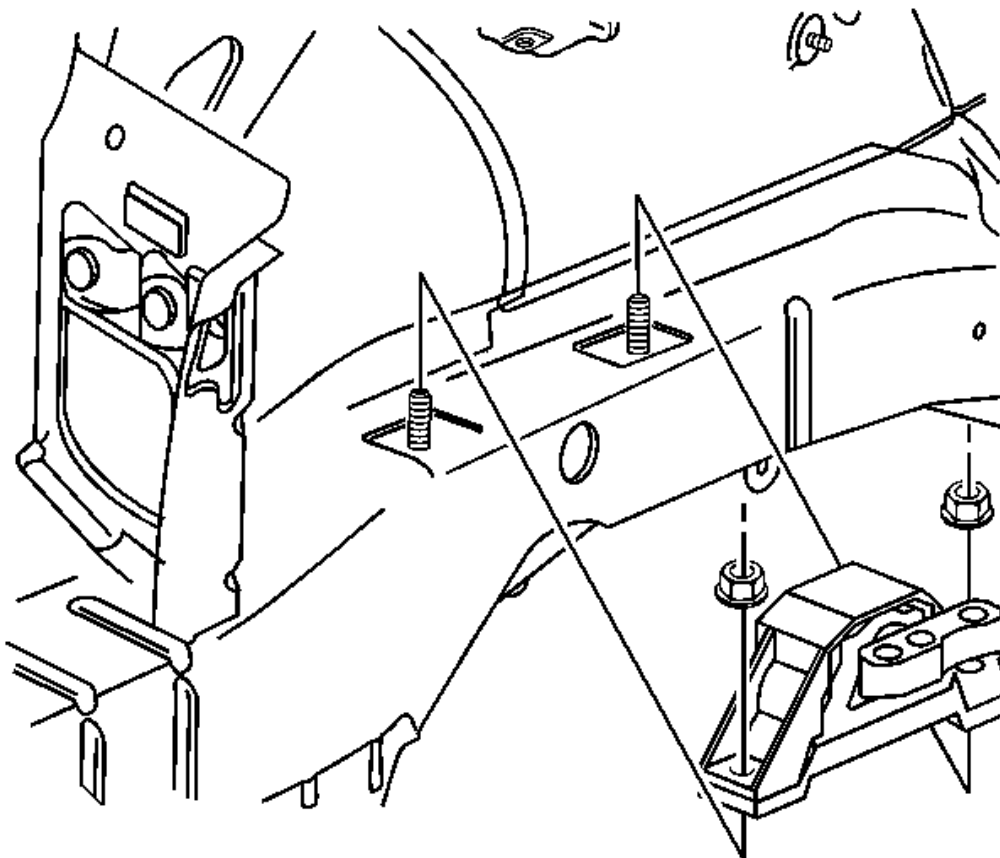


Fig. 36: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

3. Remove the engine mount to intermediate bracket bolts.



Courtesy of GENERAL MOTORS CORP.

4. Remove the engine mount to midrail nuts.
5. Remove the engine mount from the engine compartment.

Installation Procedure

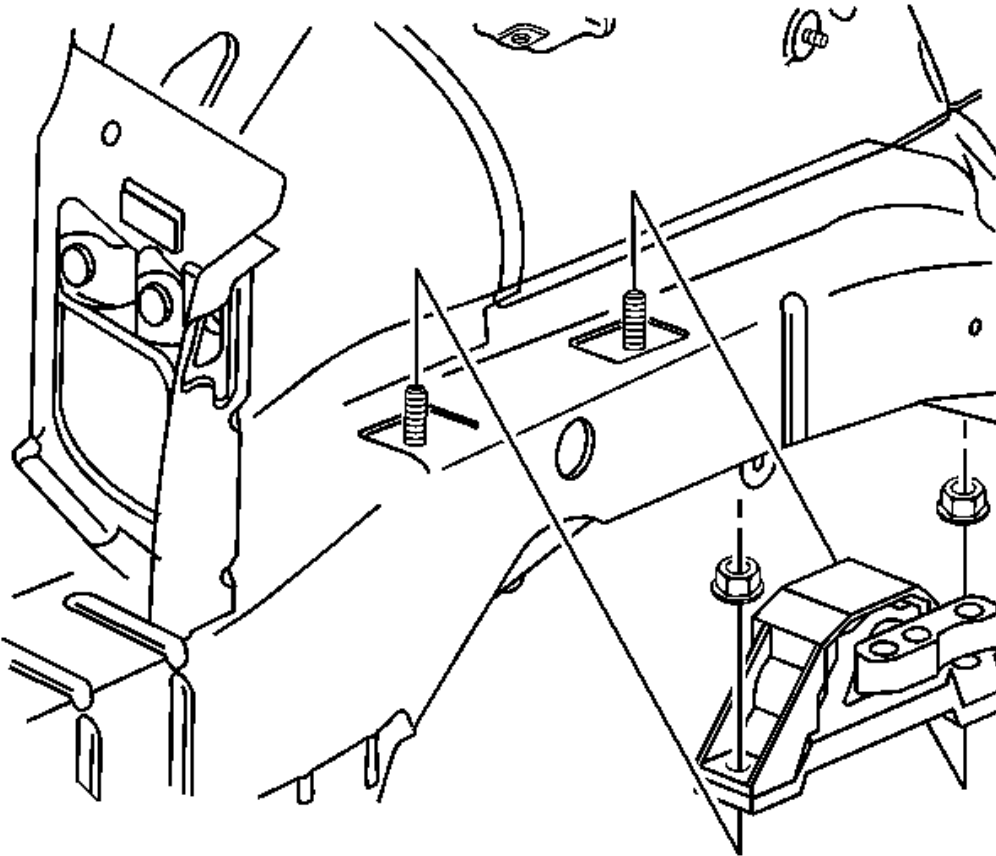


Fig. 38: View Of Engine Mount
Courtesy of GENERAL MOTORS CORP.

1. Place the engine mount onto the midrail and hand start the nuts.

NOTE: Refer to **FASTENER NOTICE** .

2. Tighten the engine mount to midrail nuts.

Tighten: Tighten the nuts to 100 N.m (74 lb ft).

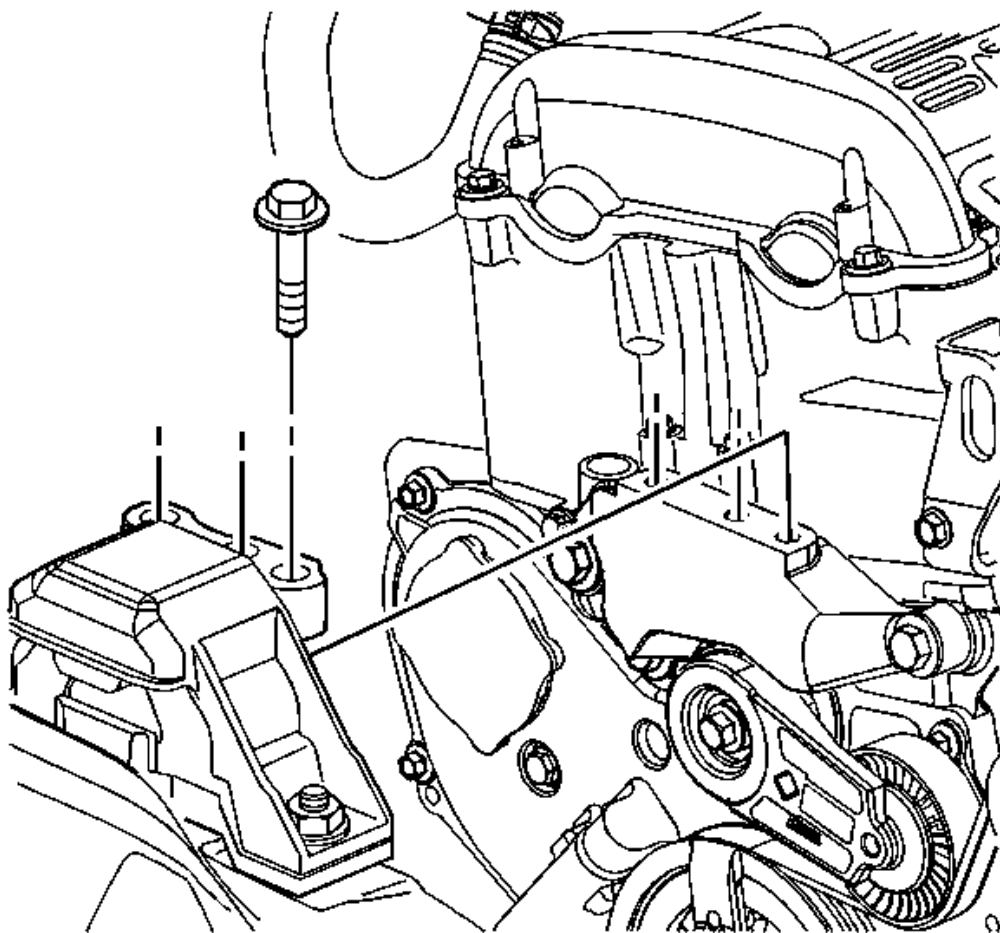


Fig. 39: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: The engine mount to intermediate bracket bolts must be hand started. Do not pry the engine mount to align the holes.

3. Hand start the engine mount to intermediate bracket bolts.
4. Tighten the engine mount to intermediate bracket bolts.

Tighten: Tighten the bolts to 50 N.m (37 lb ft).

5. Remove the hydraulic floor jack.
6. Install the air cleaner assembly. Refer to [Air Cleaner Assembly Replacement](#) .

ENGINE MOUNT REPLACEMENT - RIGHT SIDE**Removal Procedure**

IMPORTANT: Torque axis mounting systems allow more engine movement than other mounting systems. The engine movement is the design intent of the mounting system. Do not replace the torque axis mounts unless the mount or the rubber is damaged.

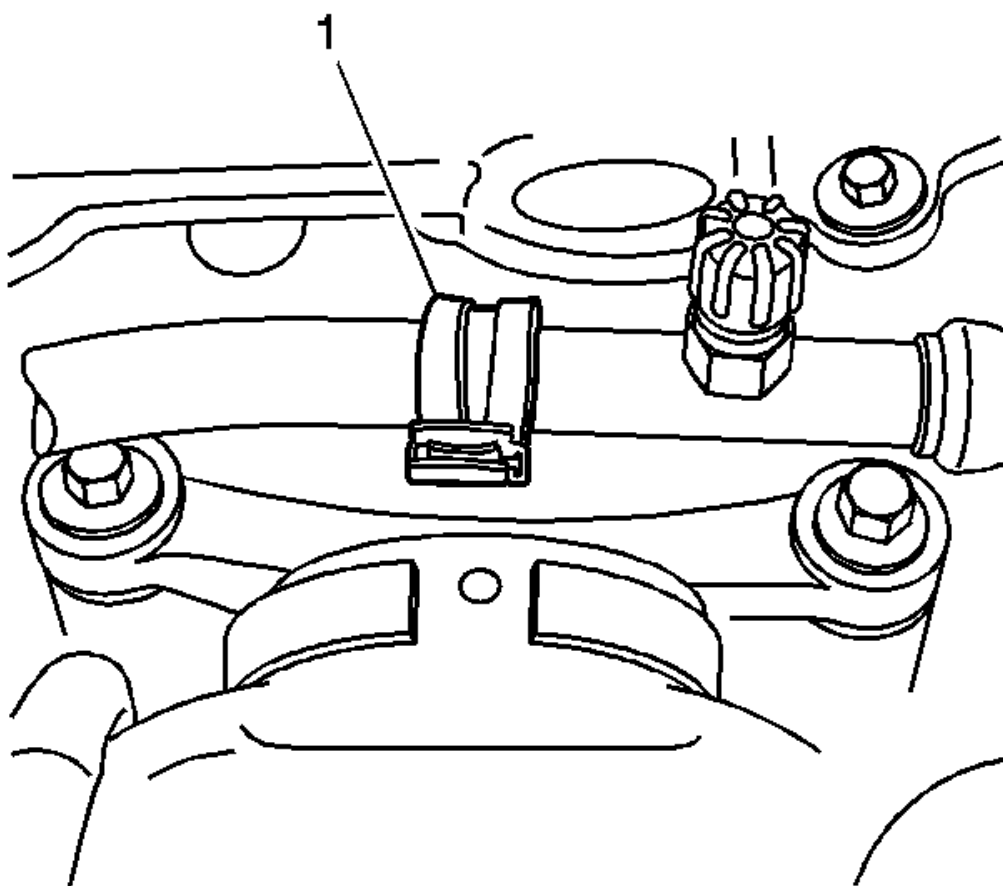


Fig. 40: View Of A/C Low Pressure Line Retaining Bracket
Courtesy of GENERAL MOTORS CORP.

1. Remove the A/C low pressure line retaining bracket (1) nut. Refer to **COMPRESSOR HOSE ASSEMBLY REPLACEMENT (L61, LE5)**.

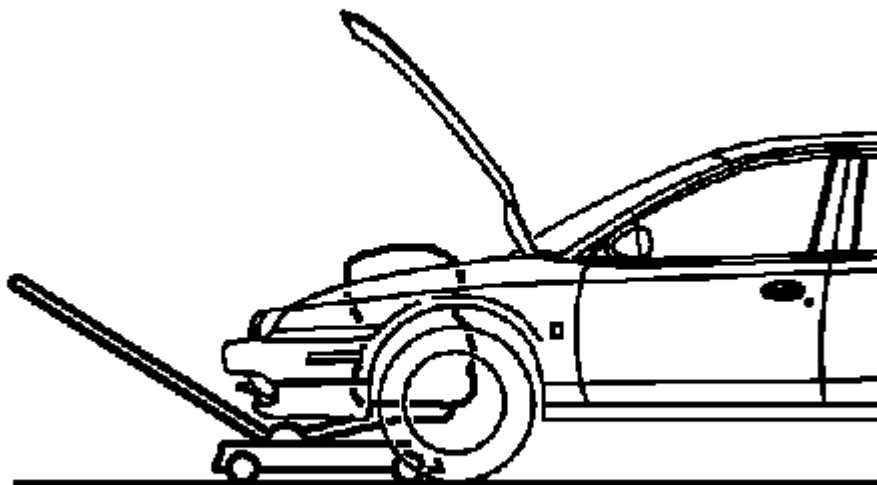


Fig. 41: Supporting Engine With Floor Jack
Courtesy of GENERAL MOTORS CORP.

2. Using a block of wood between the floor jack and the oil pan, support the engine.

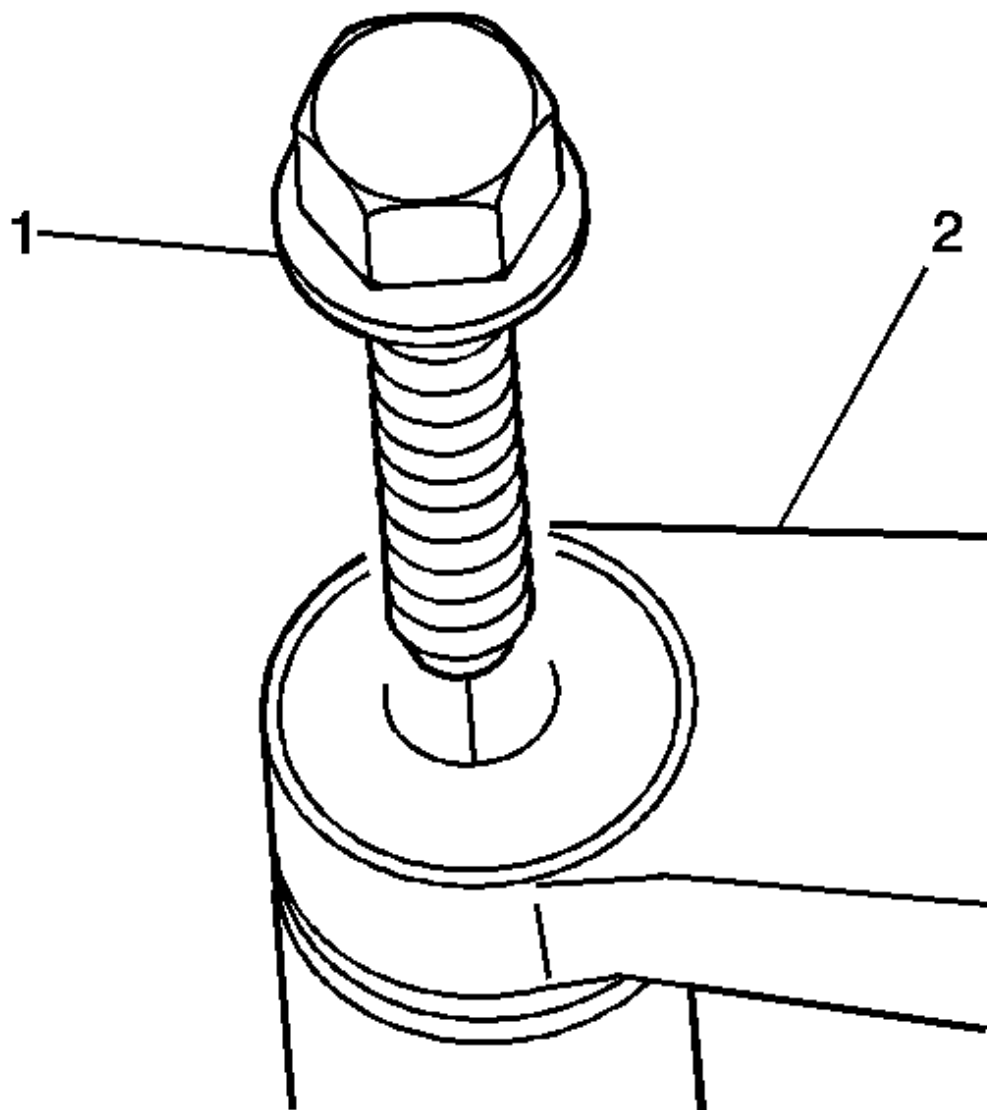


Fig. 42: View Of Engine Mount To Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

3. Remove the engine mount (2) to bracket bolts (1).

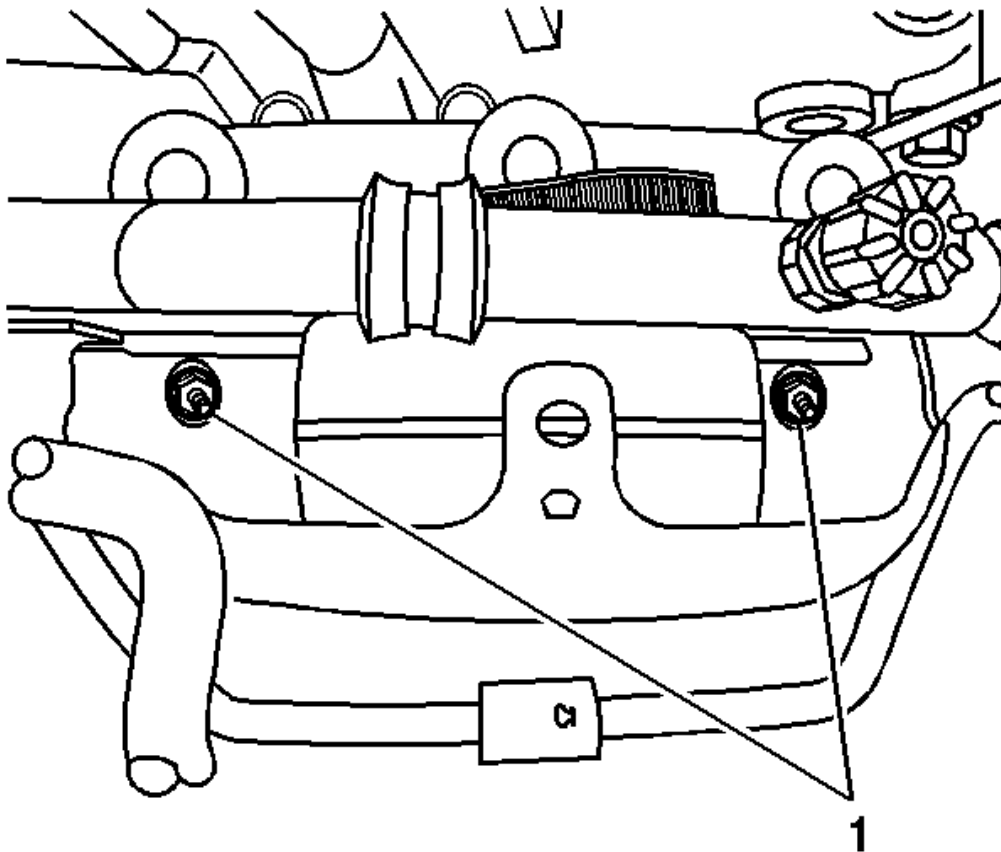


Fig. 43: View Of Engine Mount To Body Nuts
Courtesy of GENERAL MOTORS CORP.

4. Remove the engine mount to body nuts (1).
5. Remove the engine mount.

Installation Procedure

1. Install the engine mount to the vehicle.

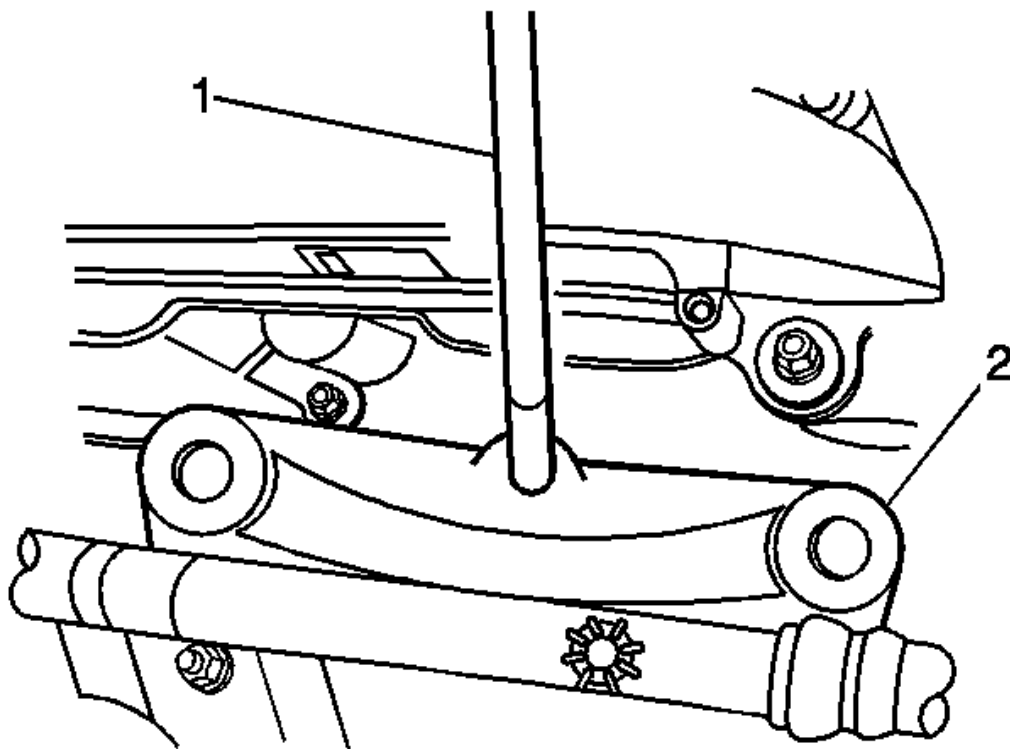


Fig. 44: Aligning Engine Mount
Courtesy of GENERAL MOTORS CORP.

2. Align the engine mount (2) to the mount bracket using a dowel (1).

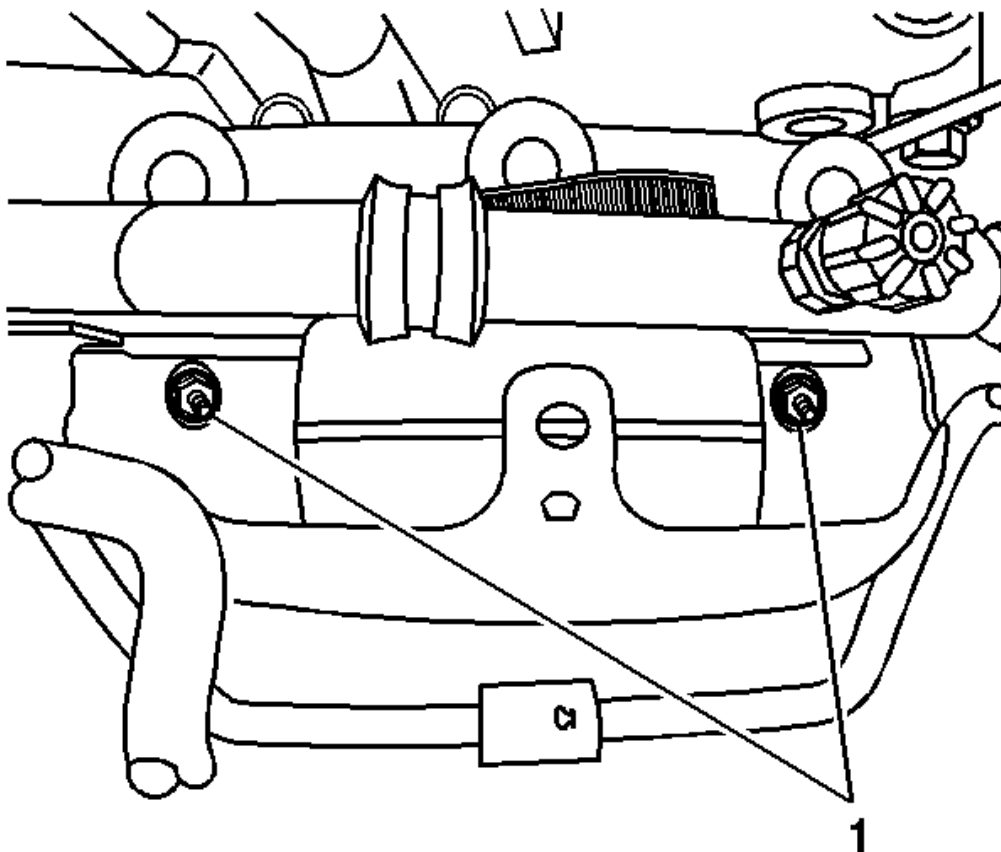


Fig. 45: View Of Engine Mount To Body Nuts
Courtesy of GENERAL MOTORS CORP.

3. Hand tighten the engine mount to body nuts (1).

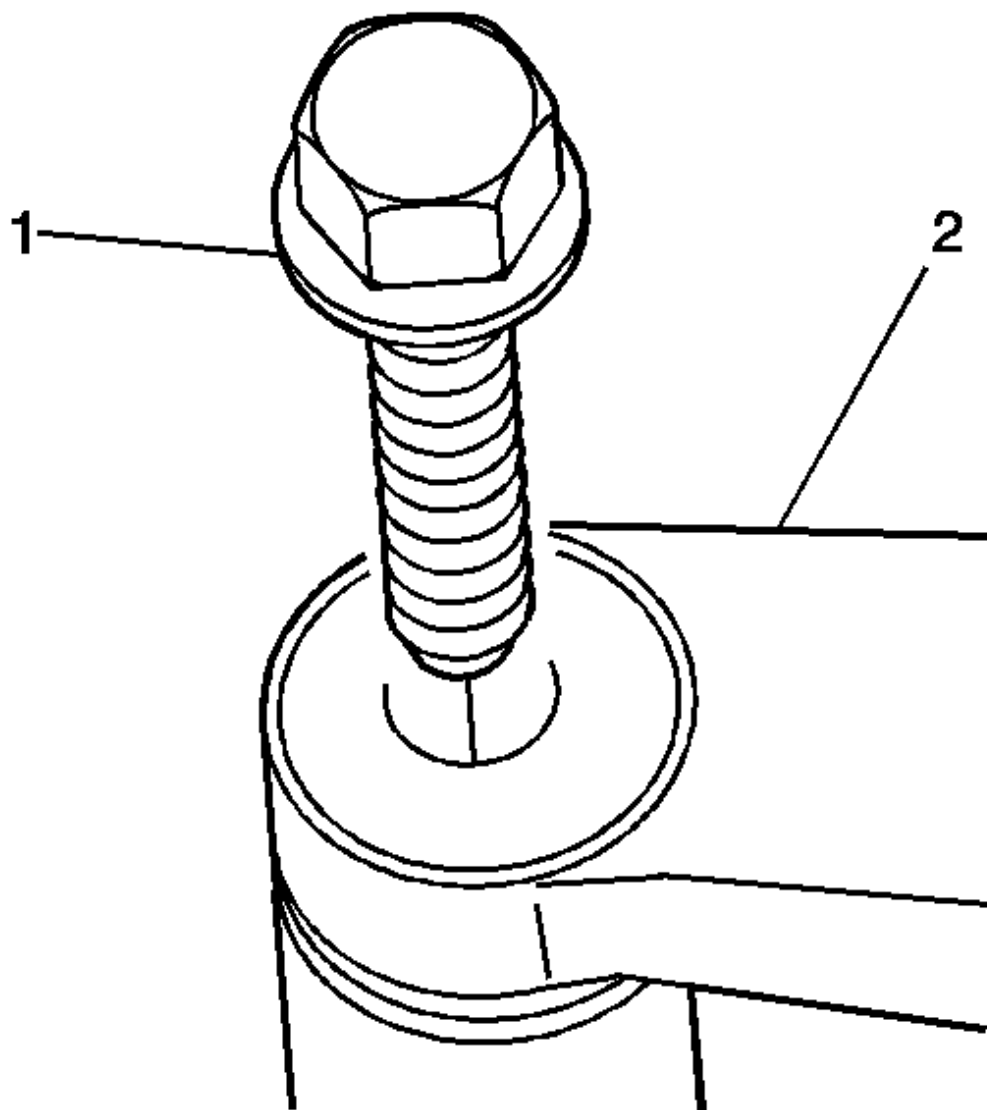


Fig. 46: View Of Engine Mount To Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

4. Install the engine mount (2) to bracket bolts (1).

Tighten:

- Tighten the engine mount to body nuts to 66 N.m (49 lb ft).
- Tighten the engine mount to bracket bolts to 130 N.m (96 lb ft) plus 45 degrees.

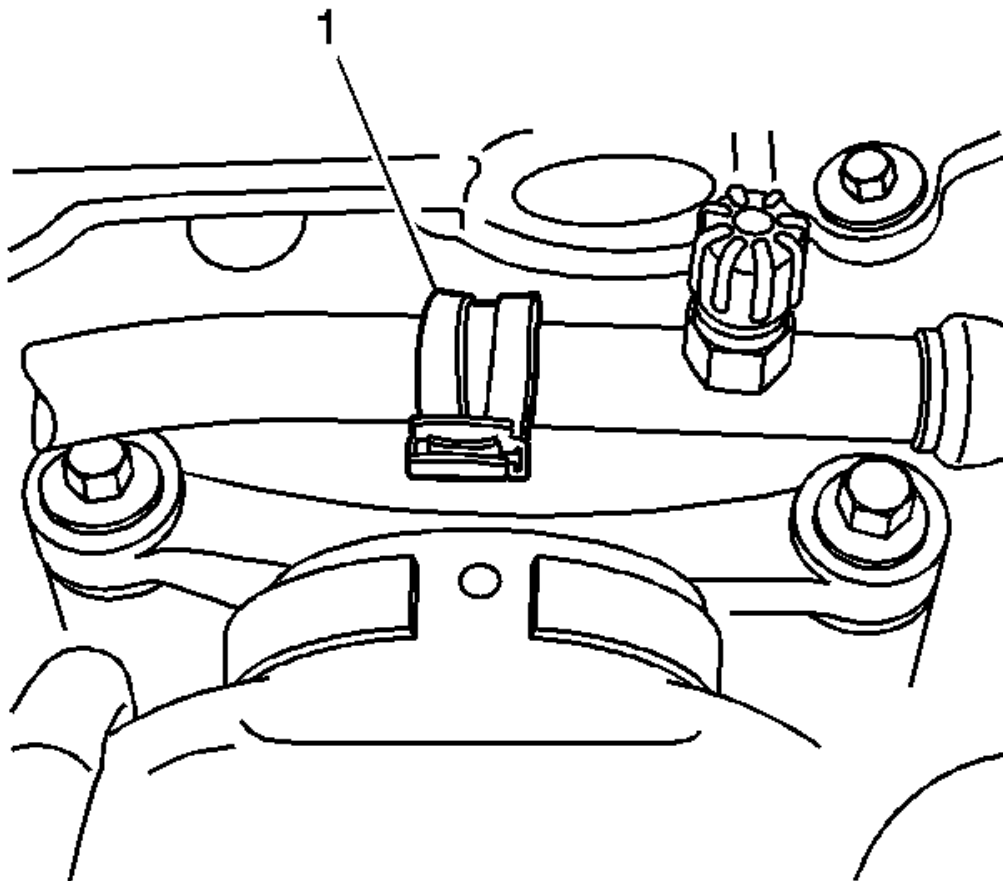


Fig. 47: View Of A/C Low Pressure Line Retaining Bracket
Courtesy of GENERAL MOTORS CORP.

5. Install the A/C low pressure line retaining bracket (1) nut. Refer to **Compressor Hose Assembly Replacement (L61, LE5)** .

Tighten: Tighten the nut to 10 N.m (89 lb in).

6. Remove the floor jack.

ENGINE AND TRANSMISSION MOUNT BALANCING - ALL MOUNTS

IMPORTANT: Follow the balance procedure in the order listed in the following steps.
Powertrain mounts must be tightened in sequence.

1. Raise and support the vehicle. Refer to Lifting and Jacking the Vehicle .

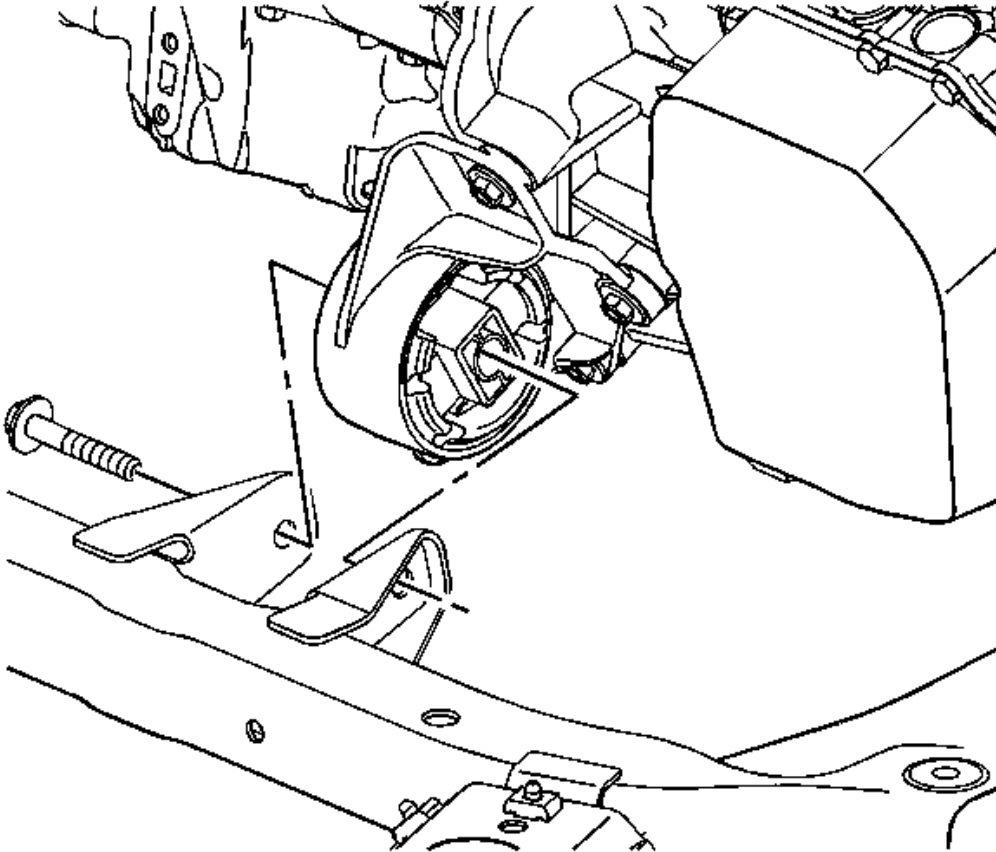


Fig. 48: View Of Front Transmission Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

2. Loosen the front transmission mount through bolt. Do not remove.

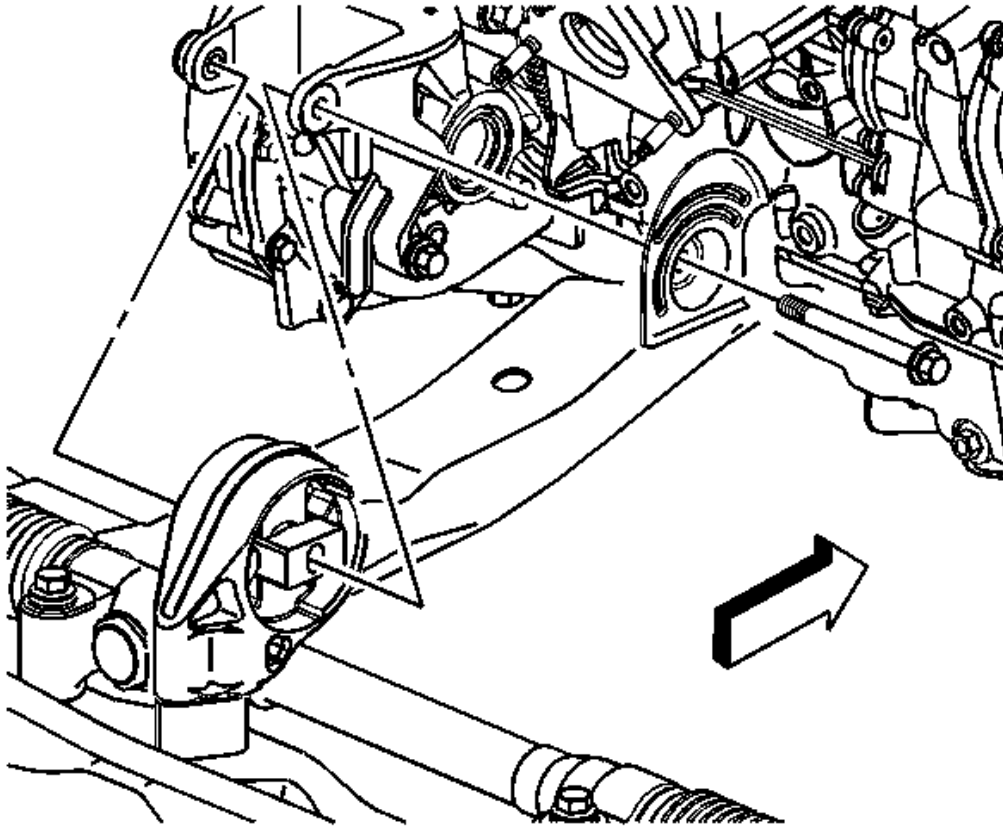


Fig. 49: View Of Rear Transaxle Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

3. Loosen the rear transmission mount through bolt. Do not remove.
4. Position two floor jacks with wood blocks under the engine and transmission to support the powertrain assembly.

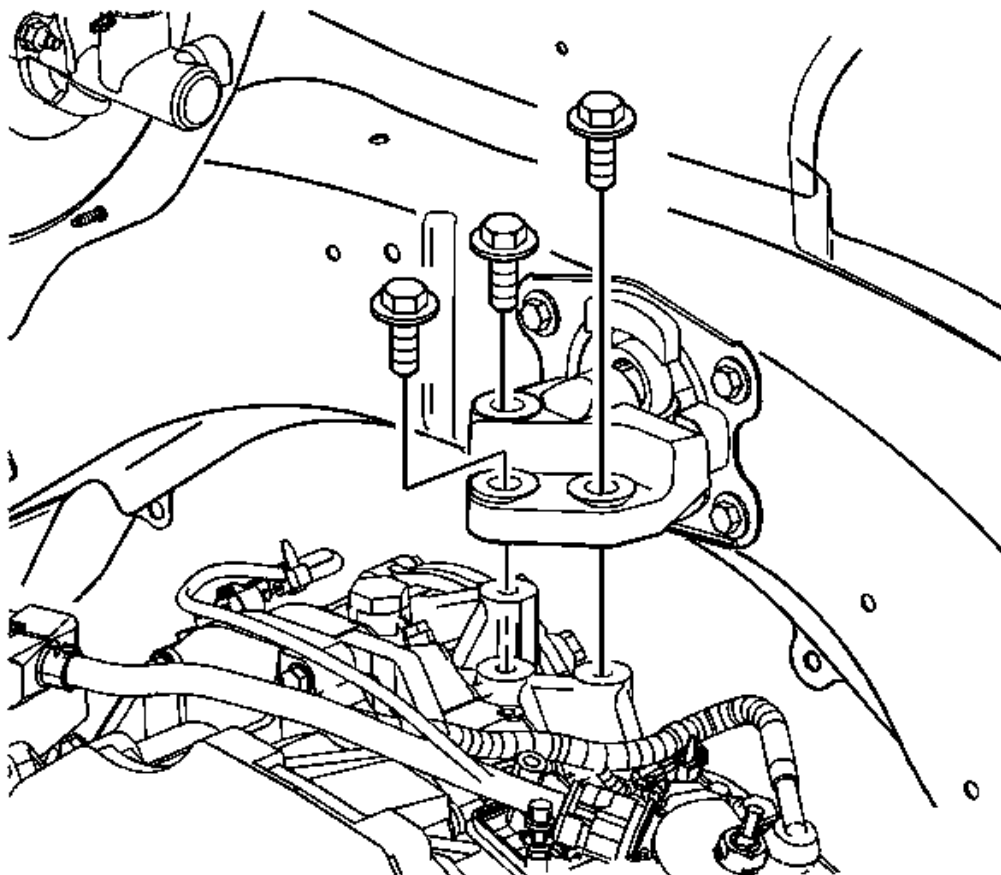


Fig. 50: View Of Transmission Mount-To-Transmission Bolts
Courtesy of GENERAL MOTORS CORP.

5. From the engine compartment, loosen the transmission mount to transmission bolts.

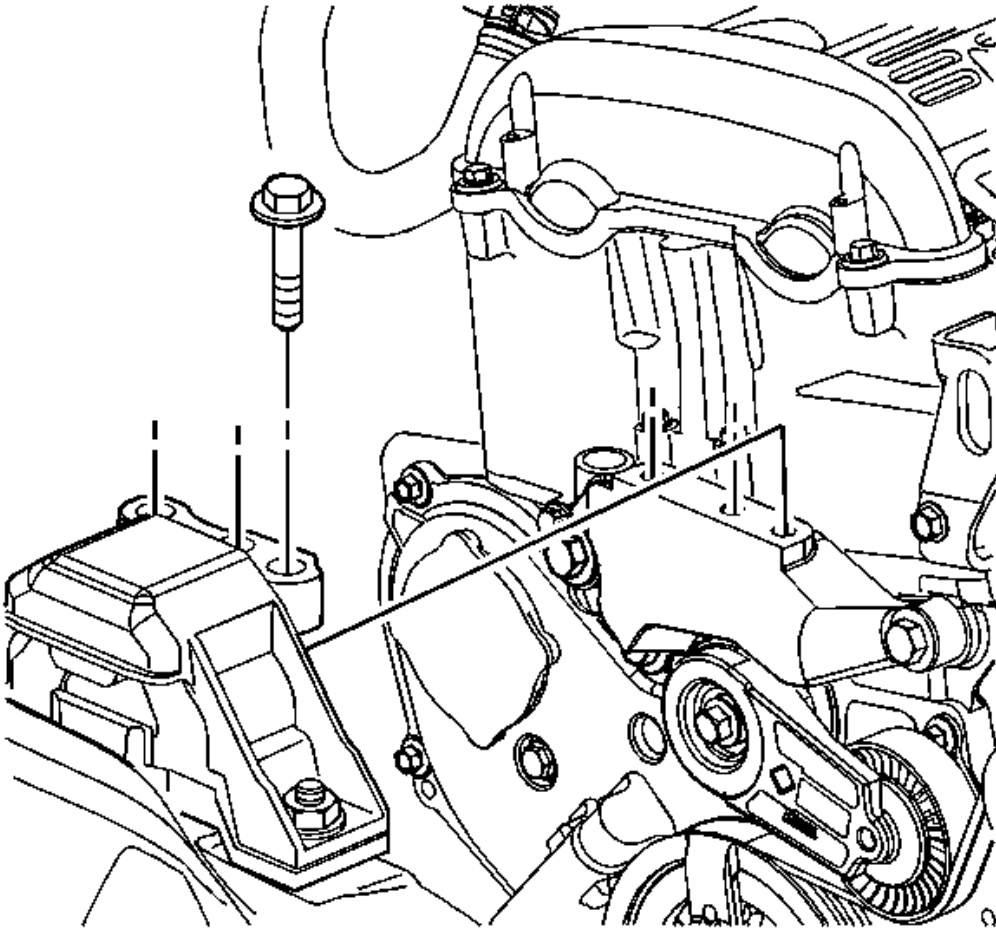


Fig. 51: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

6. Loosen the engine mount to intermediate bracket bolts.
7. Reposition the floor jacks to allow a 1/8 inch gap between the mount and mount bracket.

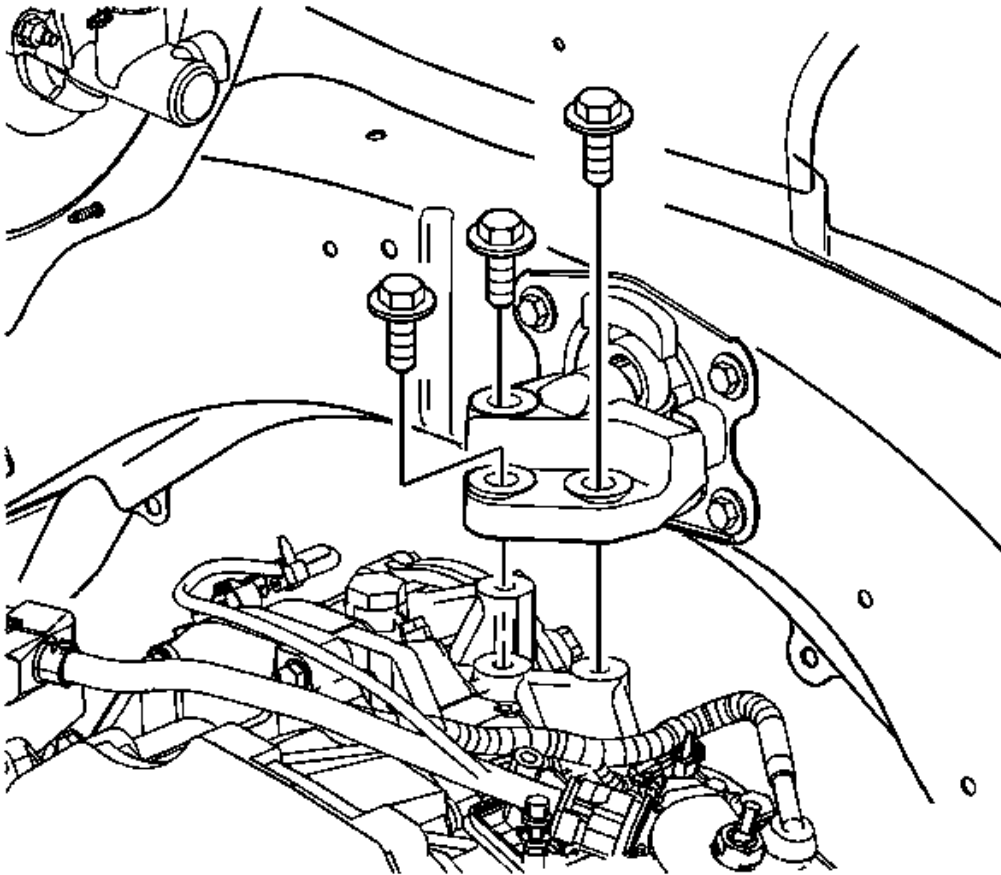


Fig. 52: View Of Transmission Mount-To-Transmission Bolts
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

8. Tighten the transmission mount to transmission bolts using the following sequence:
 1. Rear bolt
 2. Middle bolt
 3. Front bolt

Tighten: Tighten the bolts to 45 N.m (33 lb ft).

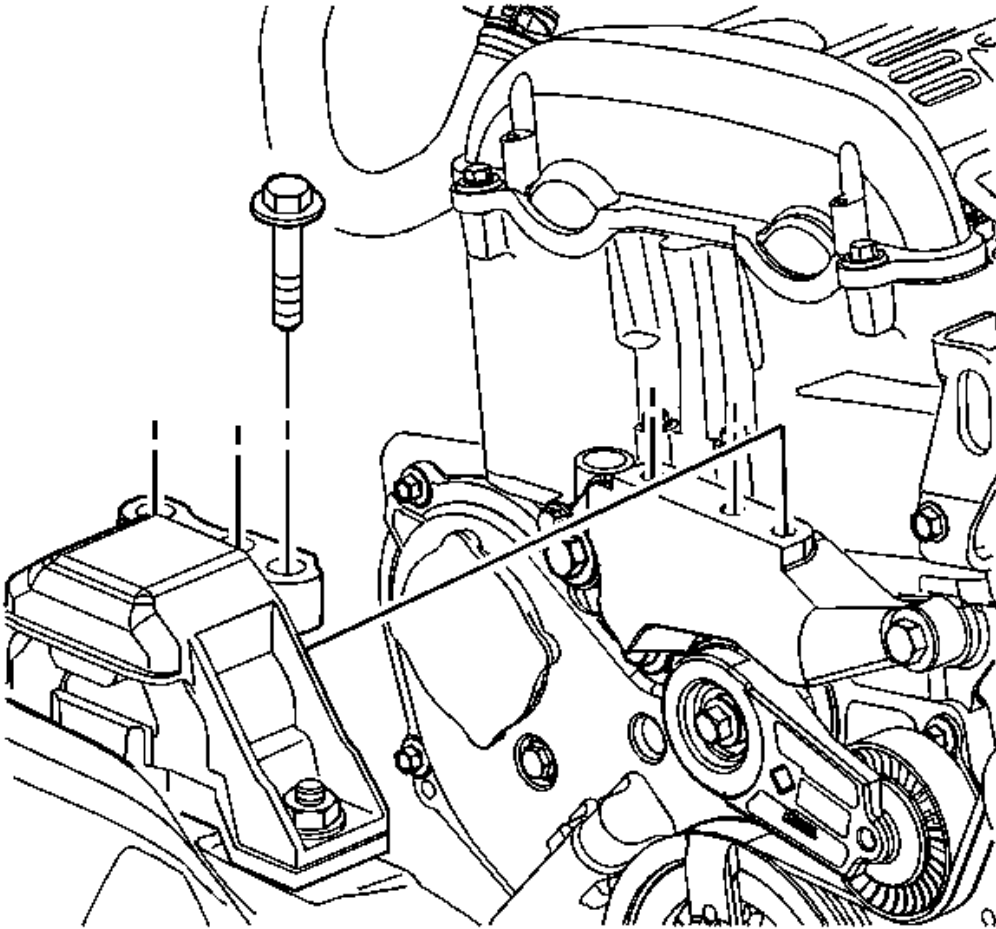


Fig. 53: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

9. Tighten the engine mount to intermediate bracket bolts starting with the center bolt.

Tighten: Tighten the bolts to 50 N.m (37 lb ft).

10. Remove the floor jacks.
11. Shake the powertrain vigorously from front to rear and allow the powertrain to settle.

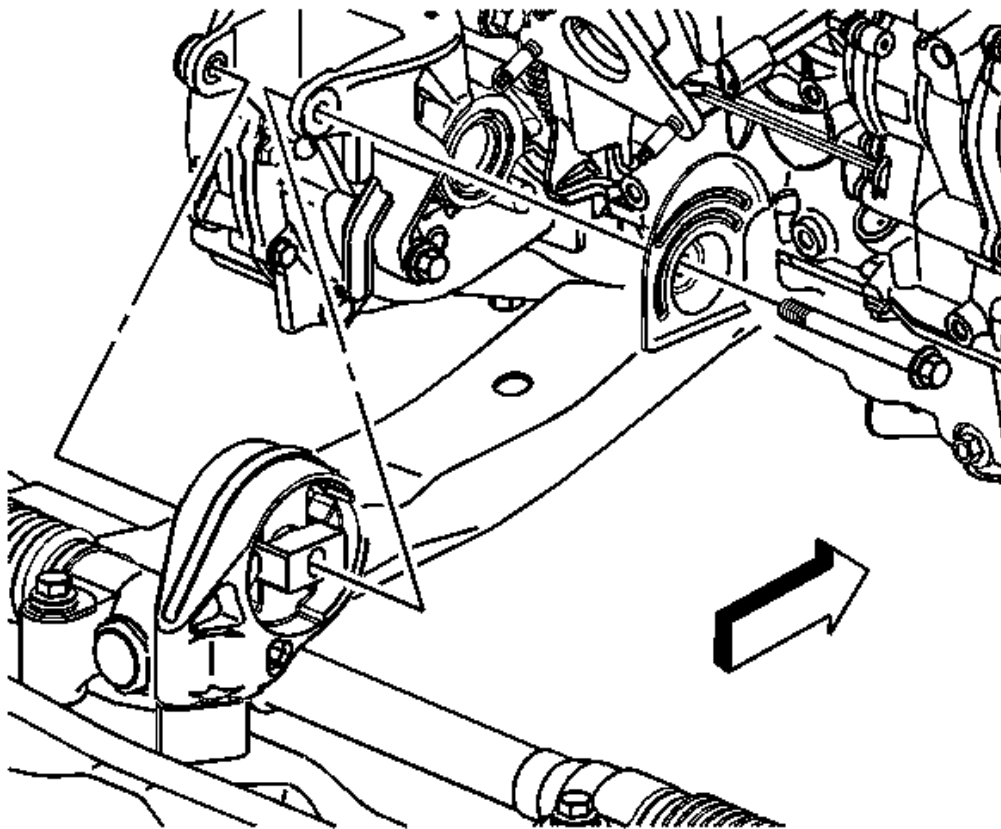


Fig. 54: View Of Rear Transaxle Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

12. Tighten the rear transmission mount through bolt.

Tighten: Tighten the bolts to 100 N.m (74 lb ft).

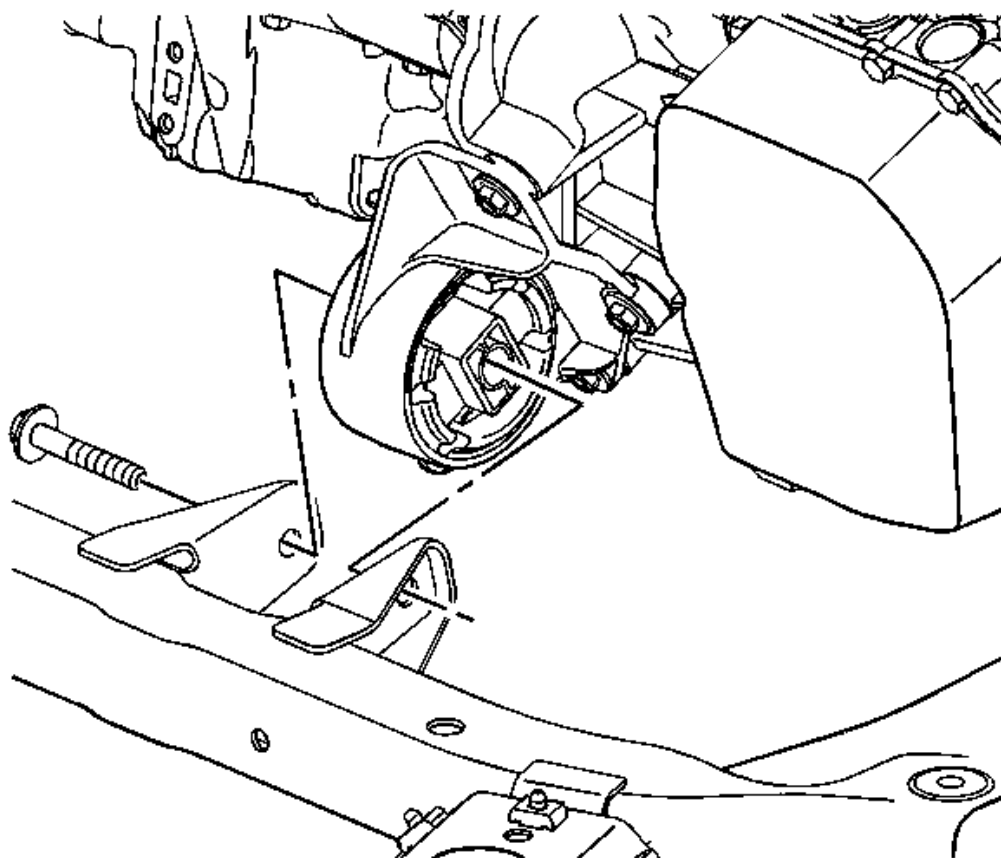


Fig. 55: View Of Front Transmission Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

13. Tighten the front transmission mount through bolt.

Tighten: Tighten the bolts to 100 N.m (74 lb ft).

14. Lower the vehicle.

POWERTRAIN MOUNT BALANCE - LOWER MOUNT

IMPORTANT: Follow the balance procedure in the order listed in the following steps.
Powertrain mounts must be tightened in sequence.

1. Raise and support the vehicle. Refer to Lifting and Jacking the Vehicle .

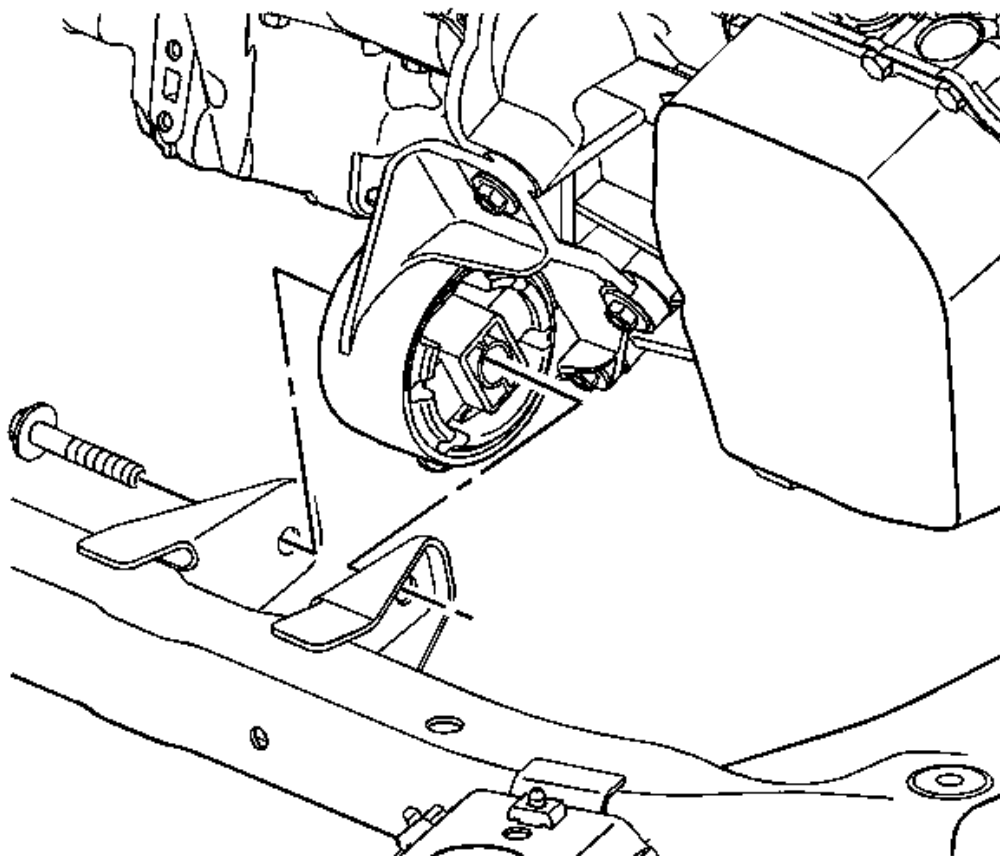


Fig. 56: View Of Front Transmission Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

2. Loosen the front transmission mount through bolt. Do not remove.

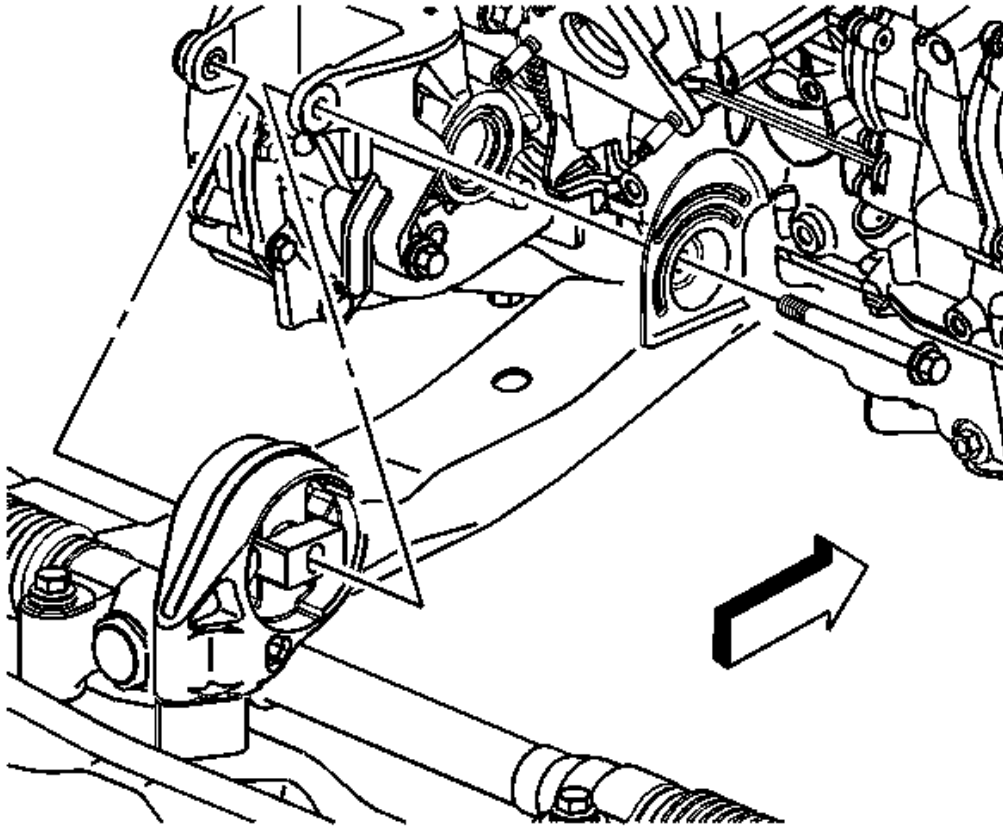


Fig. 57: View Of Rear Transaxle Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

3. Loosen the rear transmission mount through bolt. Do not remove.
4. Shake the powertrain vigorously from front to rear and allow powertrain to settle.

NOTE: Refer to Fastener Notice .

5. Tighten the rear transmission mount through bolt.

Tighten: Tighten the bolt to 100 N.m (74 lb ft).

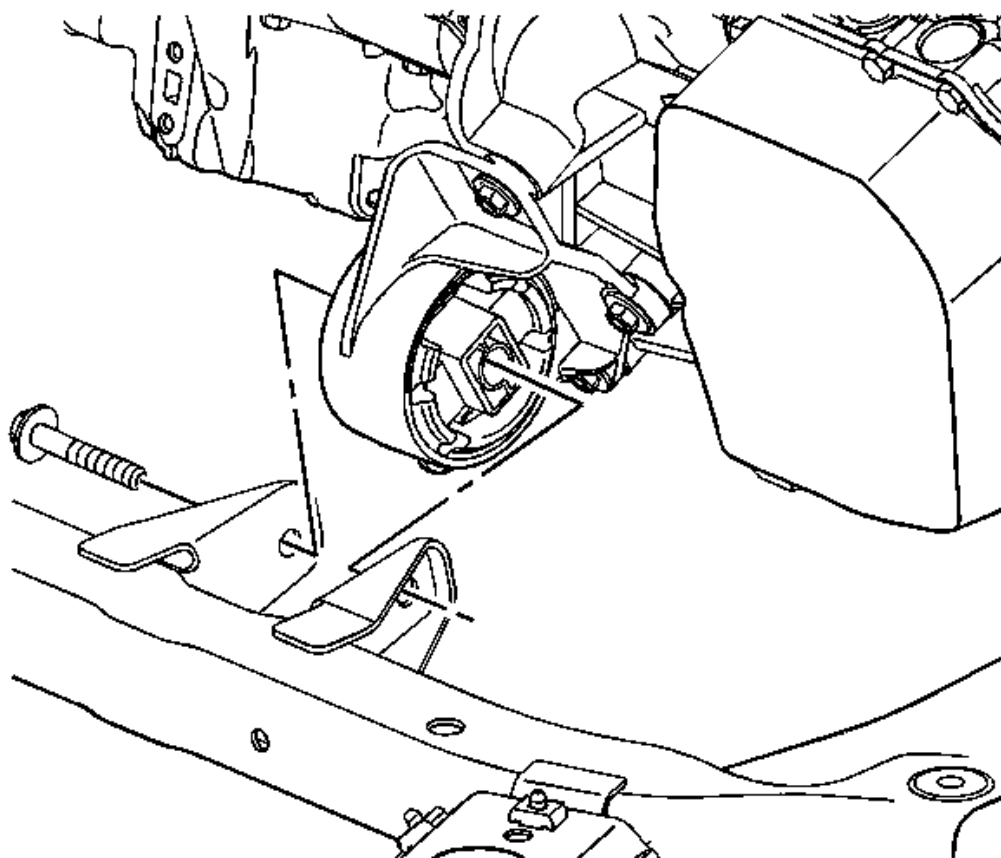


Fig. 58: View Of Front Transmission Mount Through Bolt
Courtesy of GENERAL MOTORS CORP.

6. Tighten the front transmission mount through bolt.

Tighten: Tighten the bolt to 100 N.m (74 lb ft).

7. Lower the vehicle.

ENGINE MOUNT BRACKET REPLACEMENT - RIGHT SIDE

Removal Procedure

1. Remove the engine mount. Refer to **Engine Mount Replacement**.

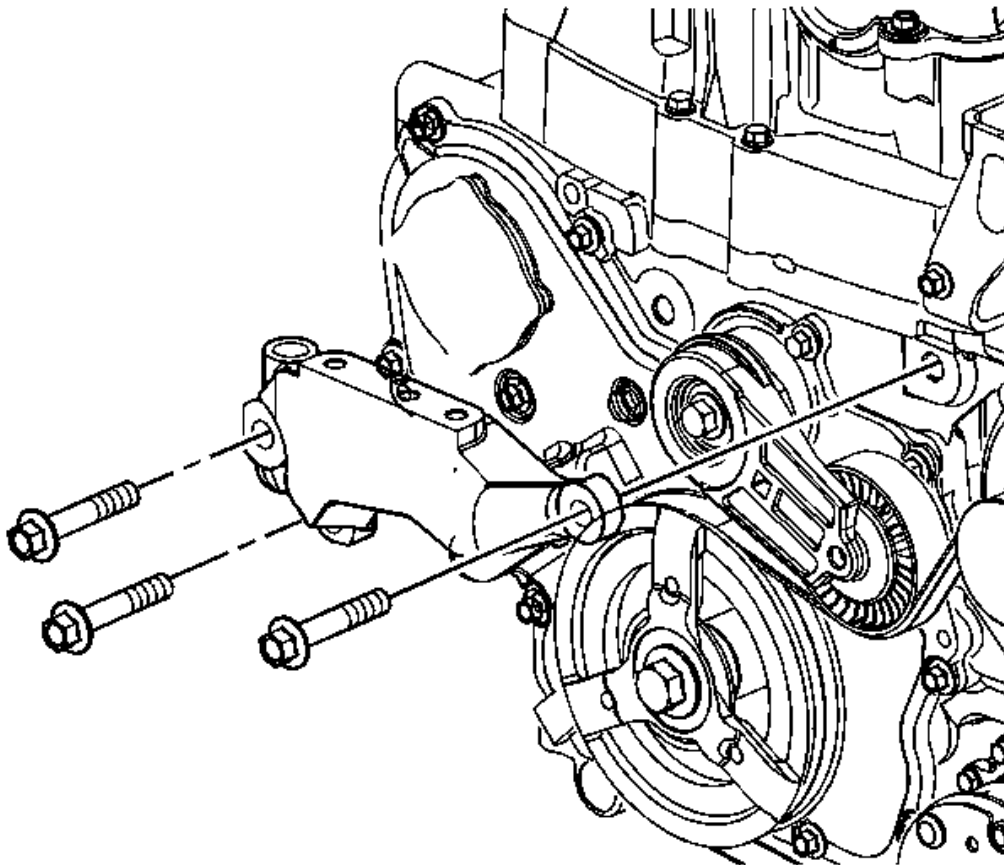


Fig. 59: View Of Intermediate Bracket
Courtesy of GENERAL MOTORS CORP.

2. Remove the intermediate bracket to engine bolts.
3. Remove the intermediate bracket from the engine.

Installation Procedure

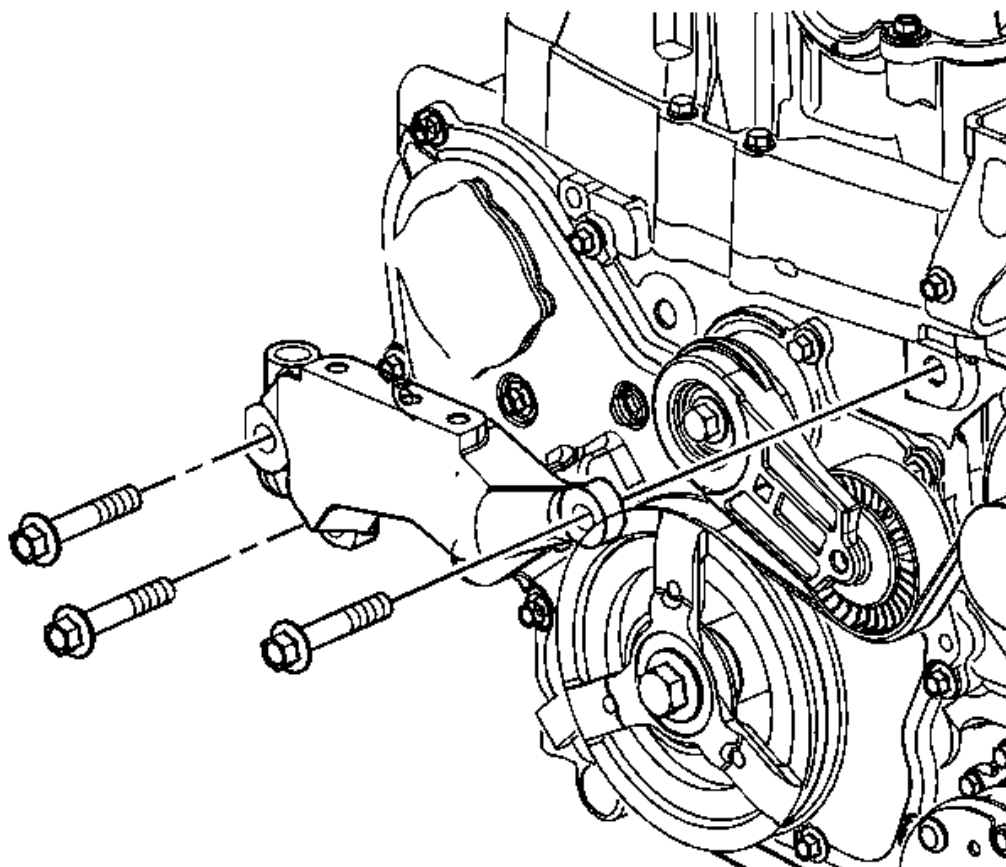


Fig. 60: View Of Intermediate Bracket
Courtesy of GENERAL MOTORS CORP.

1. Install the intermediate bracket to the engine.
2. Hand tighten the engine mount intermediate bracket bolts in the following locations:
 - The long bolts in the forward and front lower holes
 - The short bolt in the rear upper hole

NOTE: Refer to Fastener Notice .

3. Tighten the intermediate bracket bolts.

Tighten: Tighten the bolts to 100 N.m (74 lb ft).

4. Install the engine mount. Refer to Engine Mount Replacement.

ENGINE SUPPORT FIXTURE

Special Tools

- **J 28467-B** Universal Engine Support Fixture. See Special Tools.
- **J 28467-500** Engine Support Fixture

Installation Procedure

1. Remove the air cleaner assembly. Refer to Air Cleaner Assembly Replacement .
2. Place the engine support fixture legs (1) from the **J 28467-B** across the engine compartment. See Special Tools.
3. Install the engine support fixture legs (1) from the **J 28467-500** on the engine support fixture long bar (2).

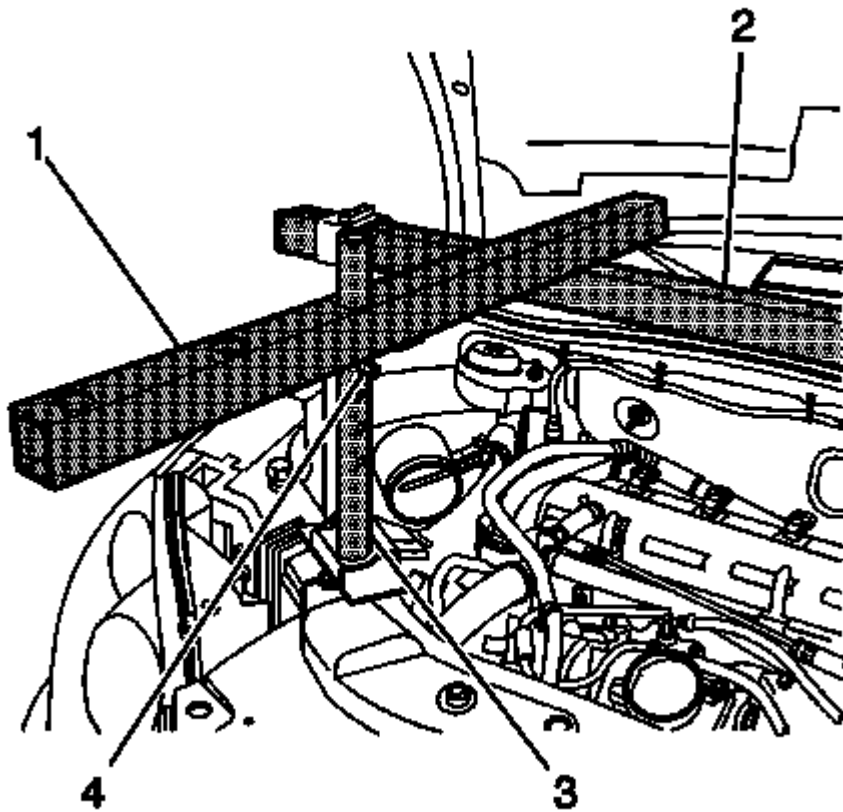


Fig. 61: View Of Engine Support Fixture
Courtesy of GENERAL MOTORS CORP.

4. Install the radiator shelf tube J-28467-2A (1) on top of the strut tower tube J-28467-3 (2) above the engine front (right back) lift hook bracket.
5. Install the round tube of the front support assembly J-28467-4A (3) through the large hole in the radiator shelf tube J-28467-2A.

6. Locate the J-28467-4A front support assembly to the upper tie bar.
7. Install the J-28467-9 7/16 inch x 2.0 inch quick-release pin (4) through the top hole in the J-28467-4A front support assembly.

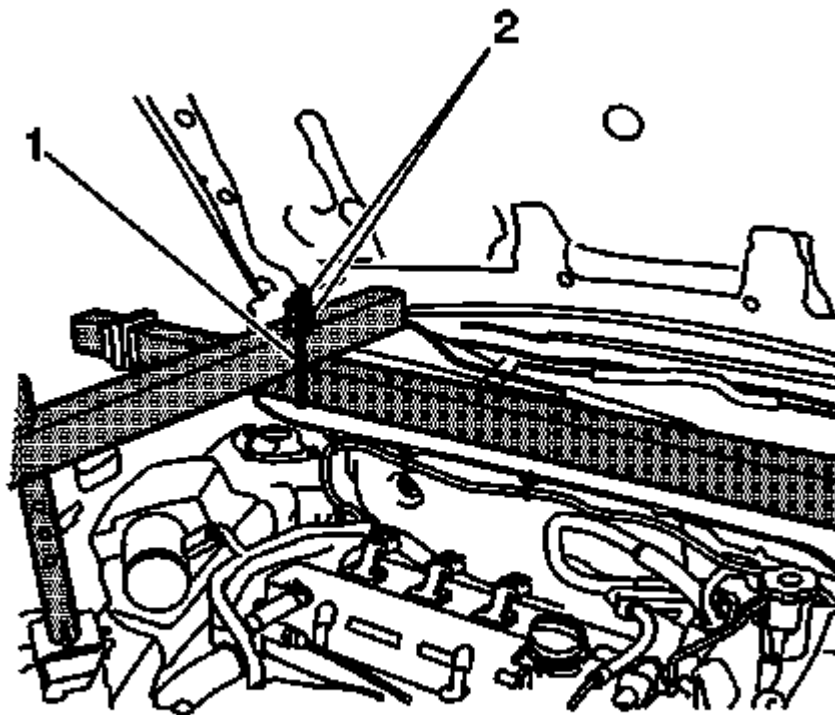


Fig. 62: View Of Engine Support Fixture & Cross Bracket
Courtesy of GENERAL MOTORS CORP.

8. Install the J-28467-1A cross bracket assembly (1).
9. Hand tighten the J-28467-1A cross bracket wing nuts (2).

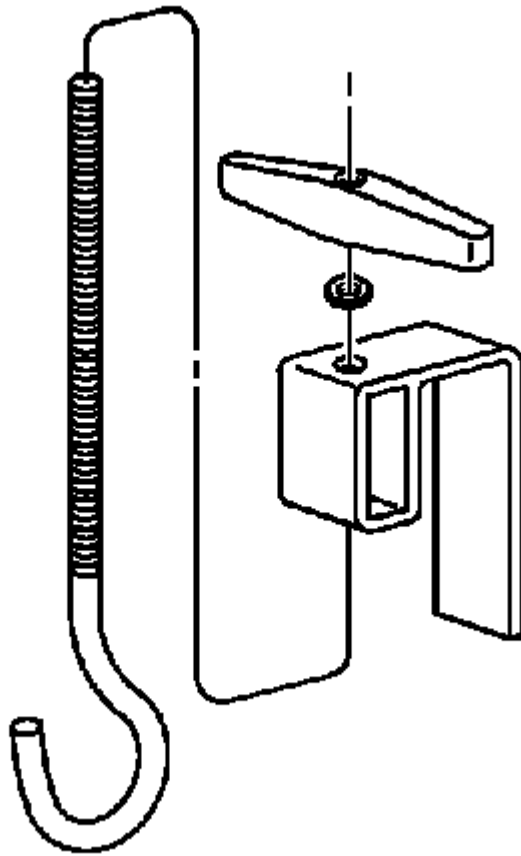


Fig. 63: View Of Lift Hook Assembly
Courtesy of GENERAL MOTORS CORP.

10. Install the J-28467-7A bolt hook through the J-28467-6A bracket.
11. Install the J-28467-34 lift hook wing nut and washer to the J-28467-7A lift hook.
12. Repeat the previous 2 steps in order to assemble 2 lift hooks and brackets.

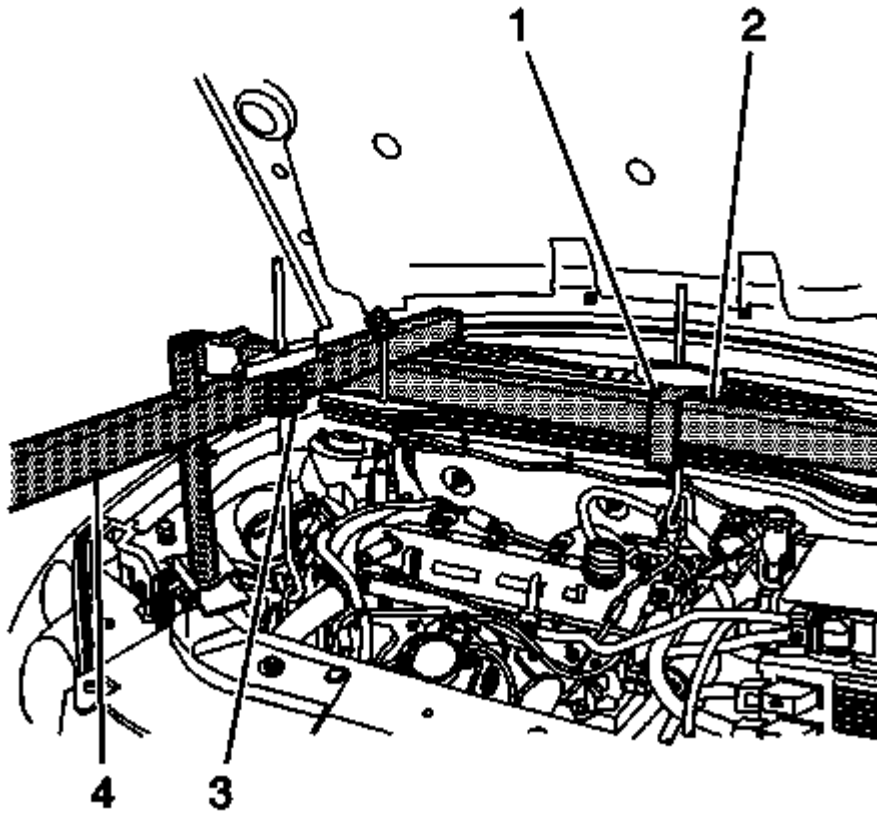


Fig. 64: Identifying Engine Support Fixture & Cross Bracket
Courtesy of GENERAL MOTORS CORP.

13. Install one of the lift hook and bracket assemblies (1) to the engine support fixture long bar (2).
14. Install the other lift hook and bracket assembly (3) to the J-28467-2A radiator shelf tube (4) above the engine front lift bracket.

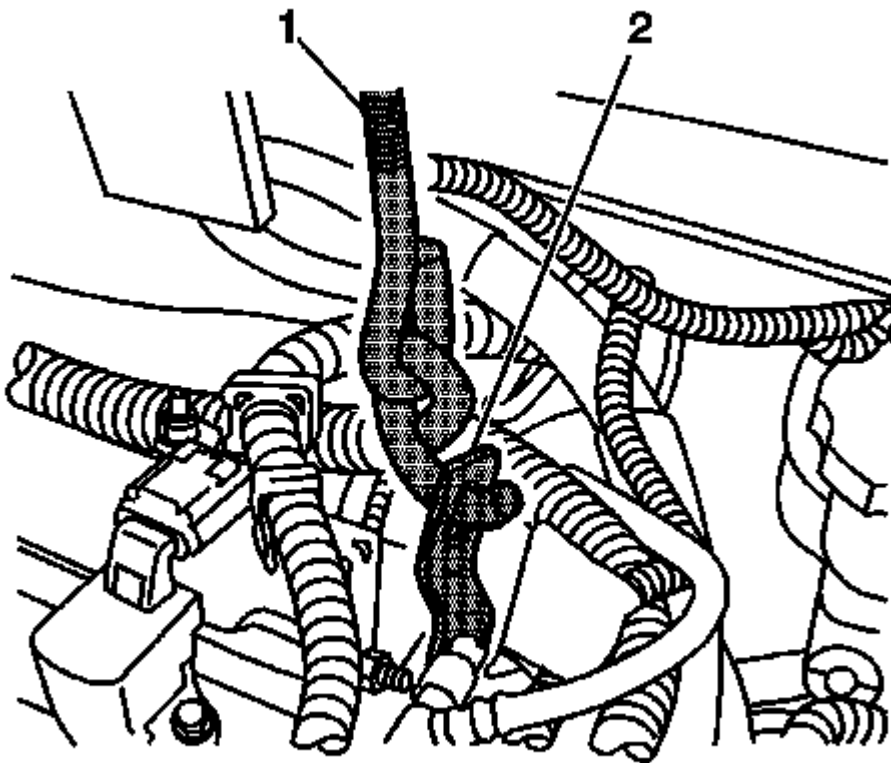


Fig. 65: Inserting Lift Hook Through Engine Rear Lift Bracket
Courtesy of GENERAL MOTORS CORP.

15. Install the lift hook J-28467-7A through the engine rear lift bracket (2).

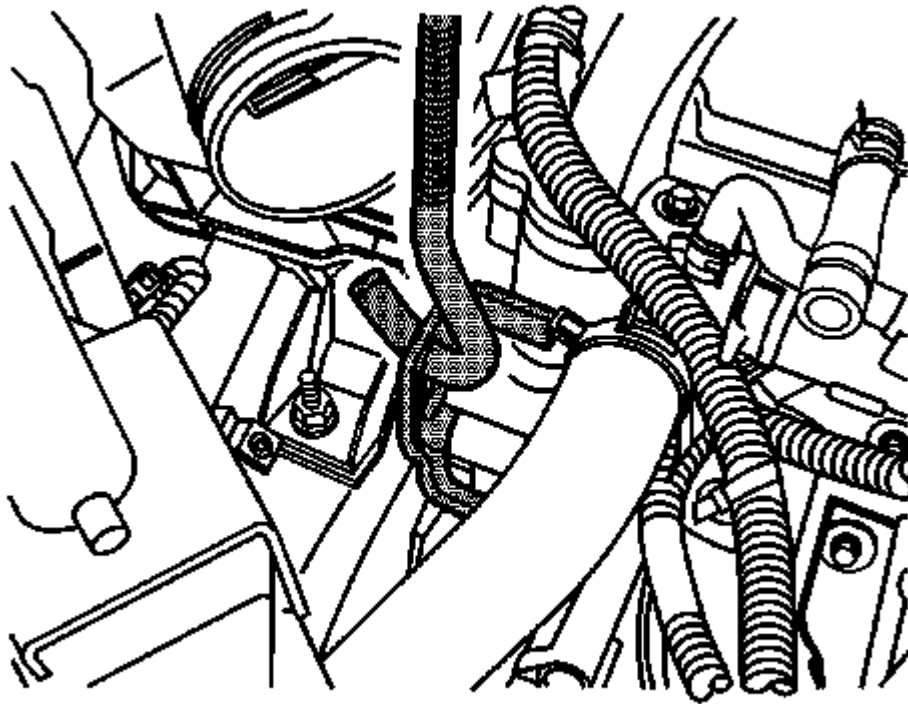


Fig. 66: Inserting Lift Hook Through Engine Front Lift Bracket
Courtesy of GENERAL MOTORS CORP.

16. Install the lift hook J-28467-7A (3) through the engine front lift bracket (4).
17. Hand tighten the lift hook wing nuts J-28467-34 (5) in order to remove all slack from the engine support fixture assembly.

OIL LEVEL INDICATOR AND TUBE REPLACEMENT

Removal Procedure

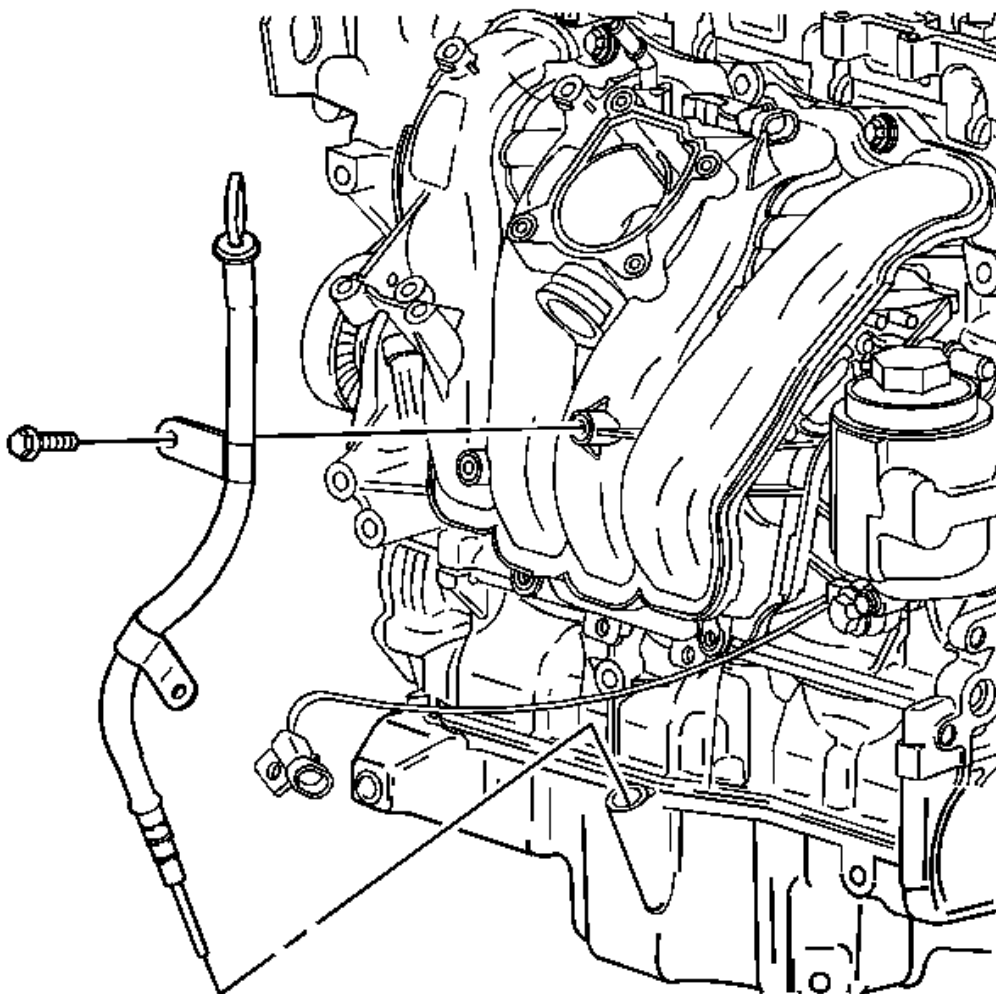


Fig. 67: View Of Oil Level Indicator Tube
Courtesy of GENERAL MOTORS CORP.

1. Remove the air cleaner outlet resonator. Refer to **Air Cleaner Outlet Resonator Replacement** .
2. Unclip the electrical wiring harness from the oil level indicator tube.
3. Remove the oil level indicator tube bolt.
4. Remove the oil level indicator tube.
5. Remove the oil level indicator tube seal.

Installation Procedure

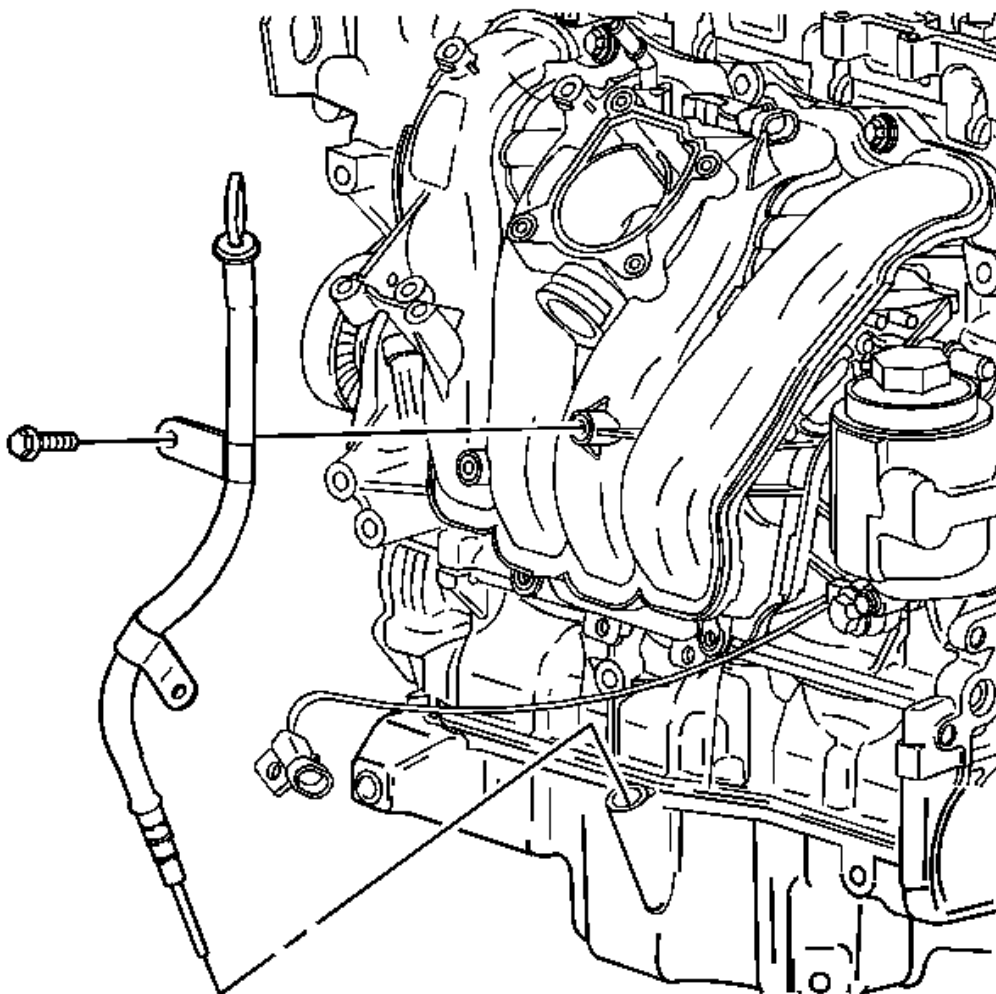


Fig. 68: View Of Oil Level Indicator Tube
Courtesy of GENERAL MOTORS CORP.

1. Install the oil level indicator tube seal.
2. Install the oil level indicator tube.
3. Clip the electrical wiring harness to the oil level indicator tube.

NOTE: Refer to FASTENER NOTICE .

4. Install the oil level indicator tube bolt.

Tighten: Tighten the oil level indicator tube bolt to 10 N.m (89 lb in).

5. Install the air cleaner outlet resonator. Refer to [Air Cleaner Outlet Resonator Replacement](#) .

POSITIVE CRANKCASE VENTILATION HOSE/PIPE/TUBE REPLACEMENT

Removal Procedure

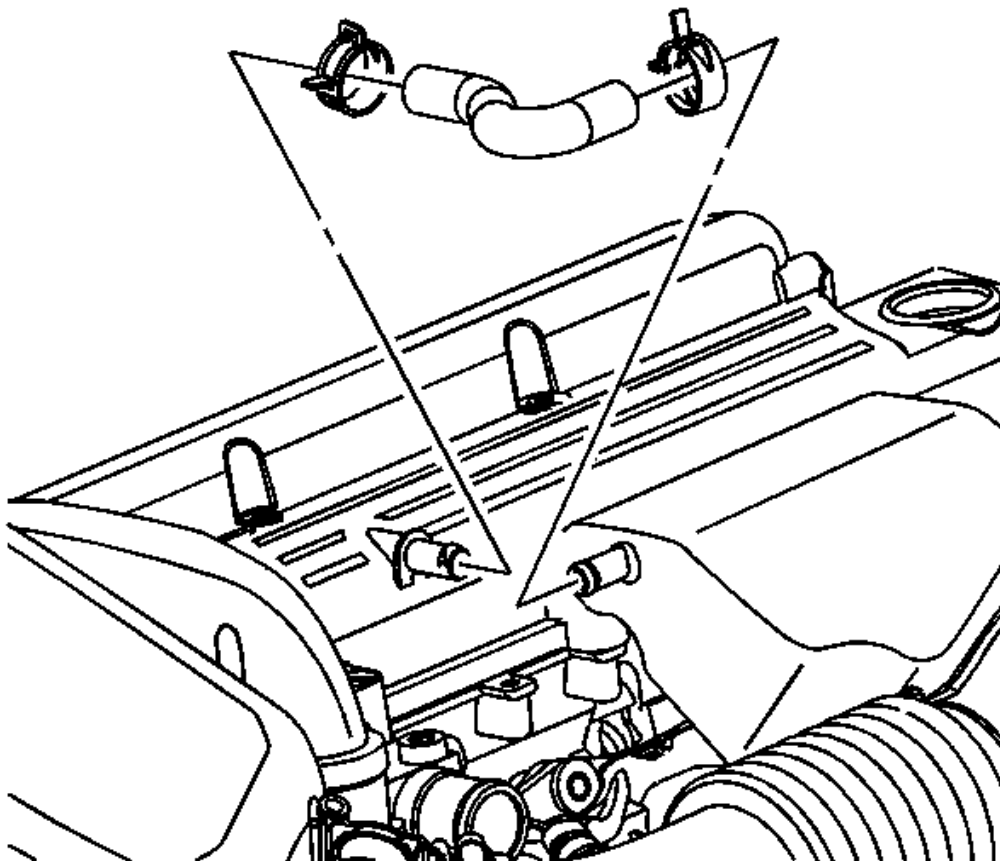


Fig. 69: View Of Crankcase Ventilation Hose
Courtesy of GENERAL MOTORS CORP.

1. Disconnect the crankcase ventilation hose from the camshaft cover.
2. Disconnect the crankcase ventilation hose from the intake manifold.

Installation Procedure

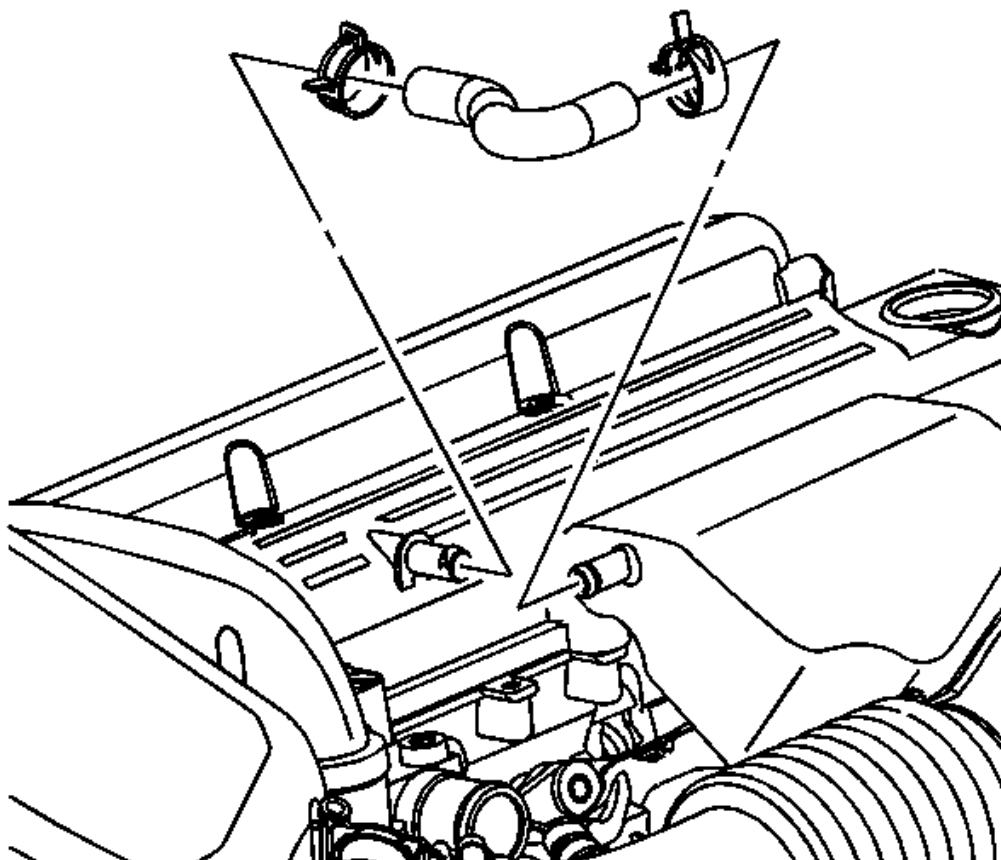


Fig. 70: View Of Crankcase Ventilation Hose
Courtesy of GENERAL MOTORS CORP.

1. Connect the crankcase ventilation hose to the camshaft cover.
2. Connect the crankcase ventilation hose to the intake manifold.

INTAKE MANIFOLD REPLACEMENT

Removal Procedure

1. Remove the air cleaner outlet resonator. Refer to [Air Cleaner Outlet Resonator Replacement](#) .
2. Remove the throttle body. Refer to [Throttle Body Assembly Replacement](#) .
3. Disconnect the positive crankcase ventilation (PCV) hose.
4. Disconnect the purge solenoid tube.
5. Disconnect the brake booster hose.

6. Remove the oil level indicator tube bolt.
7. Remove the fuel rail. Refer to **Fuel Injection Fuel Rail Assembly Replacement** .
8. Disconnect the knock sensor electrical connector.

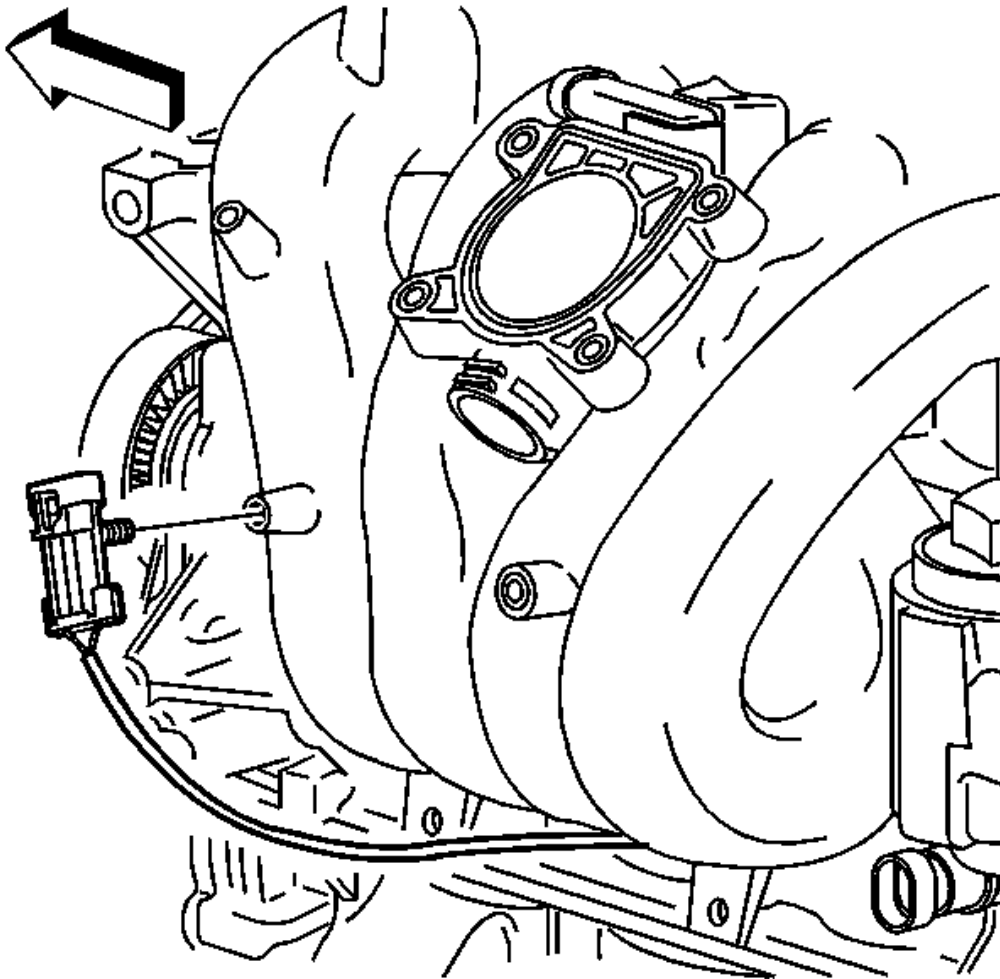


Fig. 71: View Of Knock Sensor Connector
Courtesy of GENERAL MOTORS CORP.

9. Remove the knock sensor harness connector from the intake manifold.

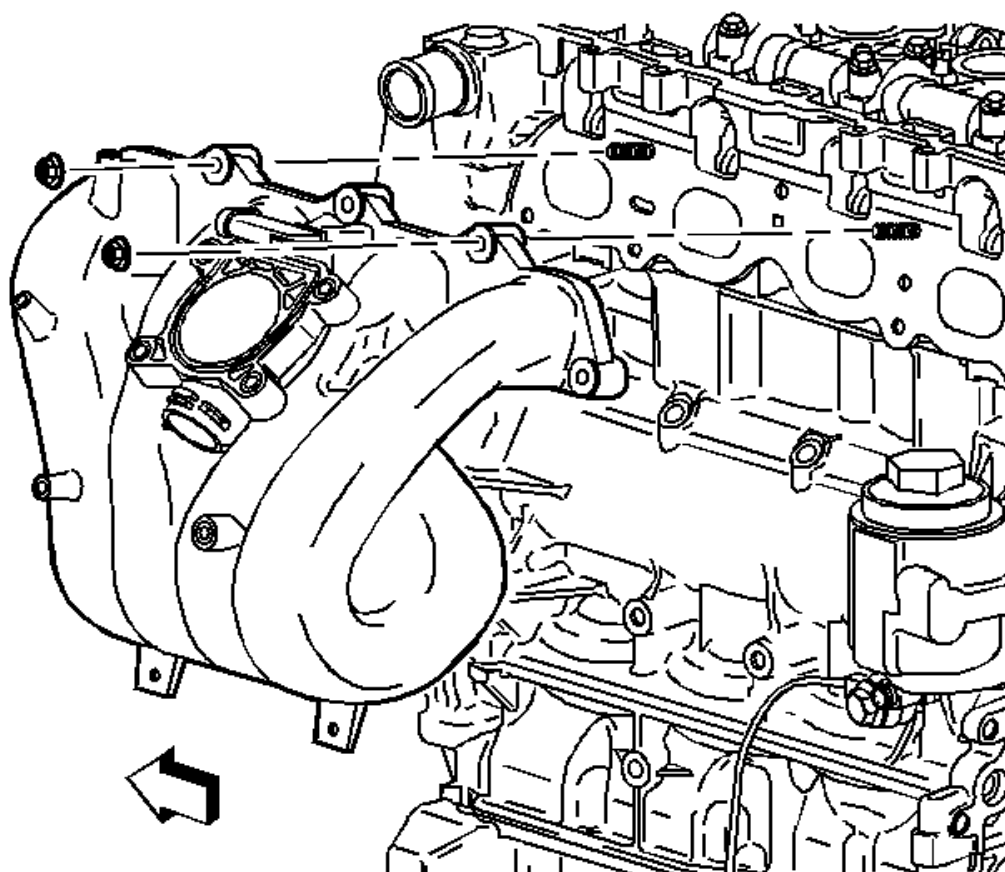


Fig. 72: View Of Intake Manifold
Courtesy of GENERAL MOTORS CORP.

10. Remove the intake manifold nuts and bolts.
11. Remove the intake manifold.

IMPORTANT: The intake manifold gasket is reusable, only replace the gasket if damage has occurred.

12. If applicable, remove the intake manifold gasket.

Installation Procedure

1. If applicable, install the intake manifold gasket.
2. Install the intake manifold.

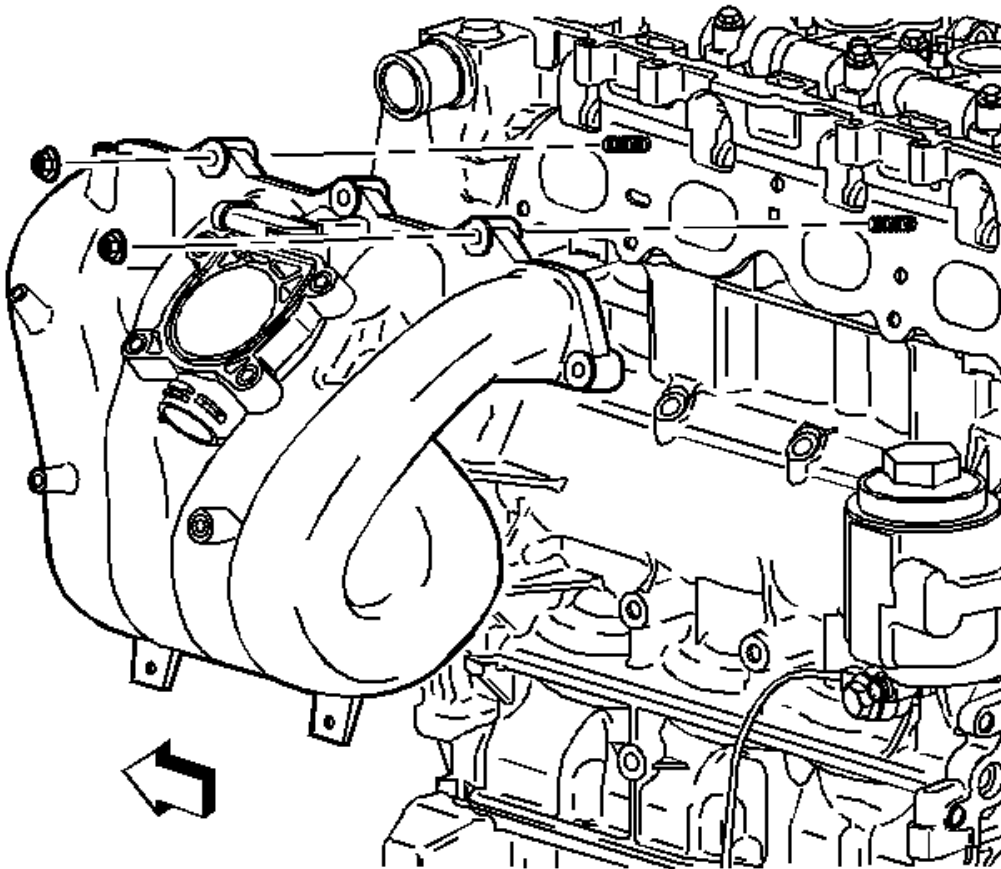


Fig. 73: View Of Intake Manifold
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

3. Install the intake manifold nuts and bolts.

Tighten: Tighten the intake manifold nuts and bolts to 10 N.m (89 lb in).

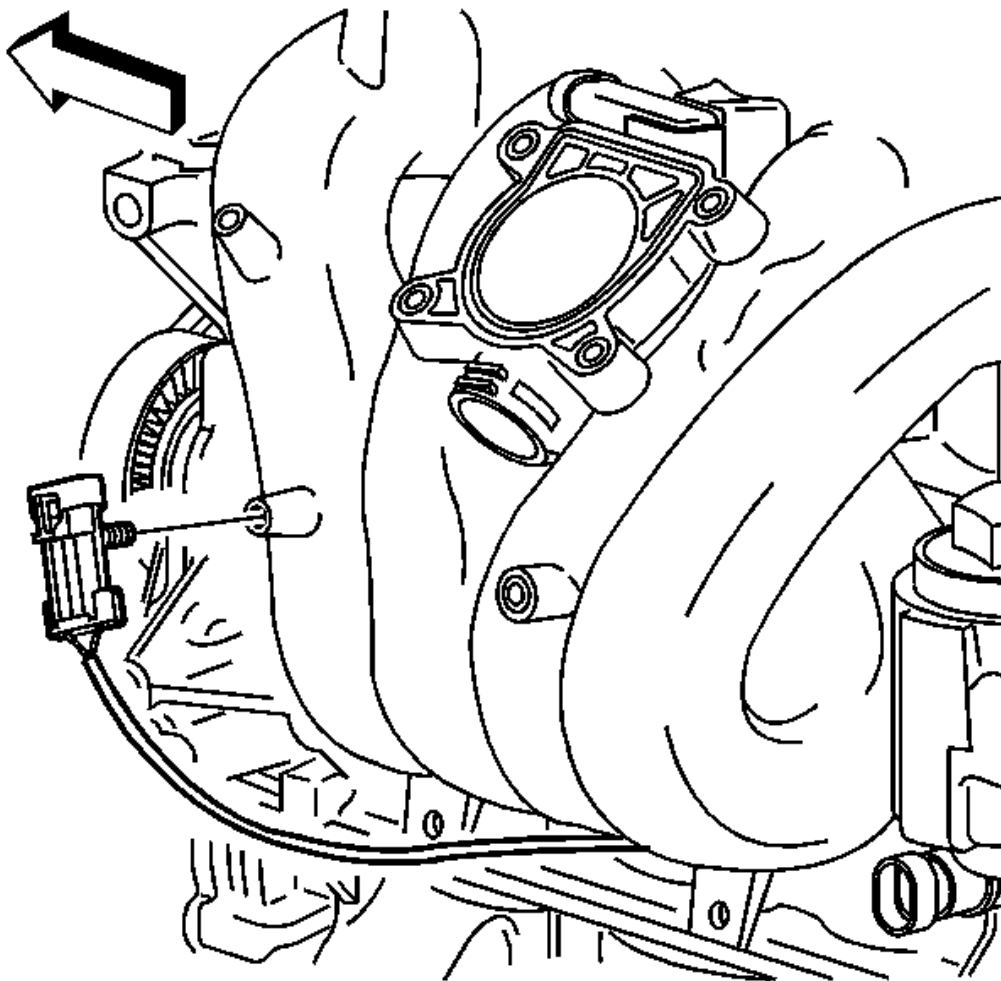


Fig. 74: View Of Knock Sensor Connector
 Courtesy of GENERAL MOTORS CORP.

4. Install the knock sensor harness connector to the intake manifold.
5. Connect the knock sensor electrical connector.
6. Install the fuel rail. Refer to **Fuel Injection Fuel Rail Assembly Replacement** .
7. Install the throttle body.
8. Install the oil level indicator tube bolt.

Tighten: Tighten the oil level indicator tube bolt to 10 N.m (89 lb in).

9. Connect the brake booster hose.

10. Connect the purge solenoid tube.
11. Connect the PCV hose.
12. Install the throttle body. Refer to Throttle Body Assembly Replacement.
13. Install the air cleaner outlet resonator. Refer to Air Cleaner Outlet Resonator Replacement.

CRANKSHAFT BALANCER REPLACEMENT

Tools Required

J 38122-A Harmonic Balancer Holder. See Special Tools.

Removal Procedure

1. Remove the engine drive belt. Refer to Drive Belt Replacement.

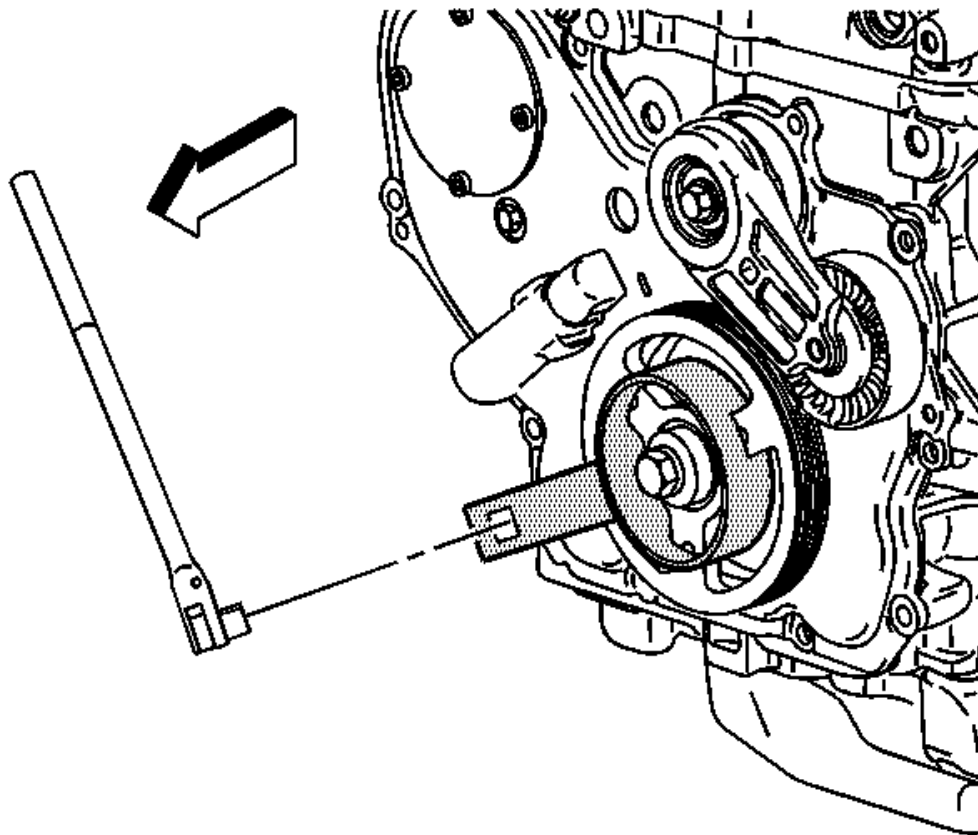


Fig. 75: View Of Harmonic Balancer Holder J38122-A
Courtesy of GENERAL MOTORS CORP.

2. Use **J 38122-A** to prevent the crankshaft from rotating while loosening the crankshaft balancer bolt. See **Special Tools**.
3. Remove the crankshaft balancer bolt. Discard the bolt.

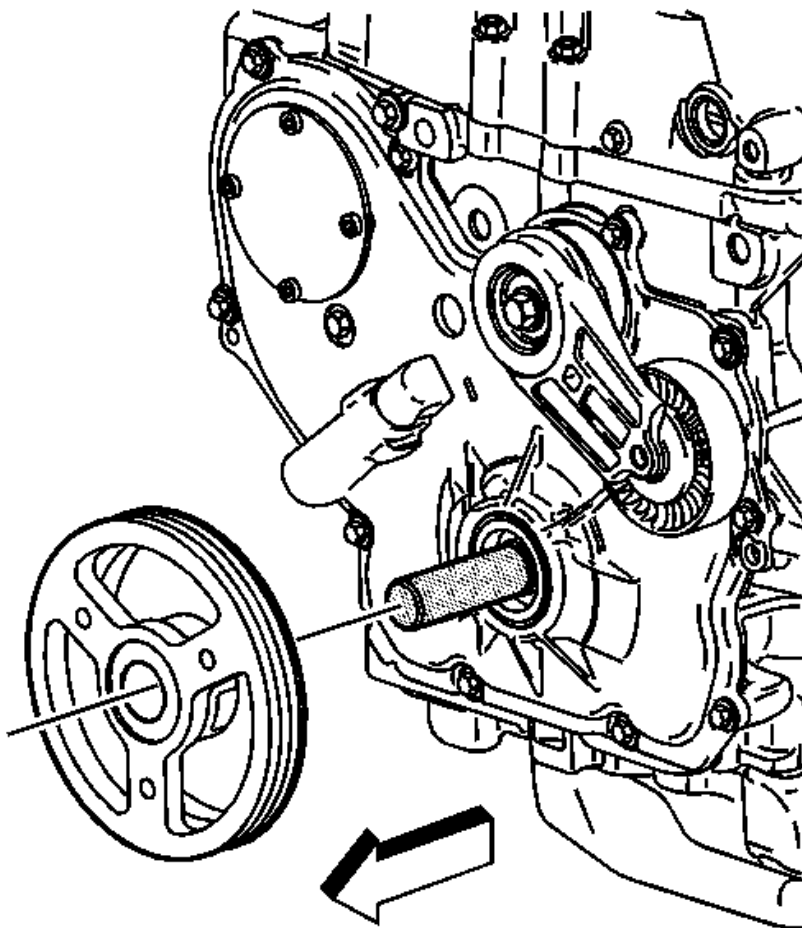


Fig. 76: View Of Crankshaft Balancer
Courtesy of GENERAL MOTORS CORP.

4. Remove the crankshaft balancer.

Installation Procedure

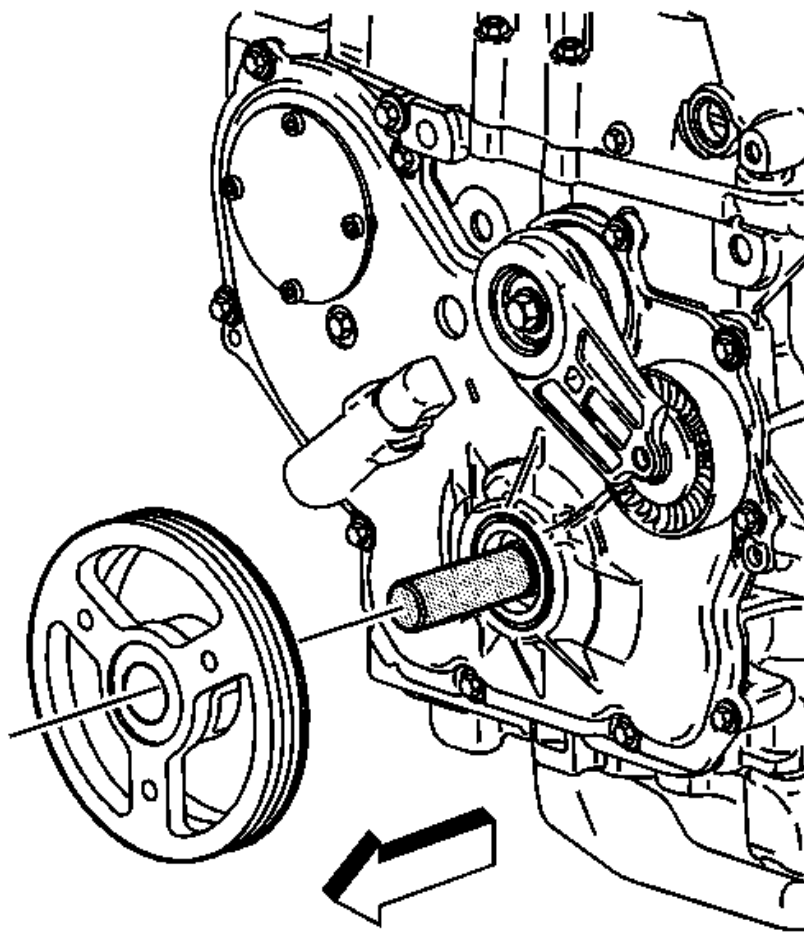


Fig. 77: View Of Crankshaft Balancer
Courtesy of GENERAL MOTORS CORP.

1. Install the crankshaft balancer.
2. Install a NEW crankshaft balancer bolt.

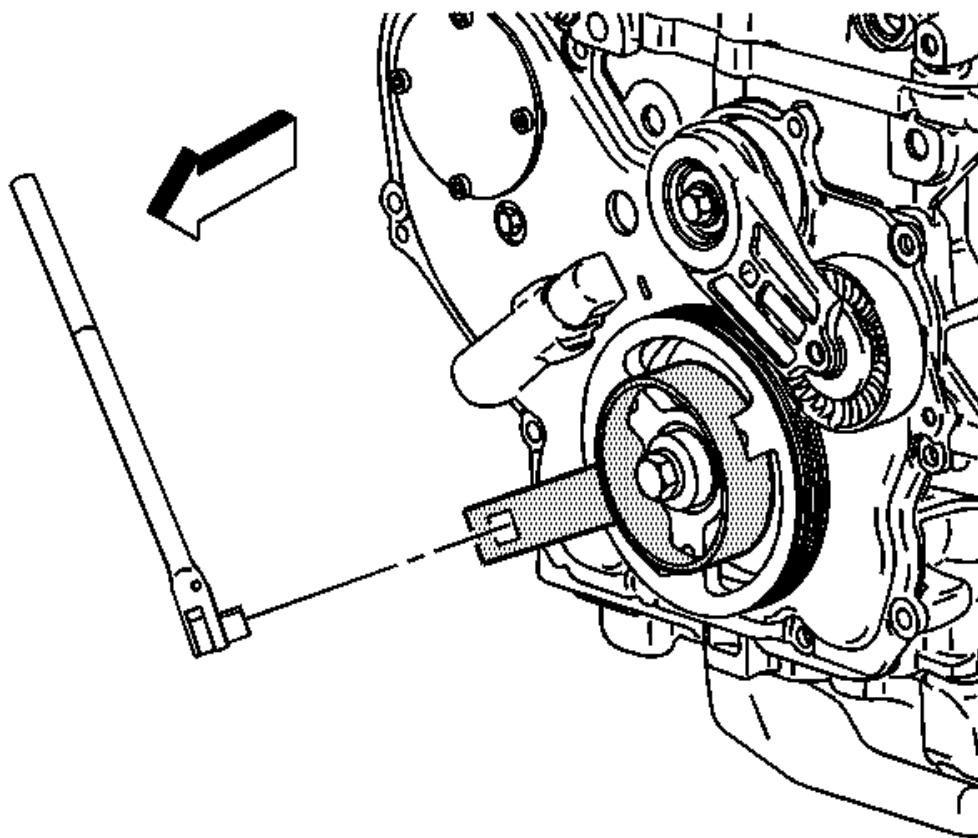


Fig. 78: View Of Harmonic Balancer Holder J38122-A
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

3. Use **J 38122-A** to prevent the crankshaft from rotating while tightening the crankshaft balancer bolt. See **Special Tools**.

Tighten: Tighten the bolt to 100 N.m (74 lb ft) plus 75 degrees.

4. Install the engine drive belt. Refer to **Drive Belt Replacement**.

CRANKSHAFT FRONT OIL SEAL REPLACEMENT

Tools Required

J 35268-A Camshaft/Front Main Seal Installer

Removal Procedure

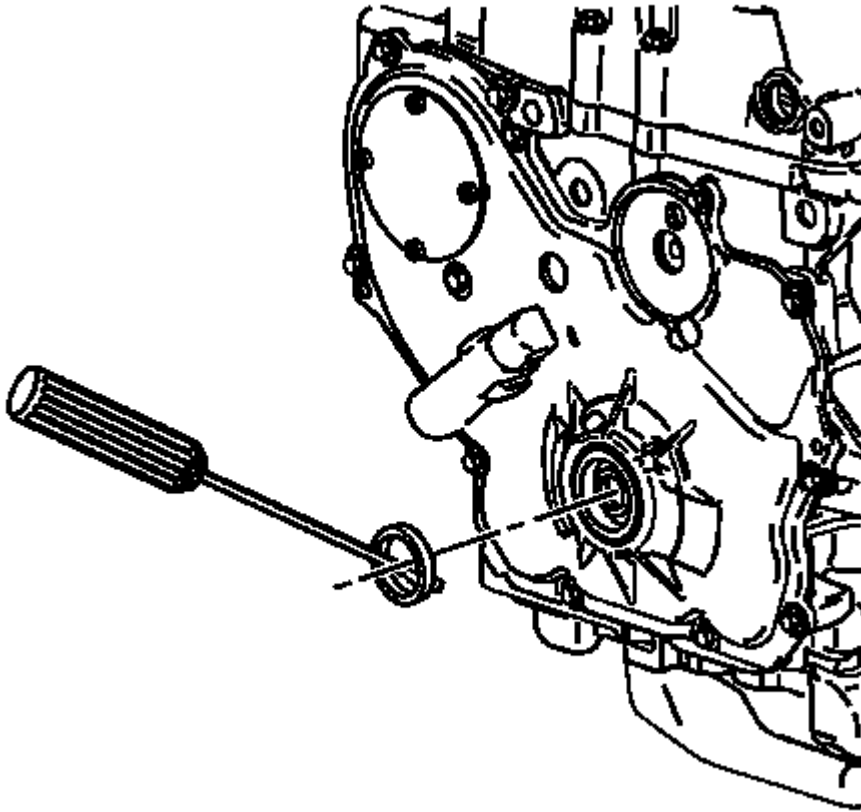


Fig. 79: Removing Crankshaft Front Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Remove the crankshaft balancer. Refer to [Crankshaft Balancer Replacement](#).
2. Use a flat-bladed tool to remove the seal from the front cover.

Installation Procedure

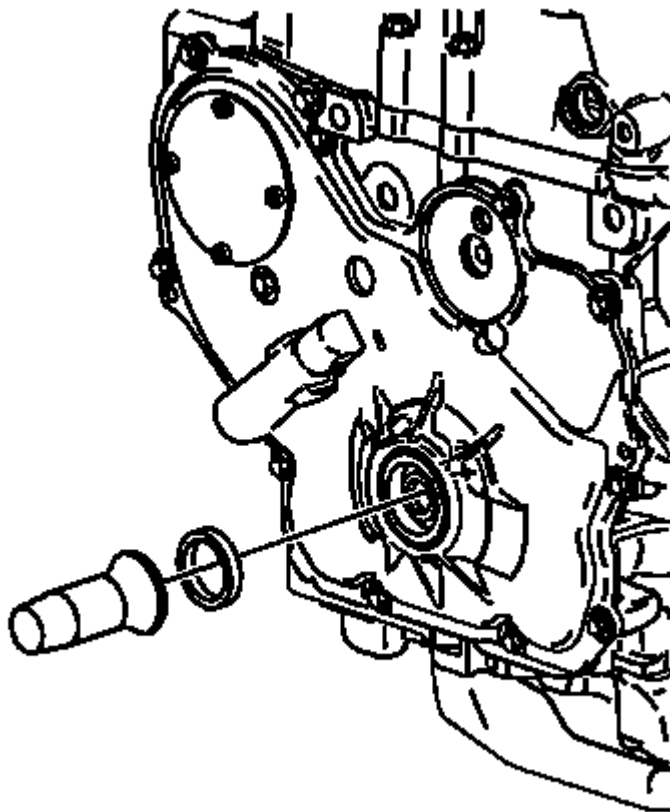


Fig. 80: Installing Crankshaft Front Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Use the **J 35268-A** in order to install the crankshaft front oil seal to the engine front cover.
2. Install the crankshaft balancer. Refer to **Crankshaft Balancer Replacement**.

ENGINE FRONT COVER REPLACEMENT

Removal Procedure

1. Remove the crankcase balancer. Refer to **Crankshaft Balancer Replacement**.

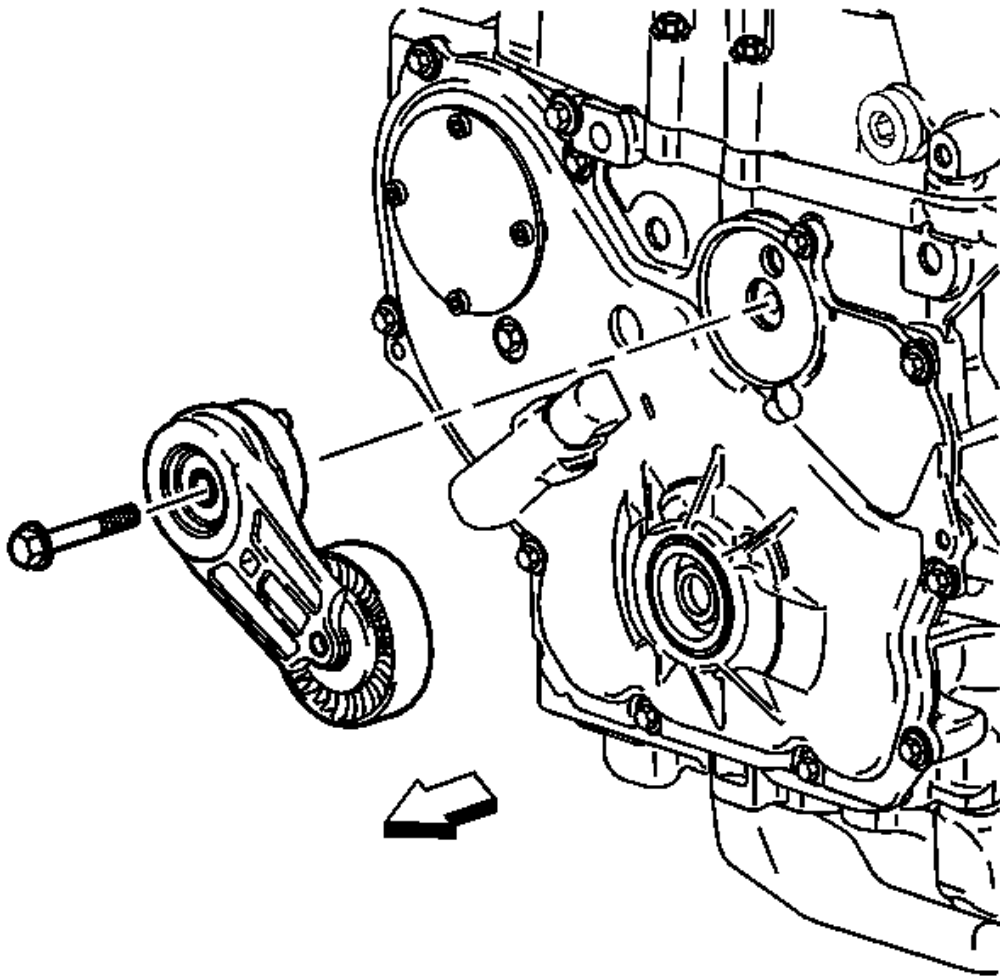


Fig. 81: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

2. Remove the drive belt tensioner.
3. Remove the engine mount bracket. Refer to **Engine Mount Bracket Replacement - Right Side.**

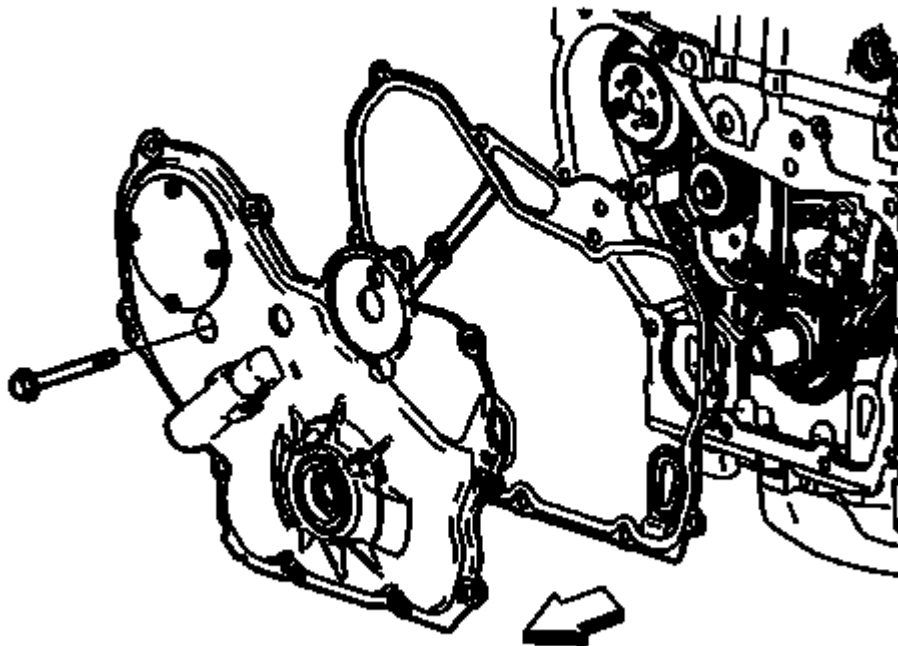


Fig. 82: View Of Engine Front Cover
Courtesy of GENERAL MOTORS CORP.

4. Remove the engine front cover to water pump bolt.

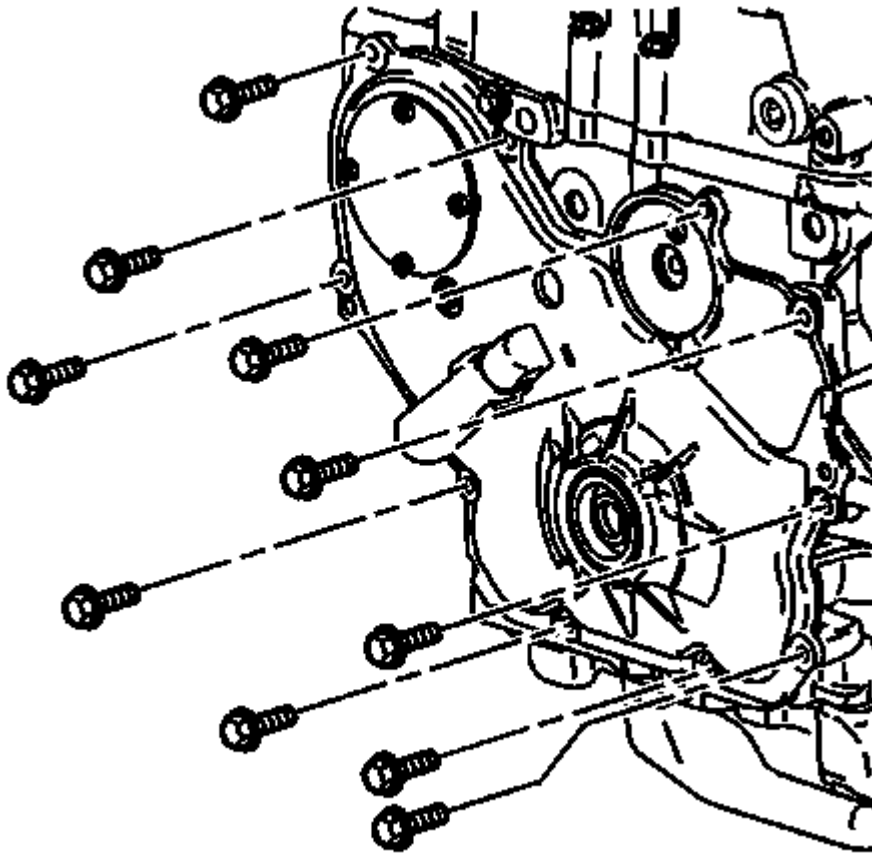


Fig. 83: View Of Engine Front Cover Bolts
Courtesy of GENERAL MOTORS CORP.

5. Remove the remaining engine front cover bolts.
6. Remove the engine front cover.
 - If the engine front cover gasket is damaged.
 - Remove the front engine mount. Refer to **Engine Mount Replacement**.
 - Remove the engine front cover gasket if it is damaged.

Installation Procedure

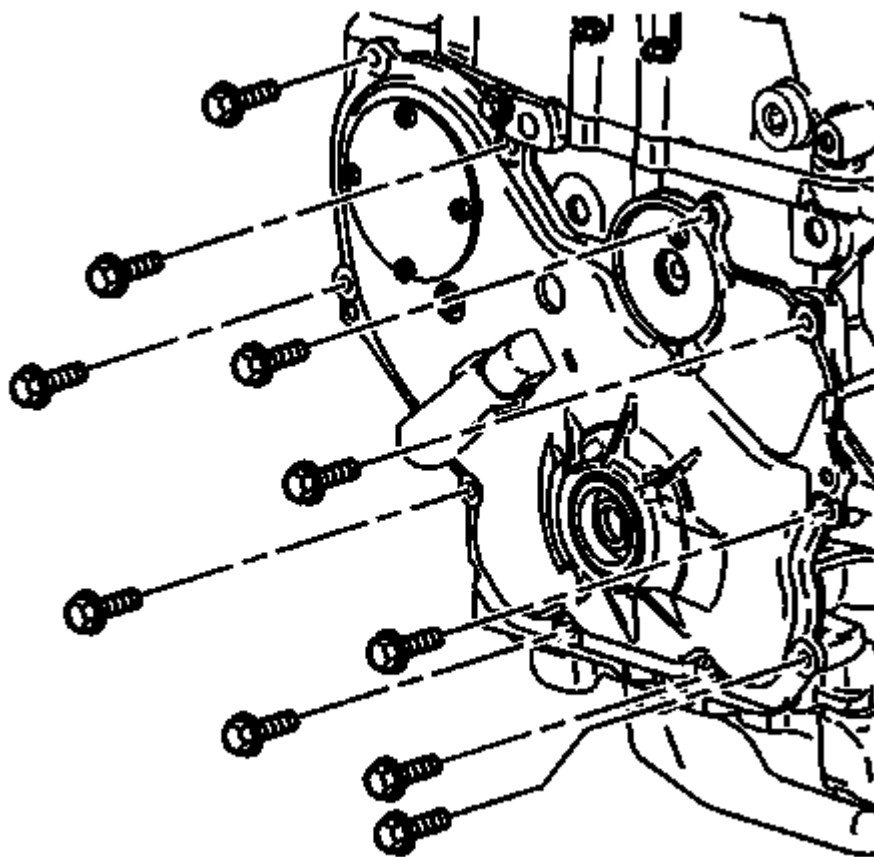


Fig. 84: View Of Engine Front Cover Bolts
Courtesy of GENERAL MOTORS CORP.

1. If removed install a new engine front cover gasket.
2. Install the front engine mount. Refer to Engine Mount Replacement.
3. Install the engine front cover.

NOTE: Refer to Fastener Notice .

4. Install the engine front cover bolts.

Tighten: Tighten the engine front cover bolts to 25 N.m (18 lb ft).

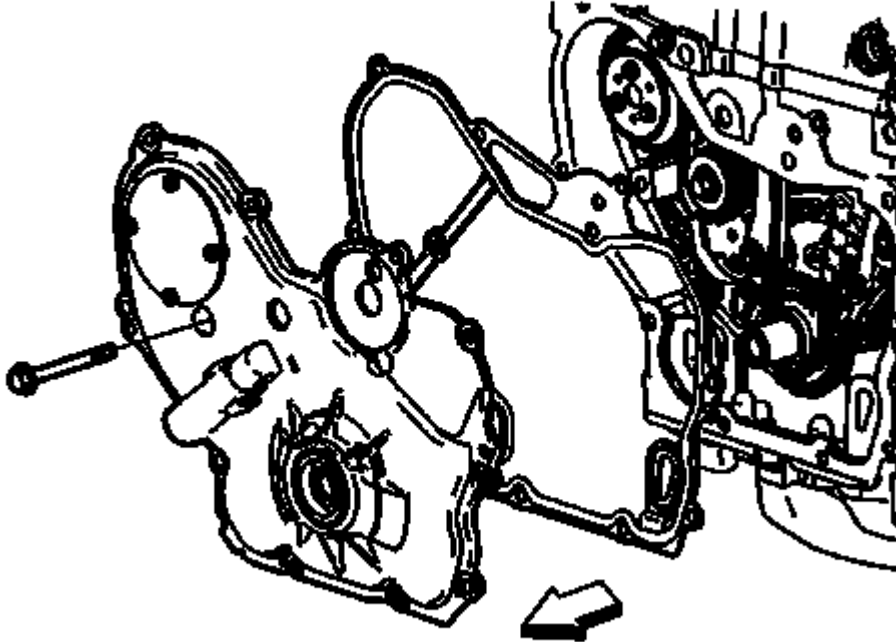


Fig. 85: View Of Engine Front Cover
Courtesy of GENERAL MOTORS CORP.

5. Install the water pump bolt.

Tighten: Tighten the water pump bolt to 25 N.m (18 lb ft).

6. Install the engine mount bracket. Refer to **Engine Mount Bracket Replacement - Right Side**.

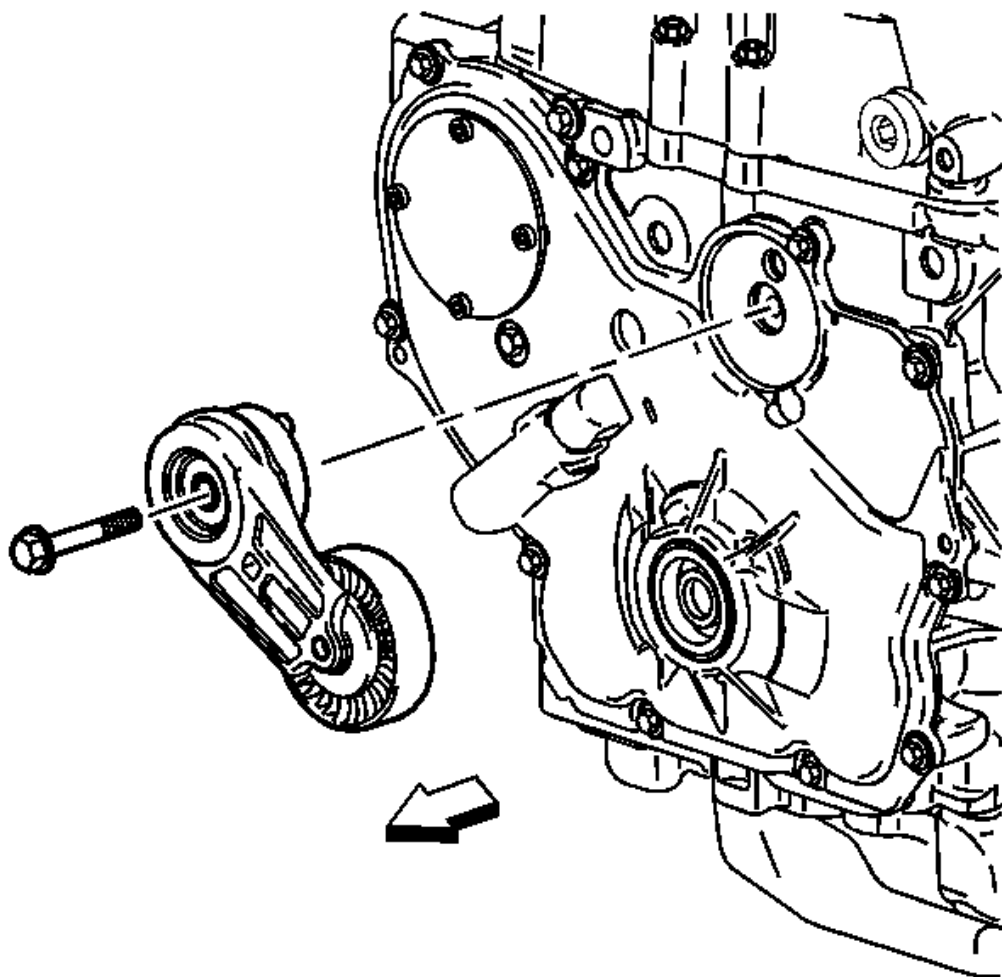


Fig. 86: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

7. Install the drive belt tensioner.
8. Install the drive belt tensioner bolt.

Tighten: Tighten the drive belt tensioner bolt to 45 N.m (33 lb ft).

9. Install the crankcase balancer. Refer to **Crankshaft Balancer Replacement**.

CAMSHAFT TIMING CHAIN, SPROCKET, AND TENSIONER REPLACEMENT

Tools Required

J 45027 Tensioner Tool**Removal Procedure**

1. Remove the camshaft cover. Refer to Camshaft Cover Replacement.
2. Raise and support the vehicle. Refer to Lifting and Jacking the Vehicle.
3. Remove the No. 1 cylinder spark plug. Refer to Spark Plug Replacement.
4. Rotate the crankshaft in the engine rotational direction clockwise, until the No. 1 piston is at top dead center (TDC) on the compression stroke.
5. Remove the engine front cover. Refer to Engine Front Cover Replacement.
6. Lower the vehicle.

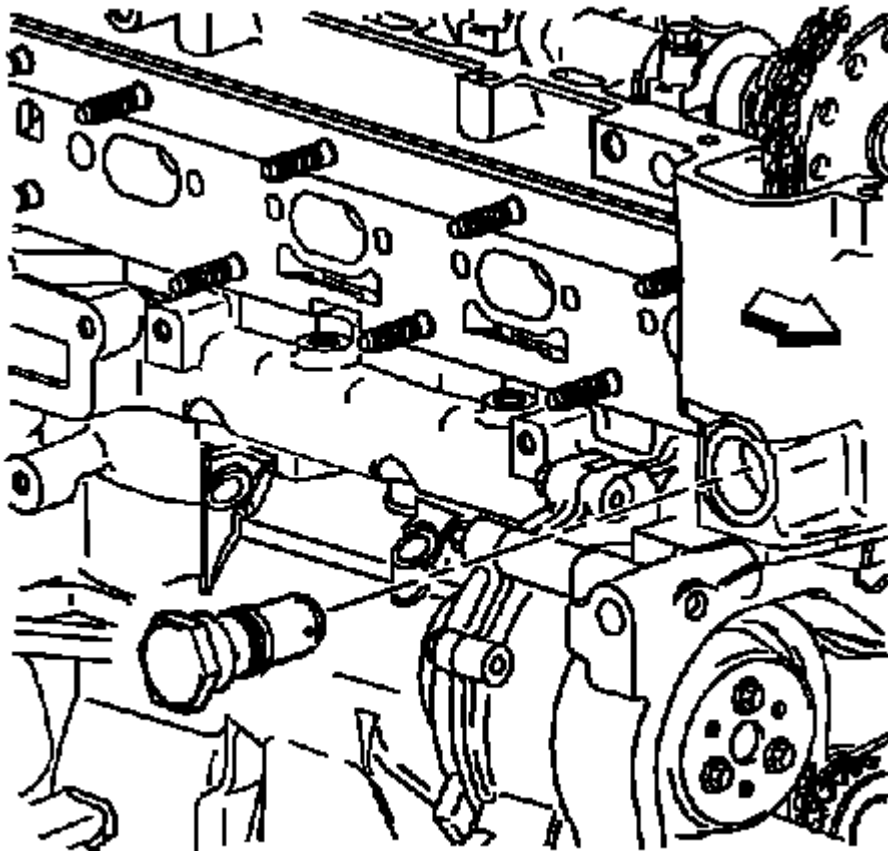


Fig. 87: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: The timing chain tensioner must be removed to unload chain tension before the timing chain is removed. If not removed, the timing chain will become cocked and it will be difficult to remove.

7. Remove the timing chain tensioner.

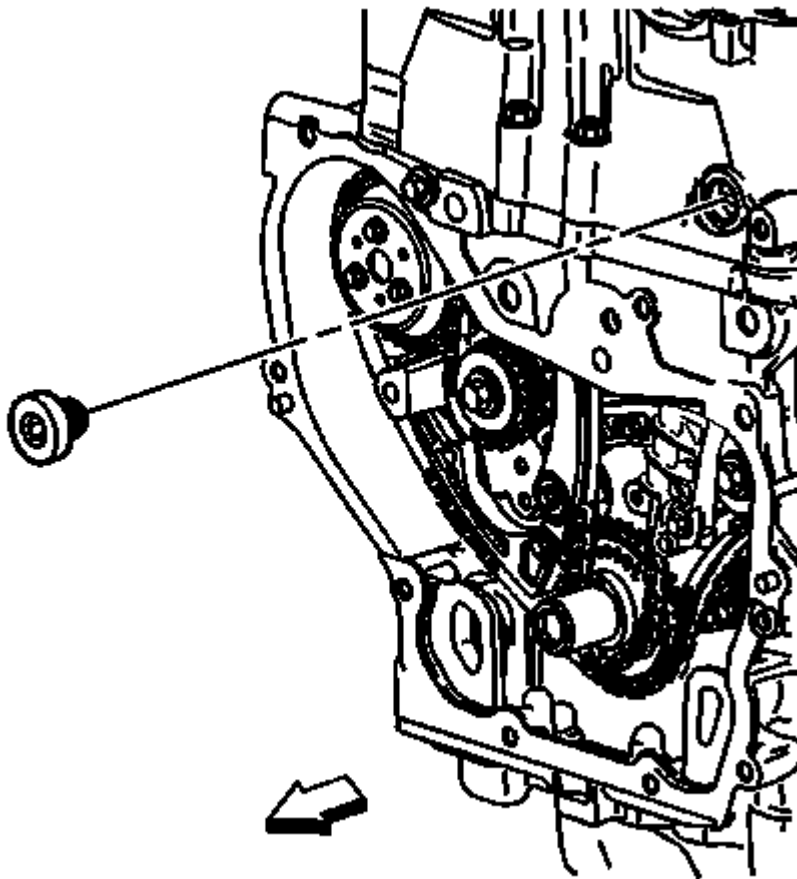


Fig. 88: View Of Fixed Timing Chain Guide Access Plug
Courtesy of GENERAL MOTORS CORP.

8. Remove the fixed timing chain guide access plug.

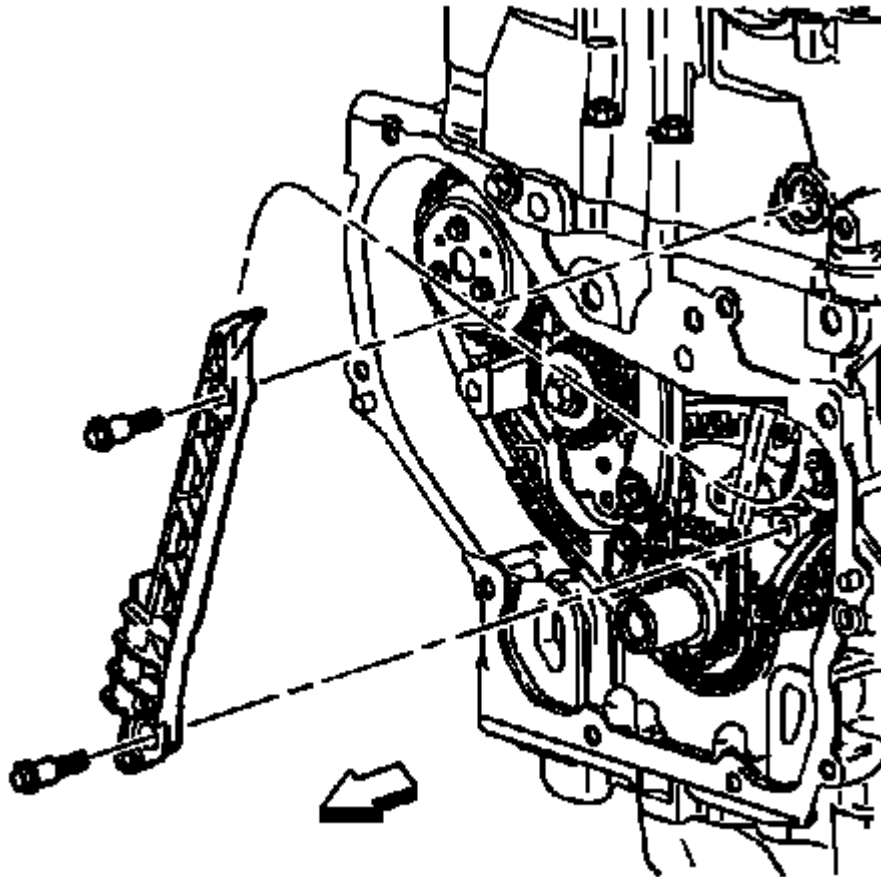


Fig. 89: View Of Fixed Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

9. Remove the fixed timing chain guide.

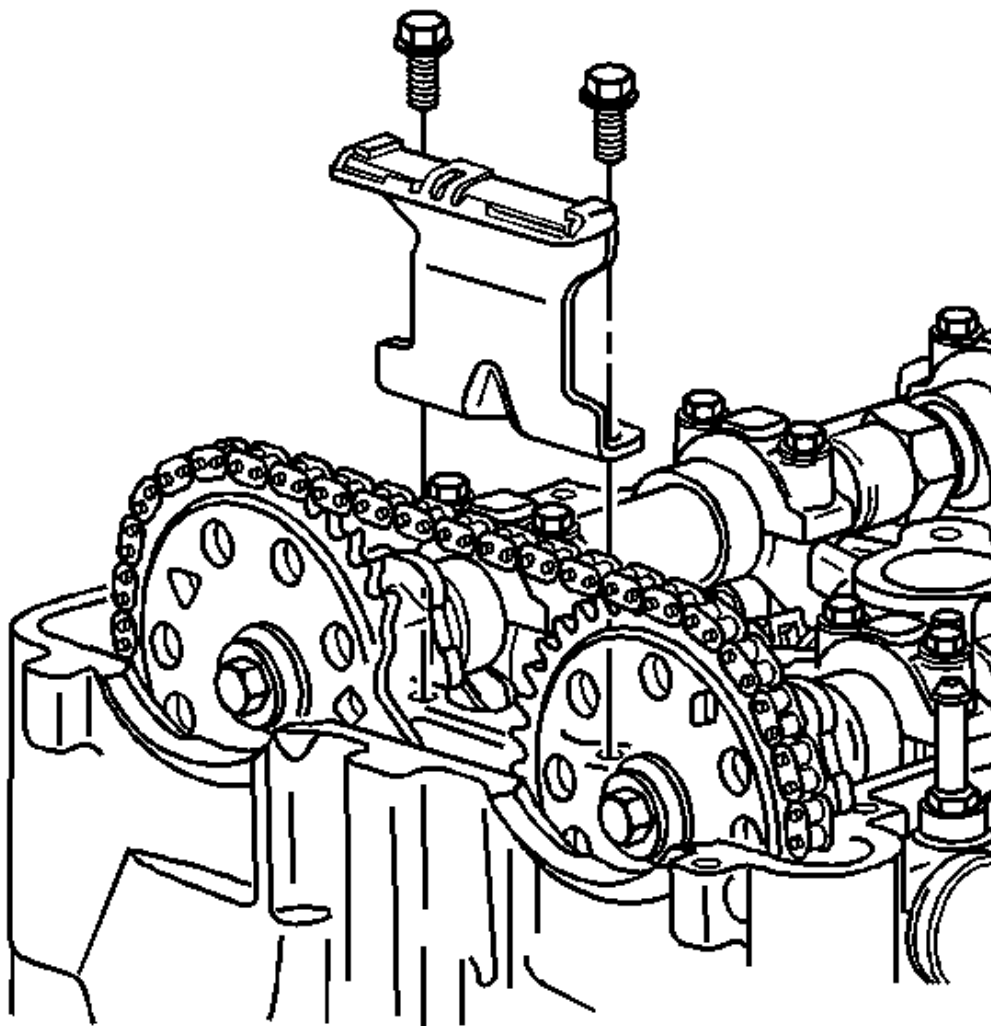


Fig. 90: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

10. Remove the upper timing chain guide.

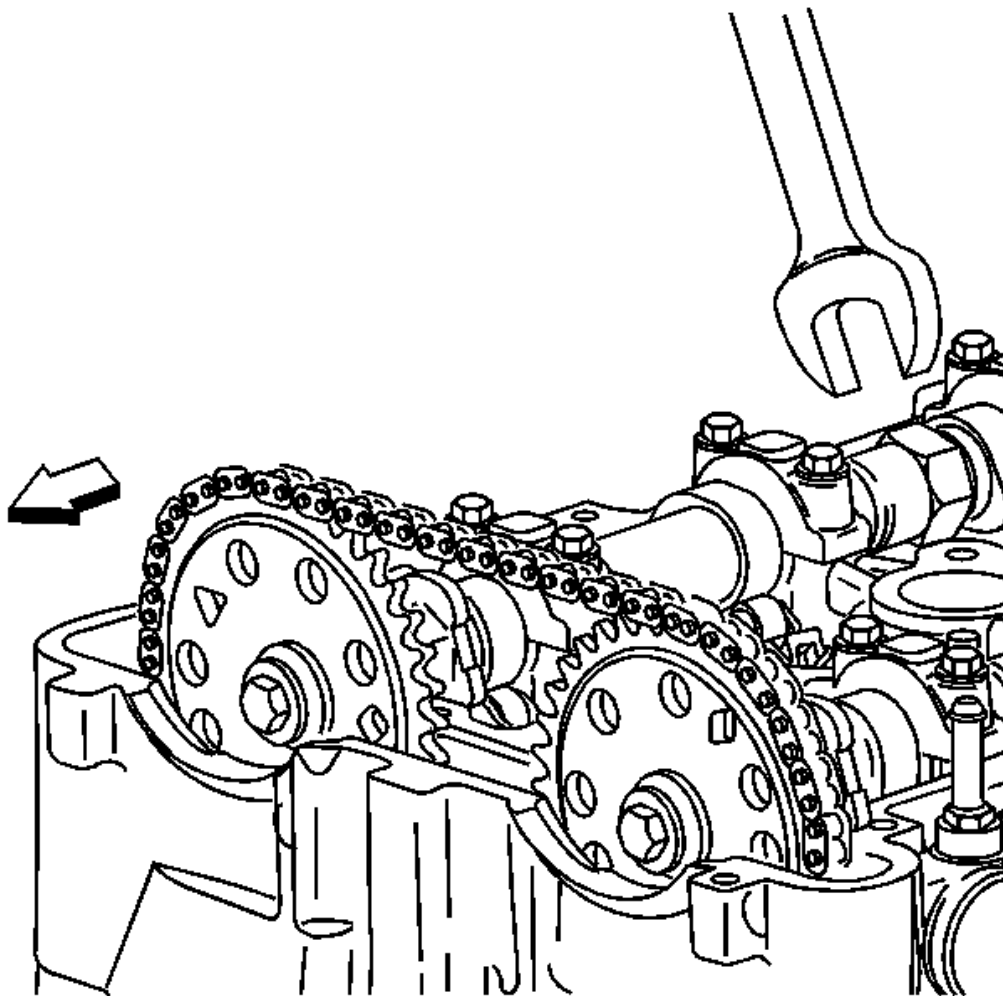


Fig. 91: Using 24 mm Wrench To Align Camshaft
Courtesy of GENERAL MOTORS CORP.

11. Use a 24 mm wrench to hold the camshafts from turning.

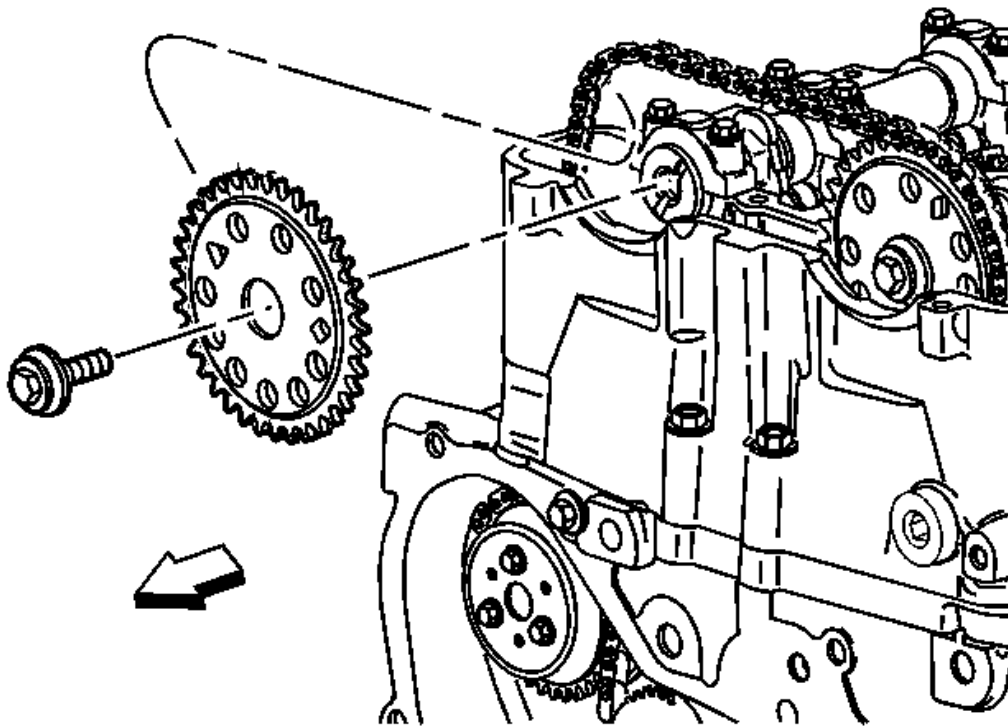


Fig. 92: Identifying Exhaust Camshaft Sprocket
Courtesy of GENERAL MOTORS CORP.

12. Remove the exhaust camshaft sprocket bolt and discard.
13. Remove the exhaust camshaft sprocket.

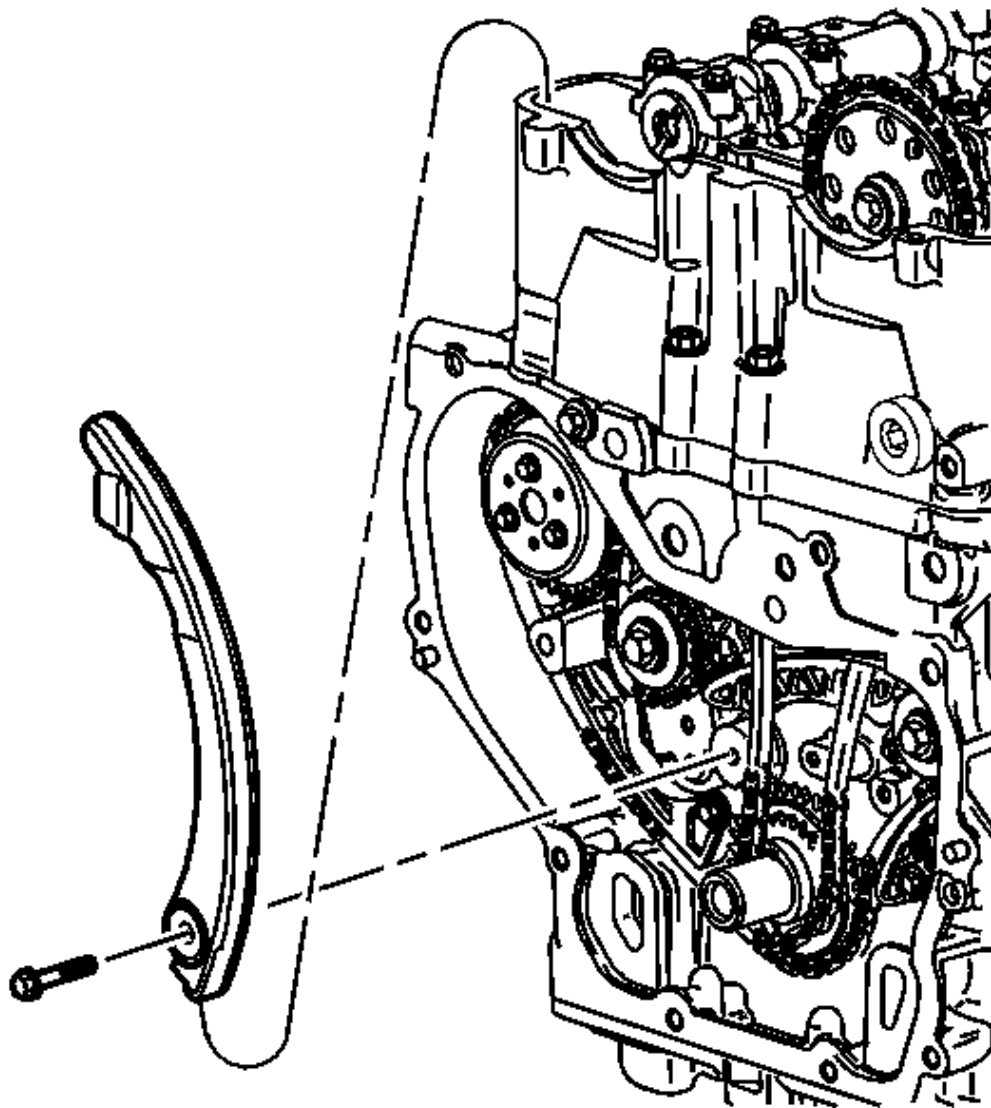


Fig. 93: View Of Timing Chain Tensioner Guide
Courtesy of GENERAL MOTORS CORP.

14. Remove the timing chain tensioner guide.

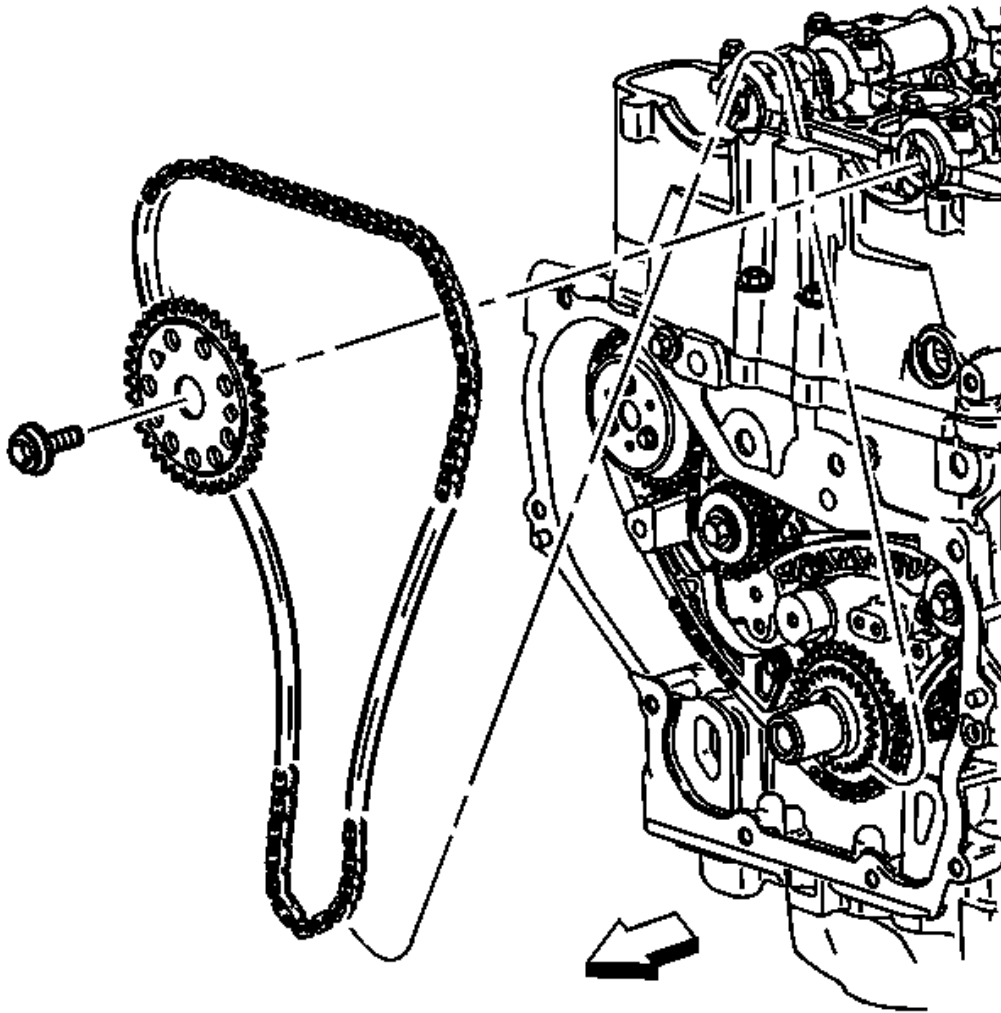


Fig. 94: View Of Intake Camshaft Sprocket And Chain
Courtesy of GENERAL MOTORS CORP.

15. Remove the intake camshaft sprocket bolt and discard.
16. Remove the intake camshaft sprocket.
17. Remove the timing chain through the top of the cylinder head.

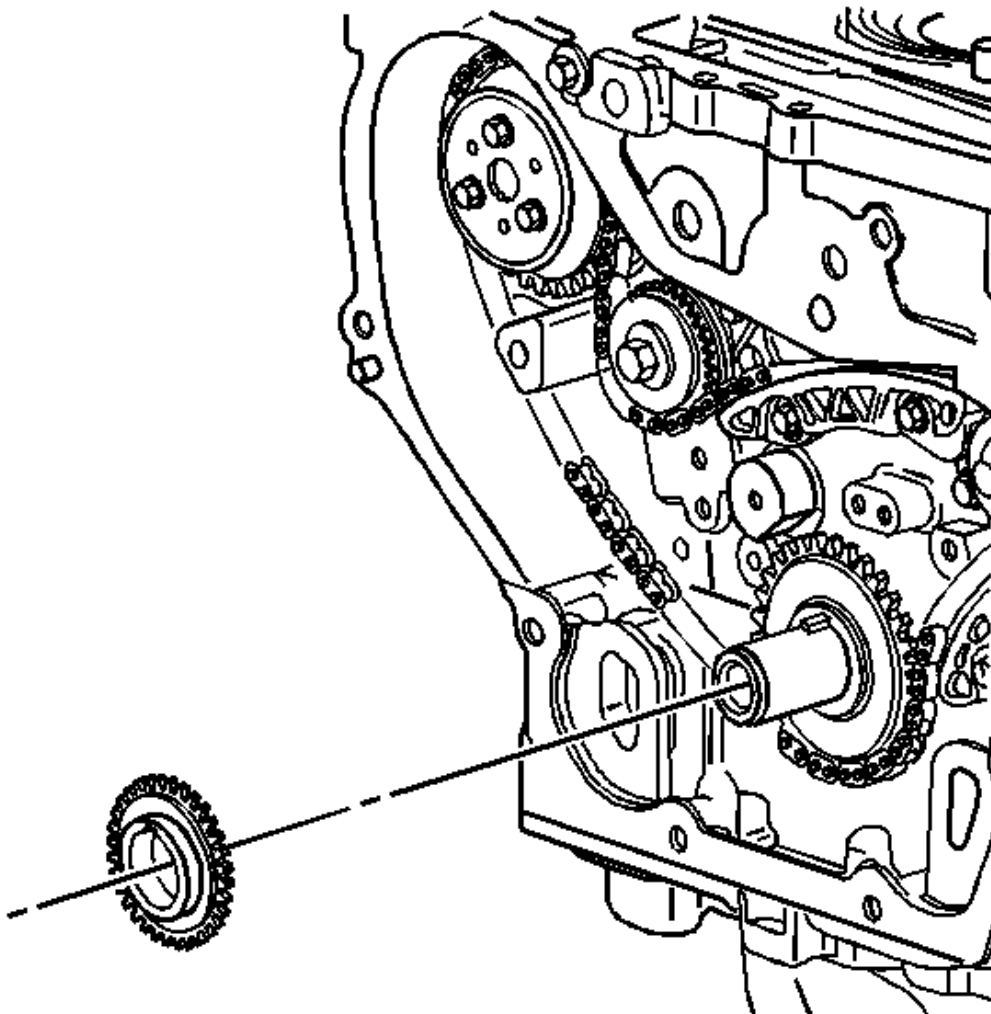


Fig. 95: View Of Crankshaft Sprocket
Courtesy of GENERAL MOTORS CORP.

18. Remove the crankshaft sprocket.

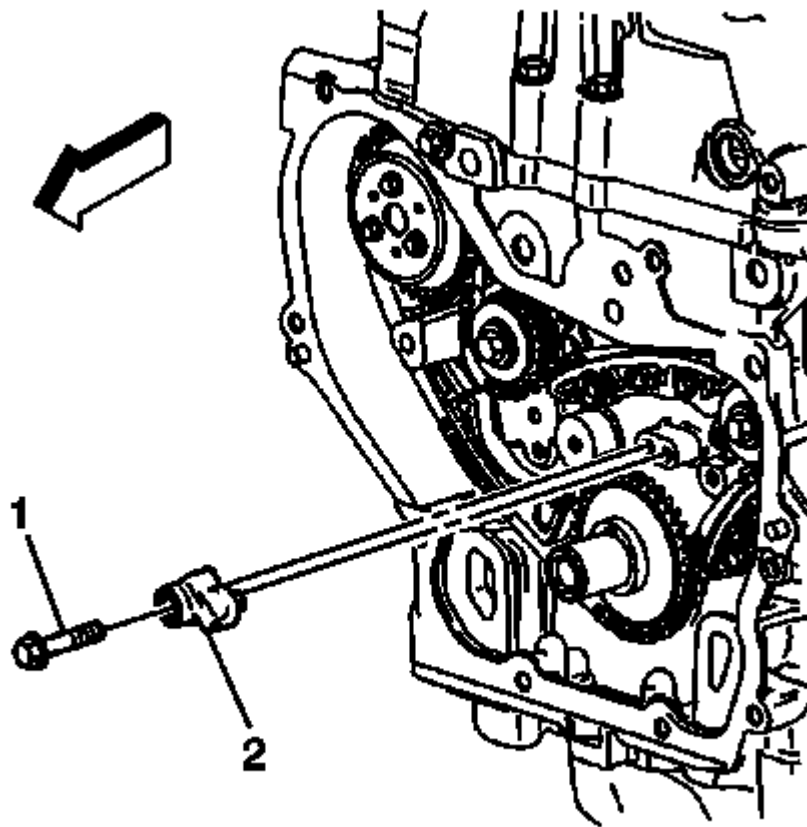


Fig. 96: View Of Oil Nozzle & Bolt
Courtesy of GENERAL MOTORS CORP.

19. Remove the oil nozzle and bolt.

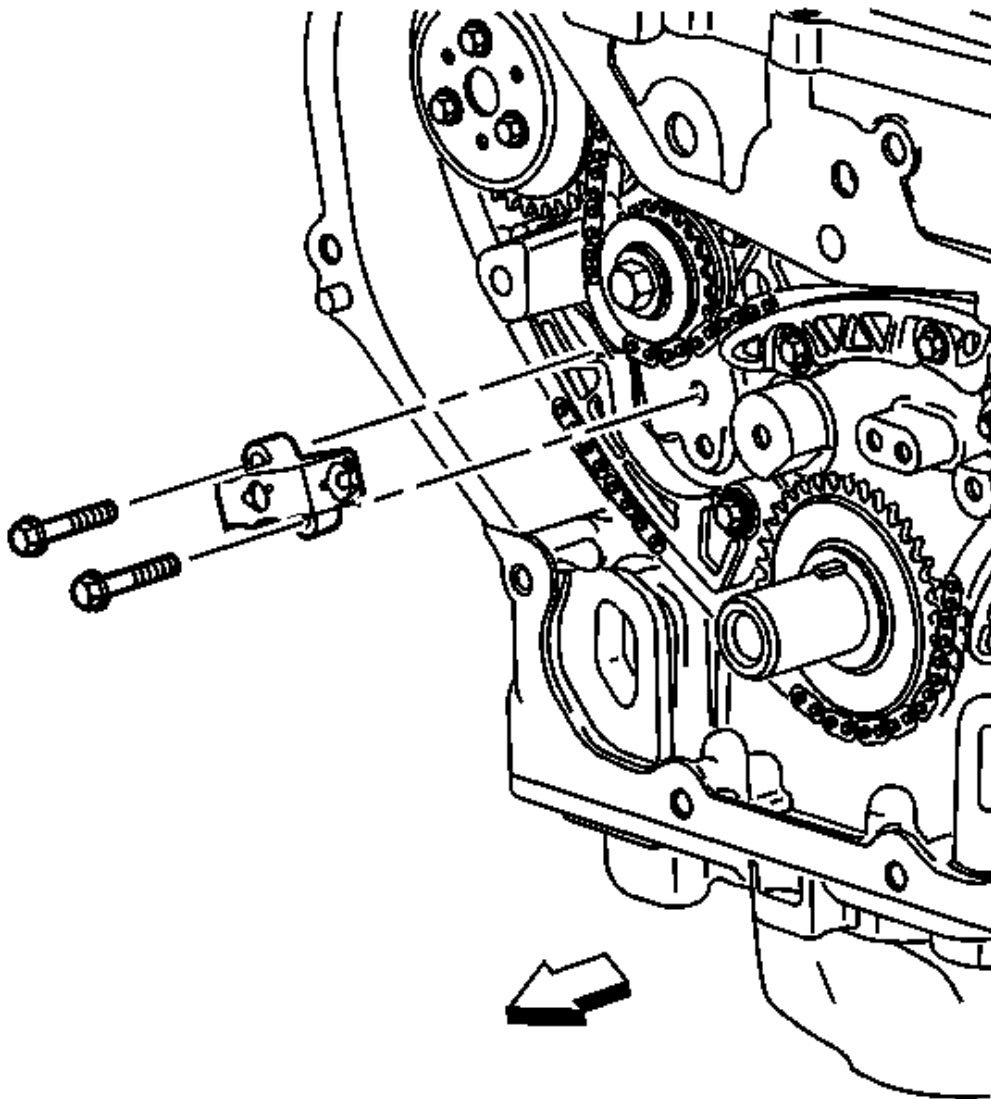


Fig. 97: Identifying Balance Shaft Drive Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

20. Remove the balance shaft drive chain tensioner.

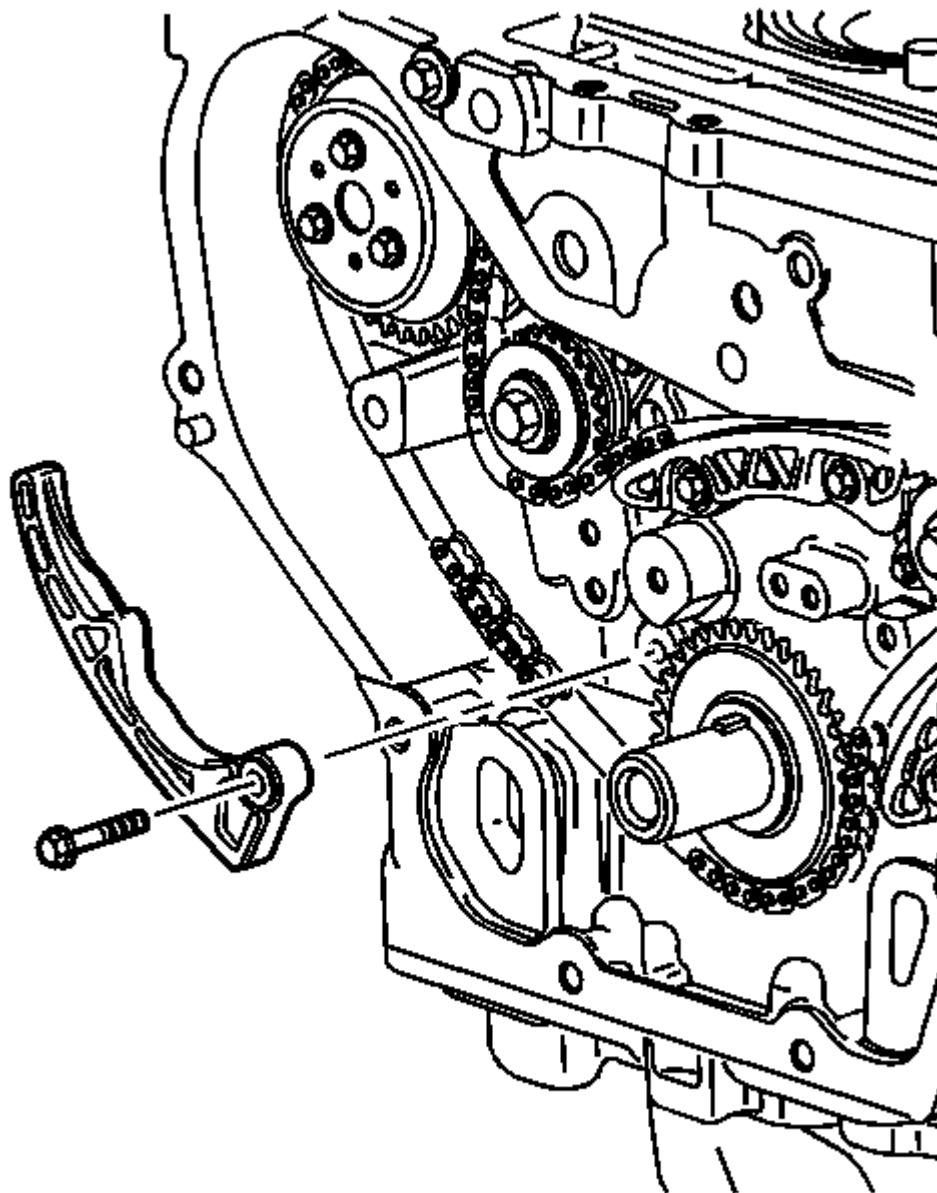


Fig. 98: View Of Adjustable Balance Shaft Chain Guide
Courtesy of GENERAL MOTORS CORP.

21. Remove the adjustable balance shaft chain guide.

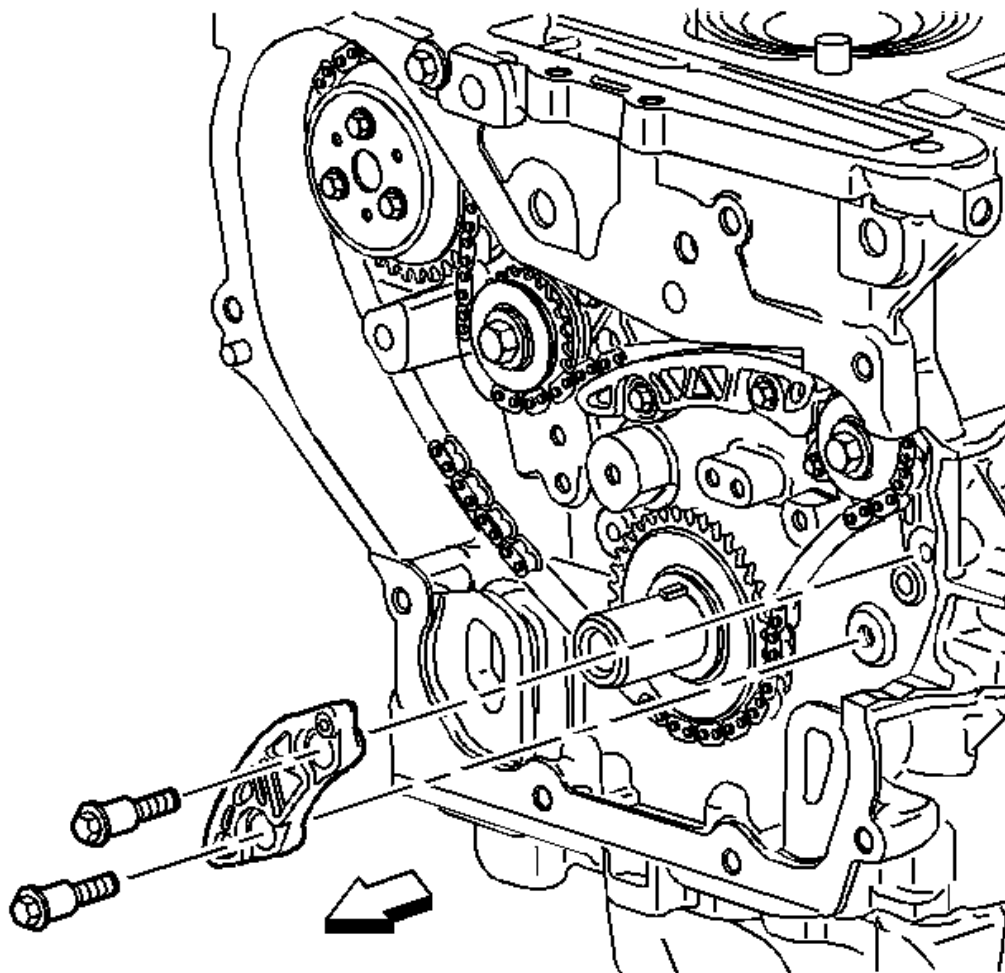


Fig. 99: Exploded View Of Small Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

22. Remove the small balance shaft drive chain guide.

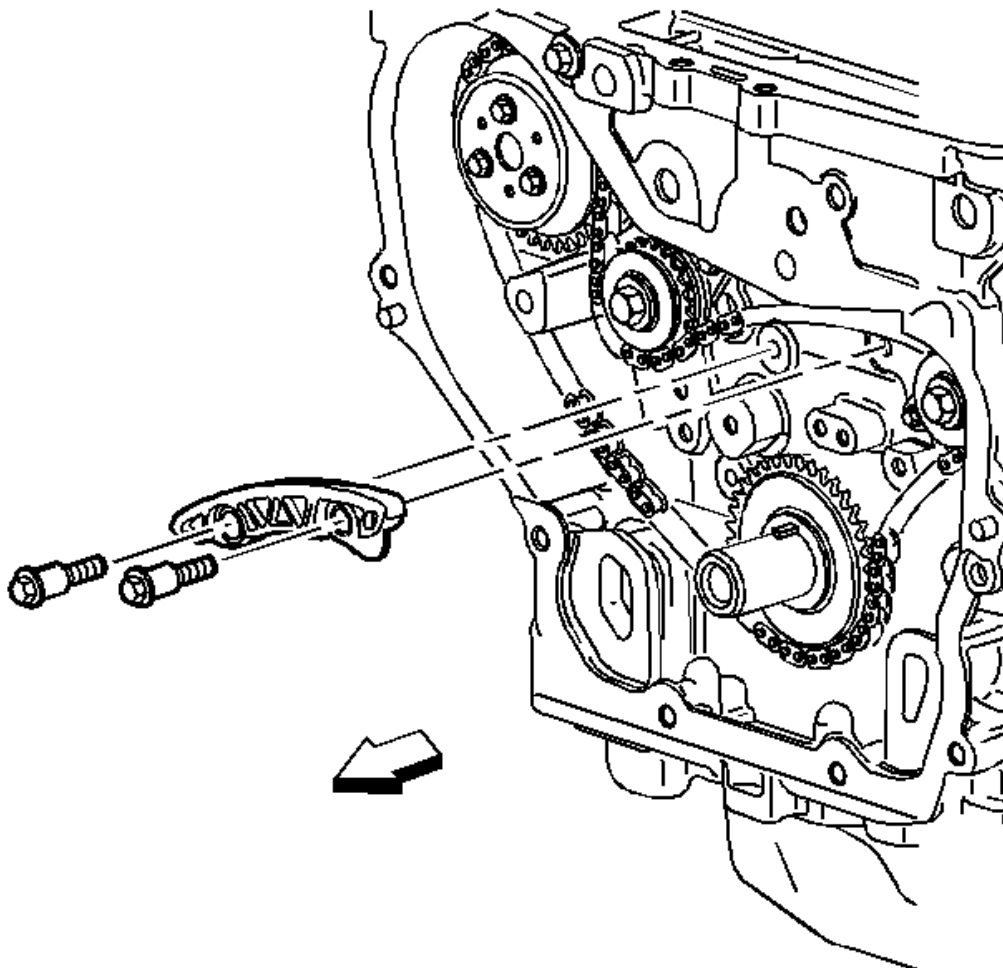


Fig. 100: View Of Upper Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

23. Remove the upper balance shaft drive chain guide.

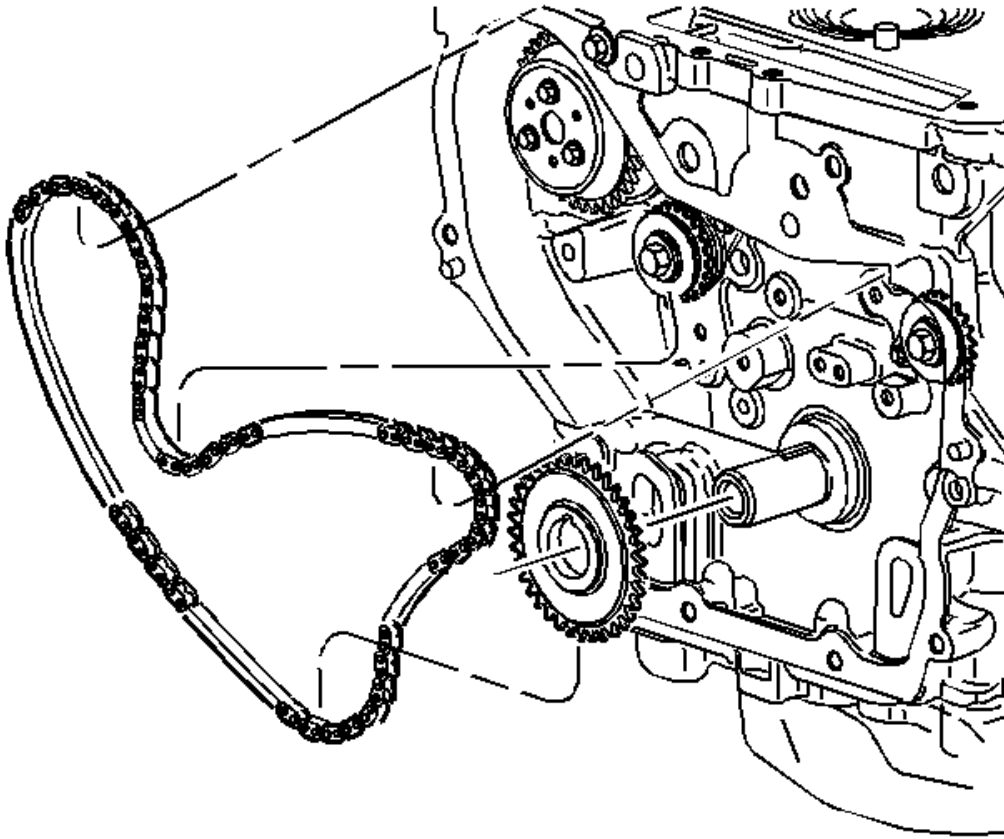


Fig. 101: Identifying Upper Balance Shaft Drive Chain/Sprocket
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: It may ease removal of the balance shaft drive chain to get all of the slack in the chain between the crankshaft and water pump sprockets.

24. Remove the balance shaft drive chain.

Installation Procedure

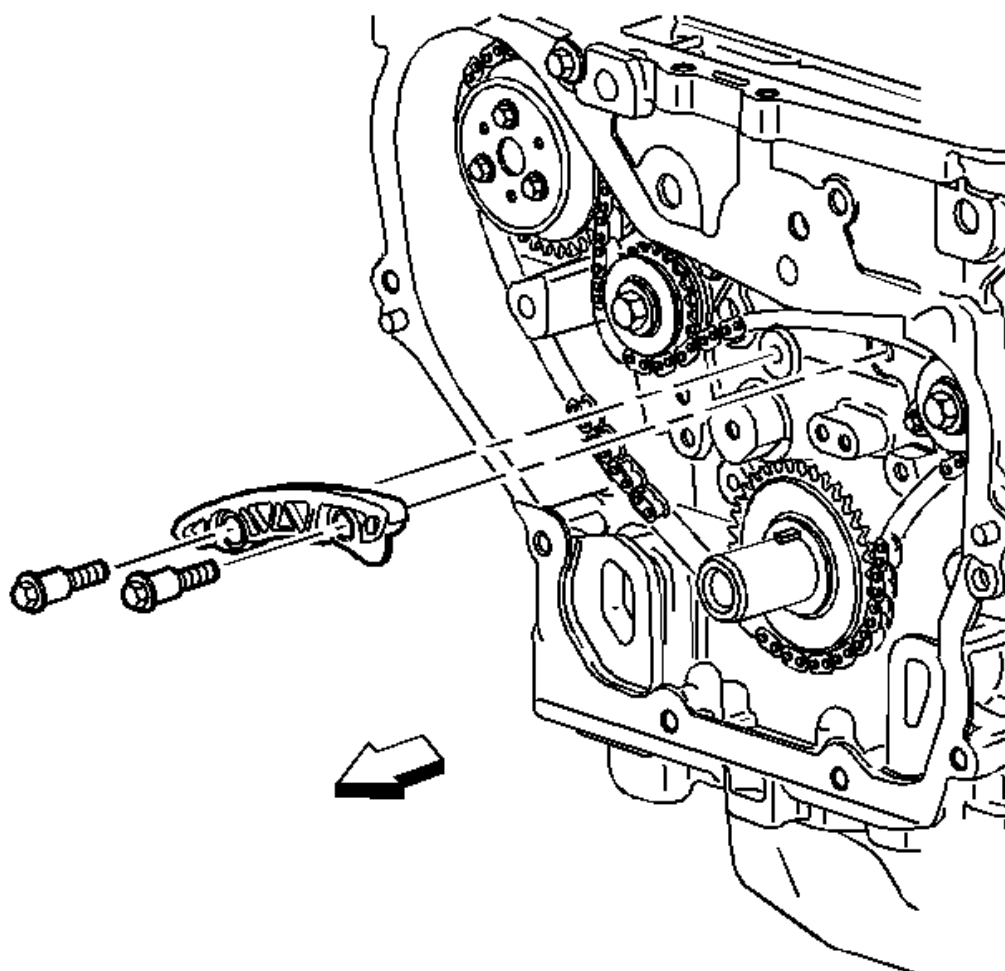


Fig. 102: View Of Upper Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

IMPORTANT: If the balance shafts are not properly timed to the engine, the engine may vibrate and make noise.

1. Install the upper balance shaft chain guide.

Tighten: Tighten the upper balance shaft chain guide bolts to 15 N.m (133 lb in).

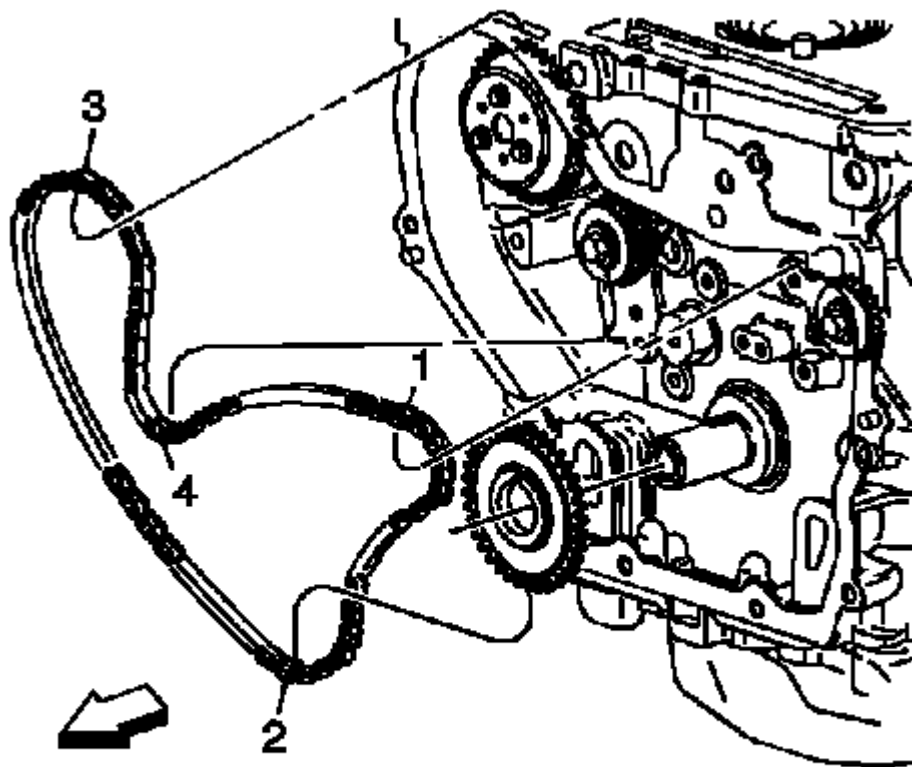


Fig. 103: Aligning Balance Shaft Drive Chain
Courtesy of GENERAL MOTORS CORP.

2. Install the balance shaft drive chain with the colored links lined up on with the marks on the balance shaft drive sprockets and the crankshaft sprocket. Use the following procedure to line up the links with the sprockets:

Orient the chain so that the copper colored and chrome links are visible.

1. Place the uniquely colored link (1) so that it lines up with the timing mark on the intake side balance shaft sprocket.
2. Working clockwise around the chain, place the first matching colored link (2) in line with the timing mark on the crankshaft drive sprocket. (approximately 5 o'clock position on the crank sprocket).
3. Place the chain (3) on the water pump drive sprocket (alignment is not critical).
4. Align the last matching colored link (4) with the timing mark on the exhaust side balance shaft drive sprocket.

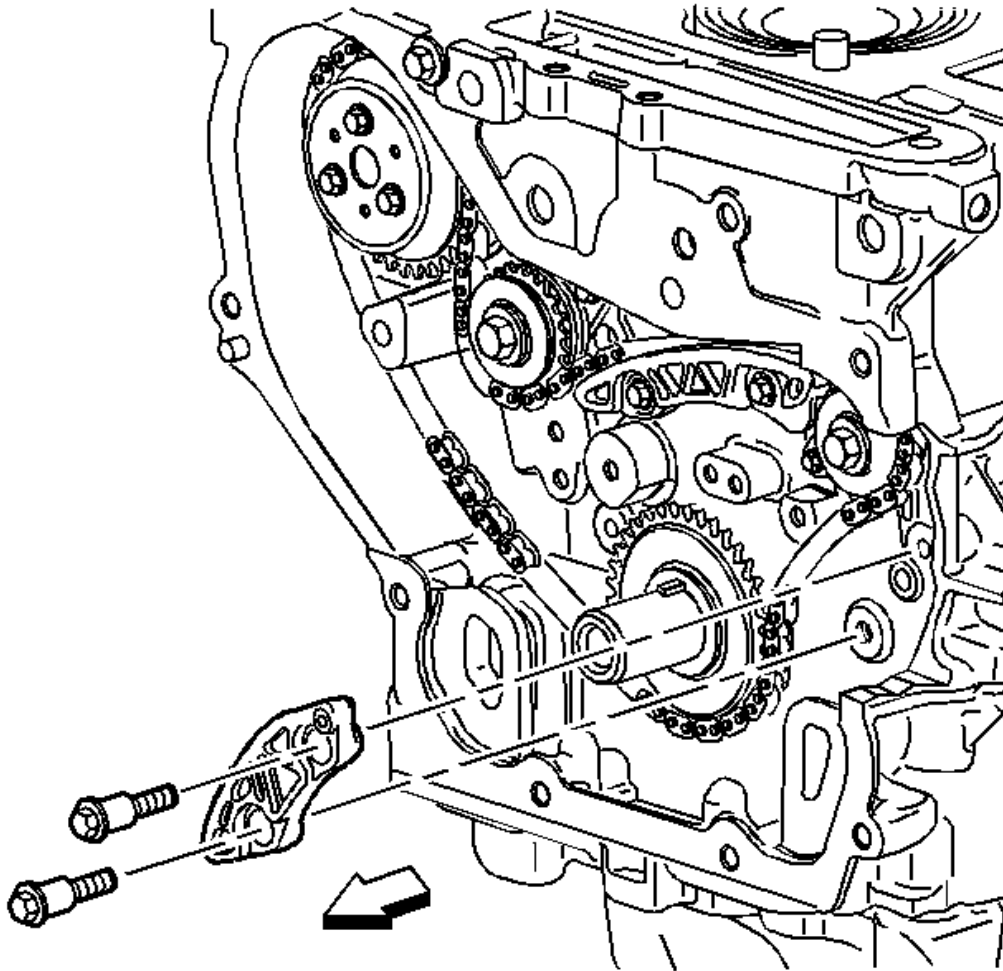


Fig. 104: Exploded View Of Small Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

3. Install the small balance shaft chain guide.
4. Tighten the balance shaft chain guide bolts.

Tighten: Tighten the chain guide bolts to 10 N.m (89 lb in).

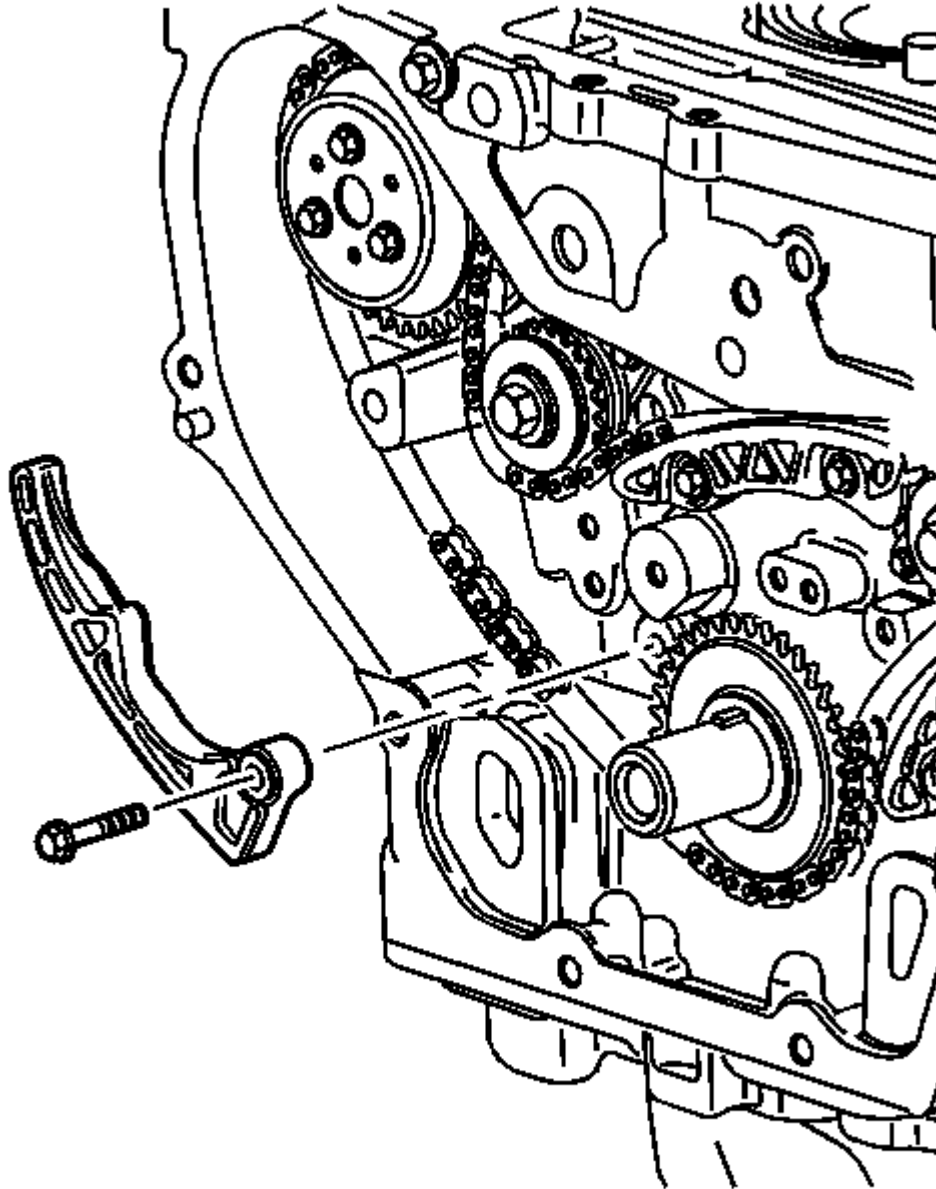


Fig. 105: View Of Adjustable Balance Shaft Chain Guide
Courtesy of GENERAL MOTORS CORP.

5. Install the adjustable balance shaft drive chain guide.

Tighten: Tighten the chain guide bolts to 10 N.m (89 lb in).

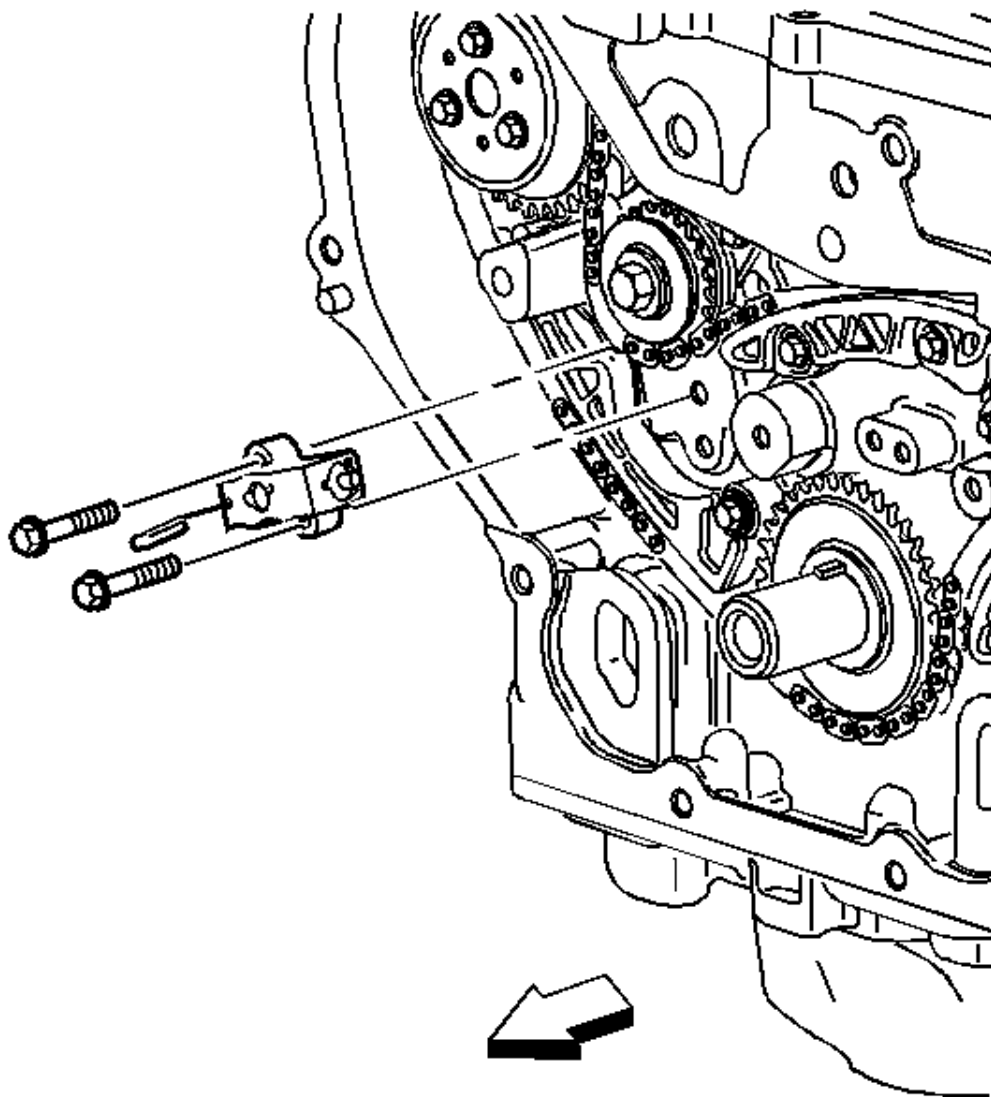


Fig. 106: View Of Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

6. Turn the tensioner plunger 90 degrees in its bore. Compress the plunger until a paper clip can be inserted through the hole in the plunger body and into the hole in the tensioner plunger.
7. Install the timing chain tensioner.
8. Tighten the chain tensioner bolts.

Tighten: Tighten the chain tensioner bolts to 10 N.m (89 lb in).

9. Remove the paper clip from the balance shaft drive chain tensioner.

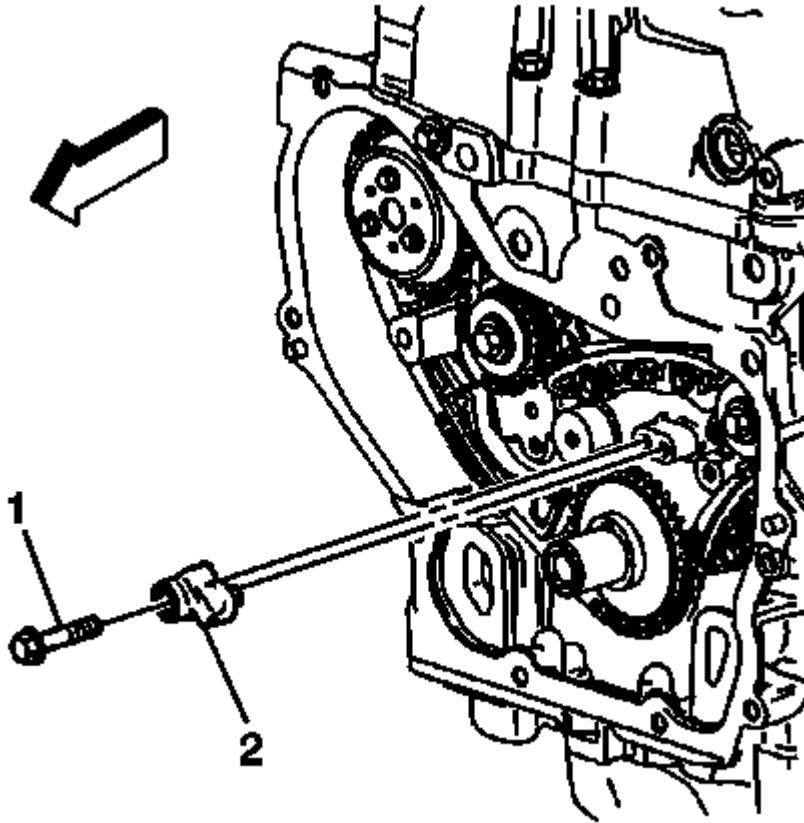


Fig. 107: View Of Oil Nozzle & Bolt
Courtesy of GENERAL MOTORS CORP.

10. Install the oil nozzle and bolt.

Tighten: Tighten the oil nozzle bolt to 10 N.m (89 lb in).

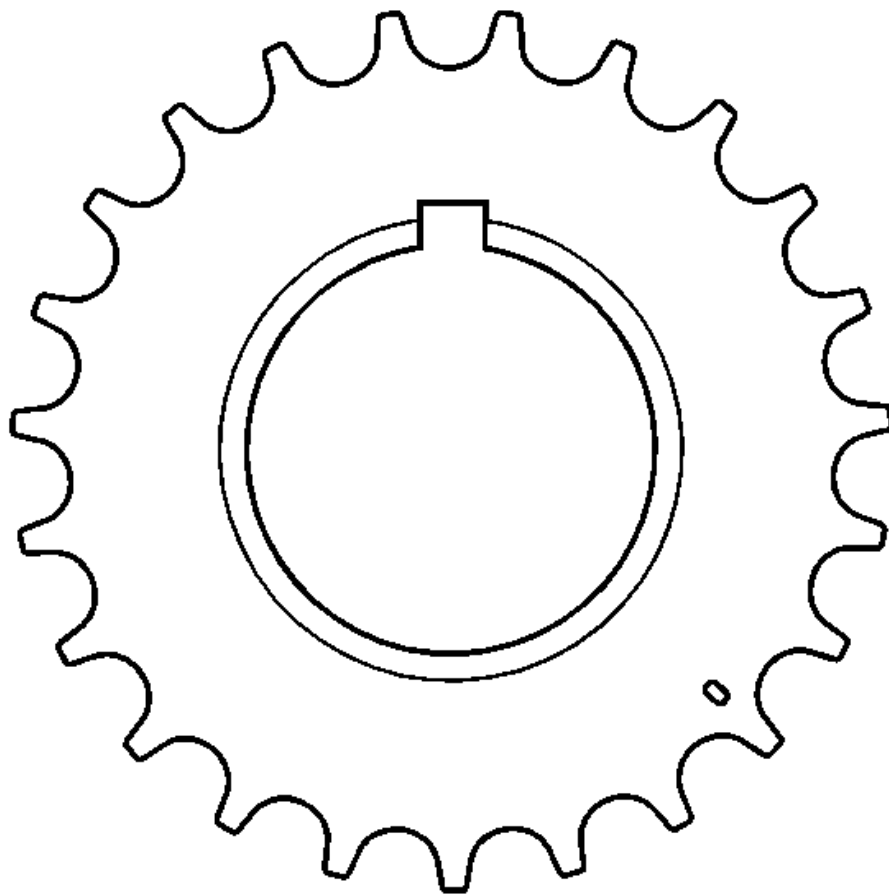


Fig. 108: View Of Crankshaft Sprocket Timing Mark
Courtesy of GENERAL MOTORS CORP.

11. Install the crankshaft sprocket with timing mark at the 5 o'clock position.

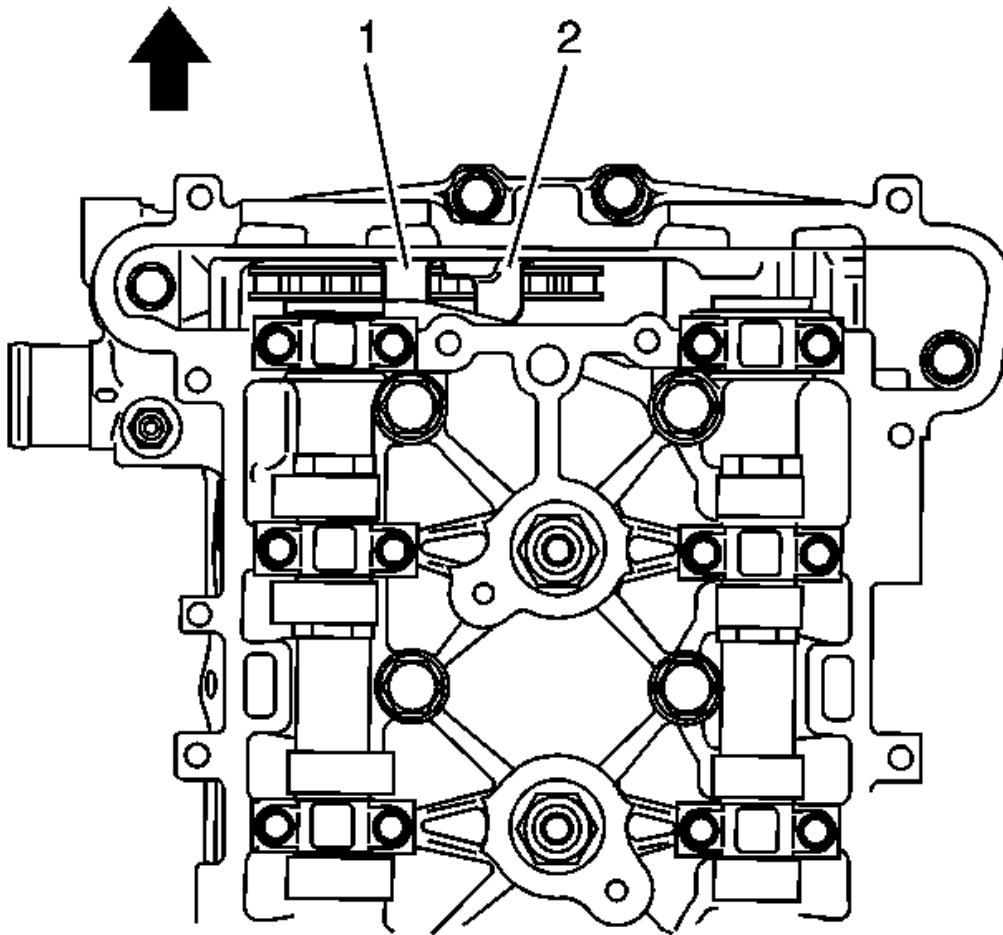


Fig. 109: Locating Cylinder Block Bosses

Courtesy of GENERAL MOTORS CORP.

12. Lower the timing chain through the opening in the top of the cylinder head. Carefully ensure that the chain goes around both sides of the cylinder block bosses (1, 2).

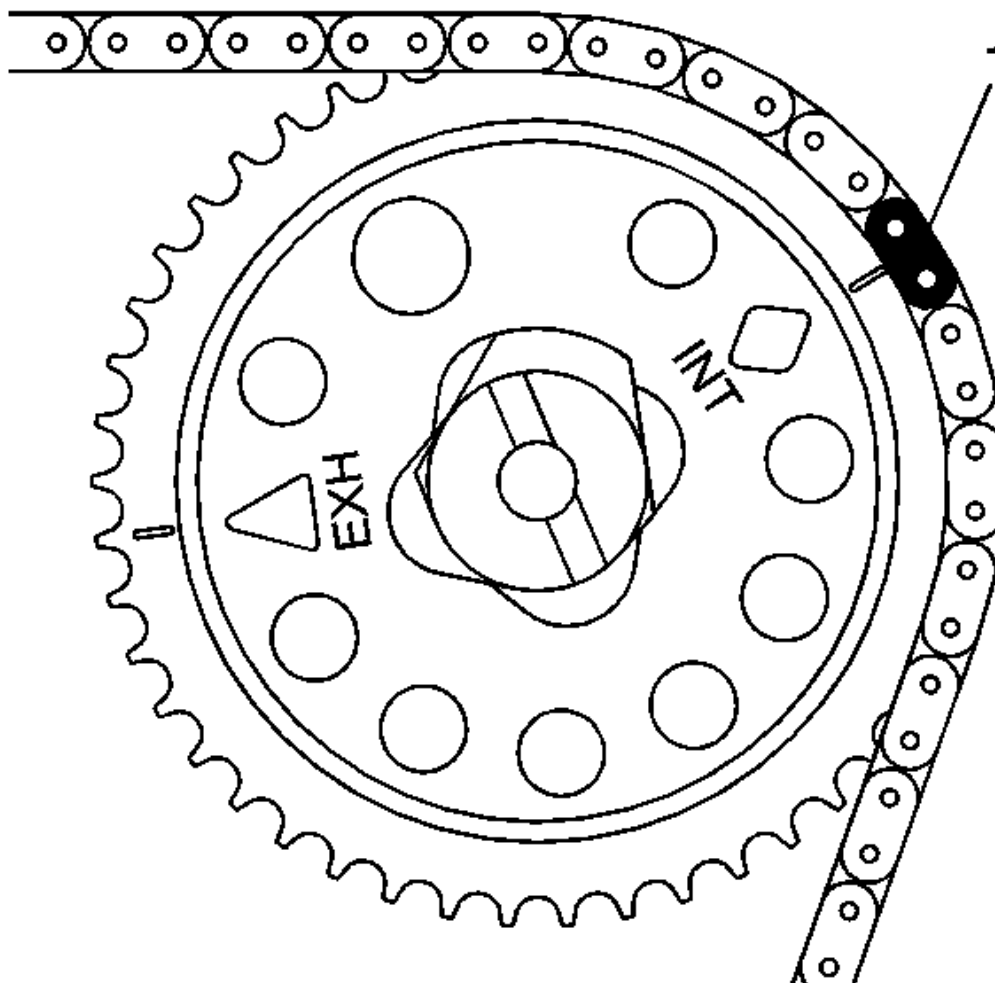


Fig. 110: Aligning Timing Chain Link & Intake Sprocket Timing Mark
Courtesy of GENERAL MOTORS CORP.

13. Install the intake camshaft sprocket with the INT diamond at the 2 o'clock position.

IMPORTANT: Always install NEW sprocket bolts.

14. Hand tighten a NEW intake camshaft sprocket bolt.
15. Route the timing chain around the crankshaft sprocket with the matching colored link aligning with the timing mark.
16. Route the timing chain around the intake camshaft sprocket with the uniquely colored link (1) aligning with the INT diamond.

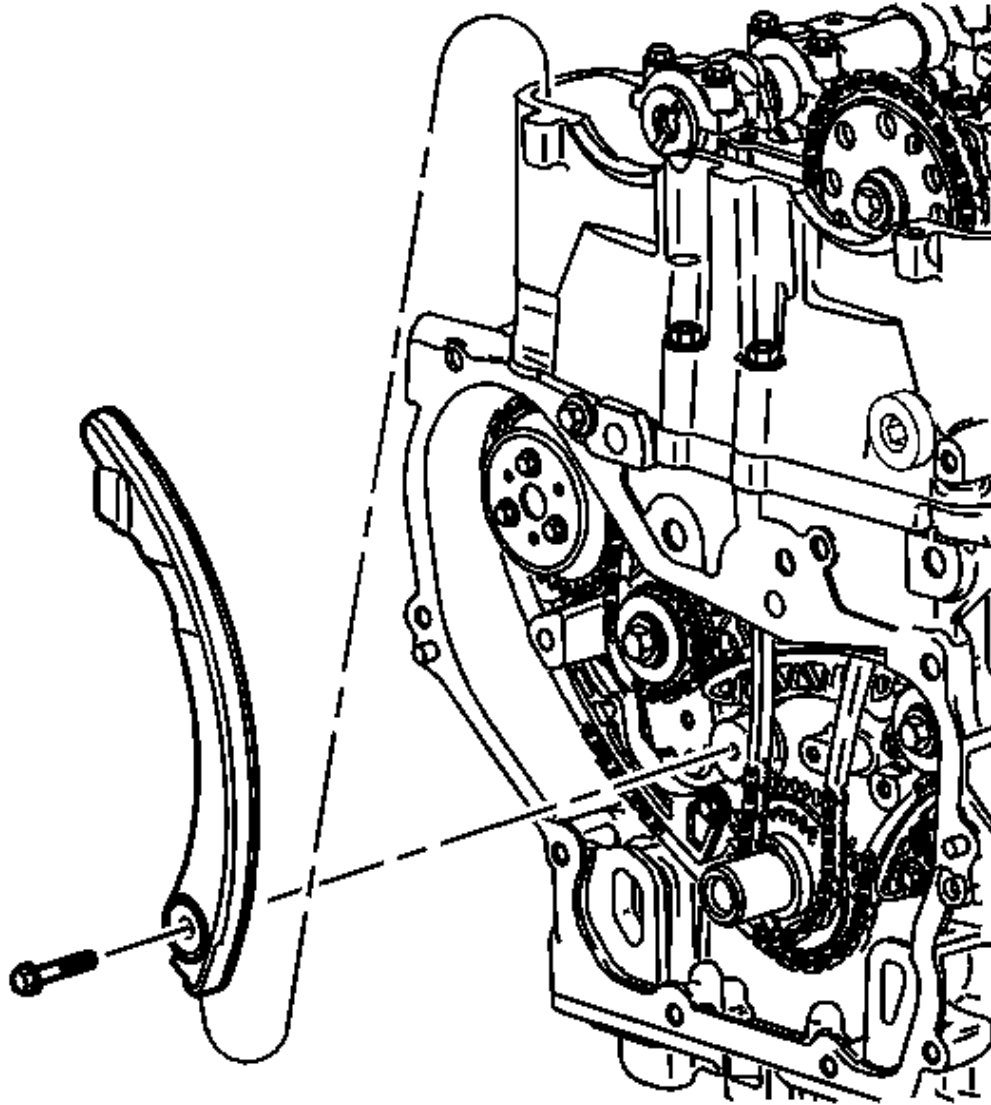


Fig. 111: View Of Timing Chain Tensioner Guide
Courtesy of GENERAL MOTORS CORP.

17. Install the timing chain tensioner guide through the opening in the top of the cylinder head.

Tighten: Tighten the timing chain tensioner guide bolt to 10 N.m (89 lb in).

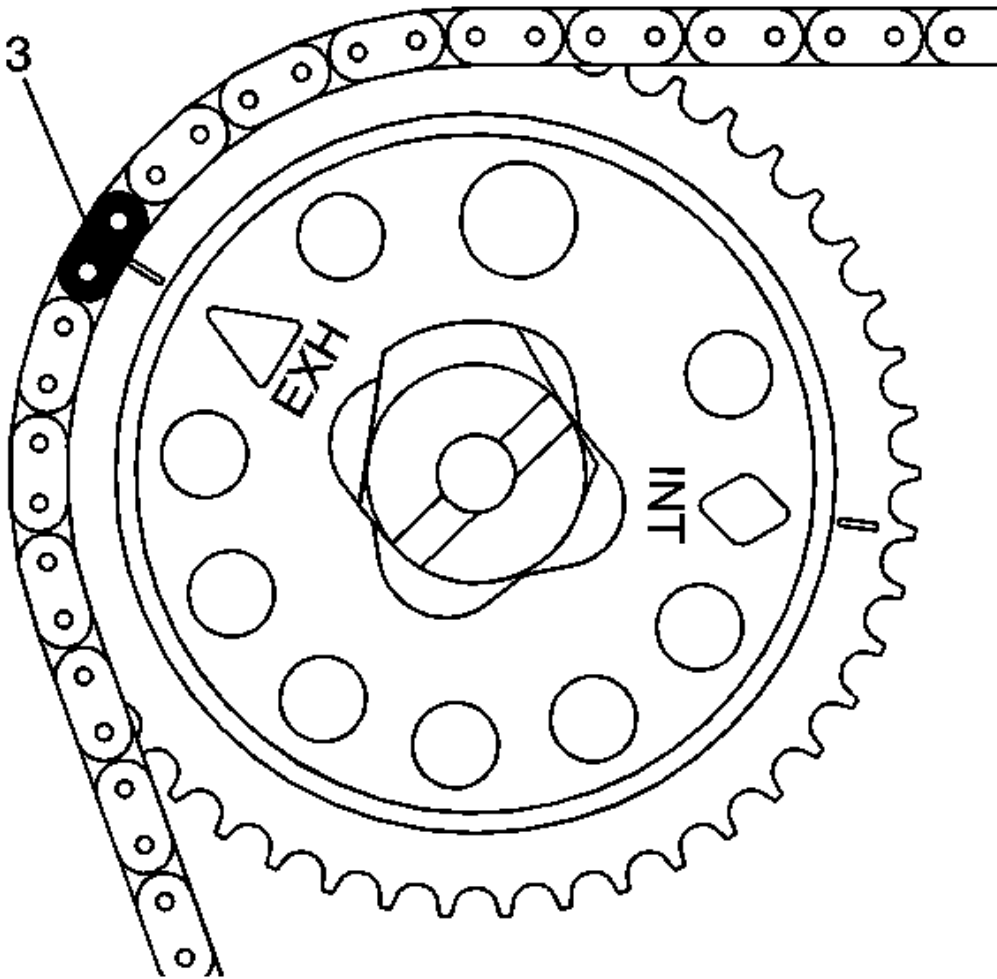


Fig. 112: Aligning Timing Chain Link & Exhaust Timing Mark
Courtesy of GENERAL MOTORS CORP.

18. Install the exhaust camshaft sprocket with the timing chain matching colored link (3) at EXH triangle aligned at the 10 o'clock position.

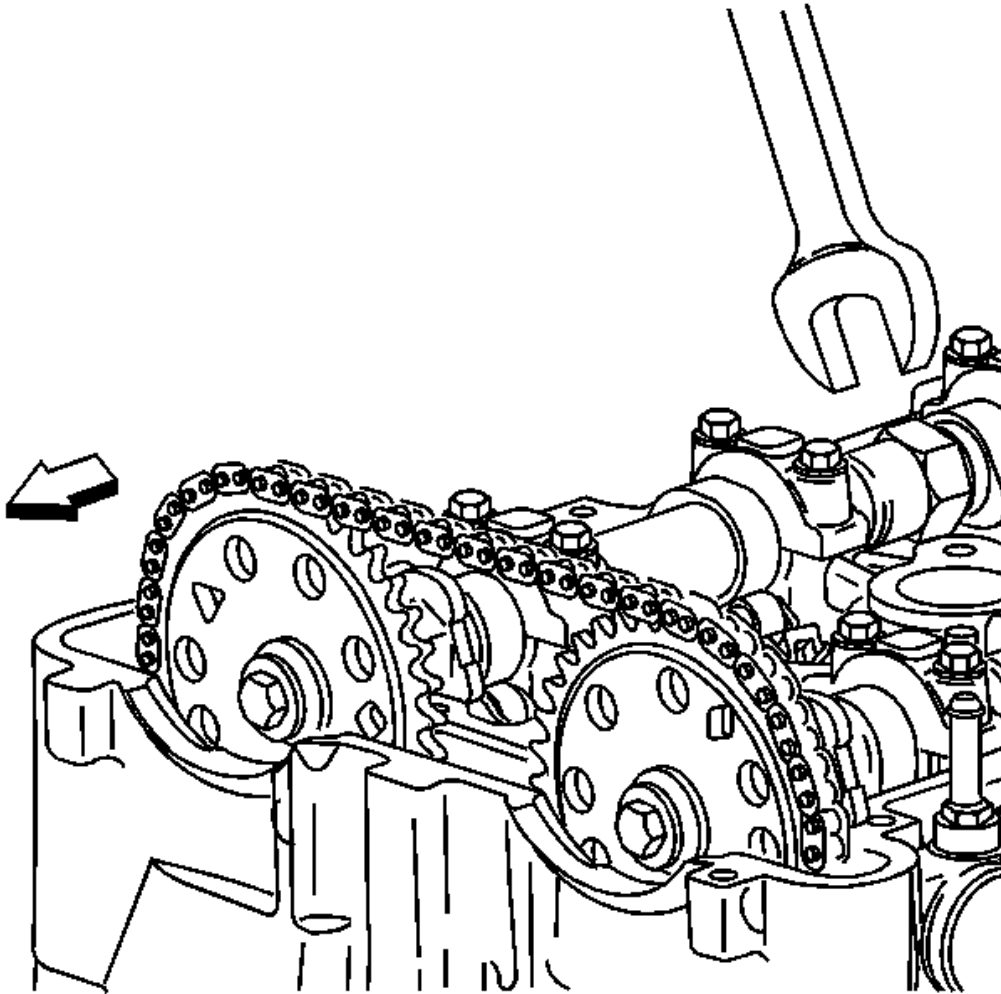


Fig. 113: Using 24 mm Wrench To Align Camshaft
Courtesy of GENERAL MOTORS CORP.

19. Use a 24 mm wrench to rotate the camshaft slightly, until exhaust sprocket aligns with the camshaft.

IMPORTANT: Always install NEW sprocket bolts.

20. Hand tighten the NEW exhaust camshaft sprocket bolt.

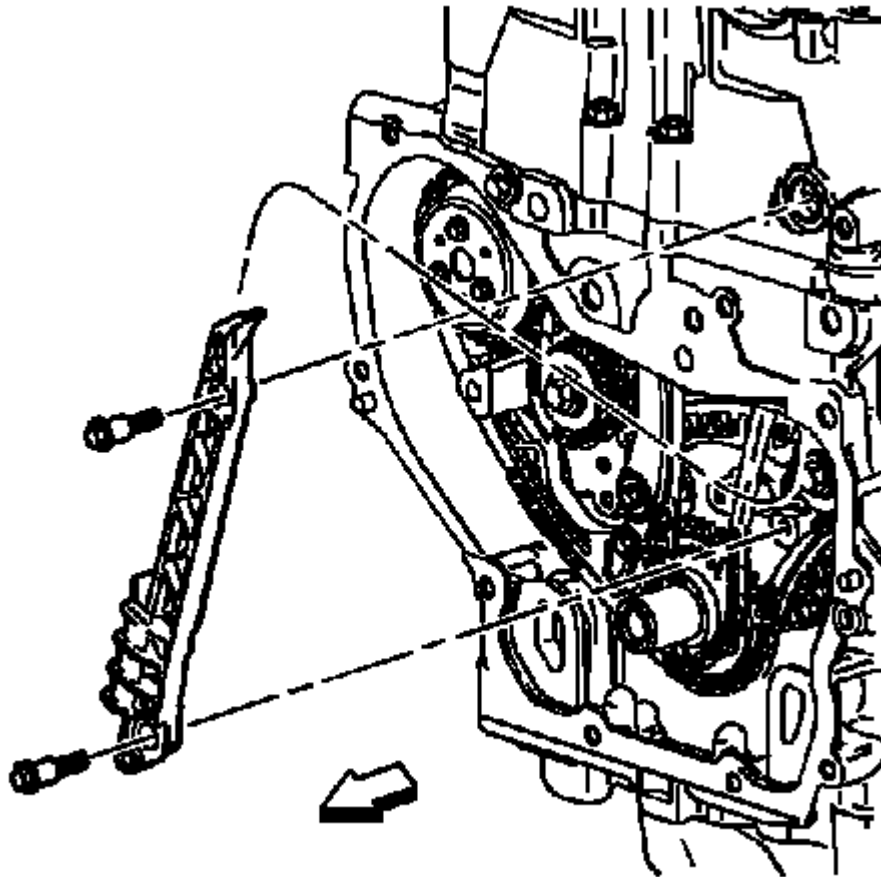


Fig. 114: View Of Fixed Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

21. Install the fixed timing chain guide.

Tighten: Tighten the fixed timing chain bolts to 15 N.m (133 lb in).

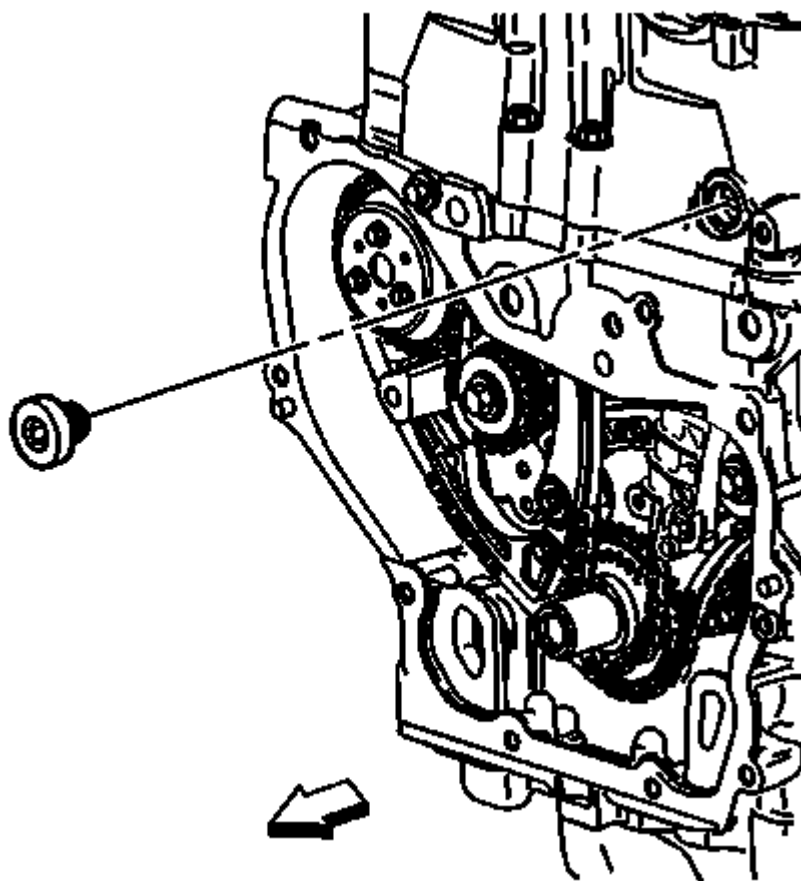


Fig. 115: View Of Fixed Timing Chain Guide Access Plug
Courtesy of GENERAL MOTORS CORP.

22. Apply sealant compound to thread and install the timing chain guide bolt access hole plug. Refer to **Adhesives, Fluids, Lubricants, and Sealers** for the correct part number.

Tighten: Tighten the chain guide plug to 90 N.m (59 lb ft).

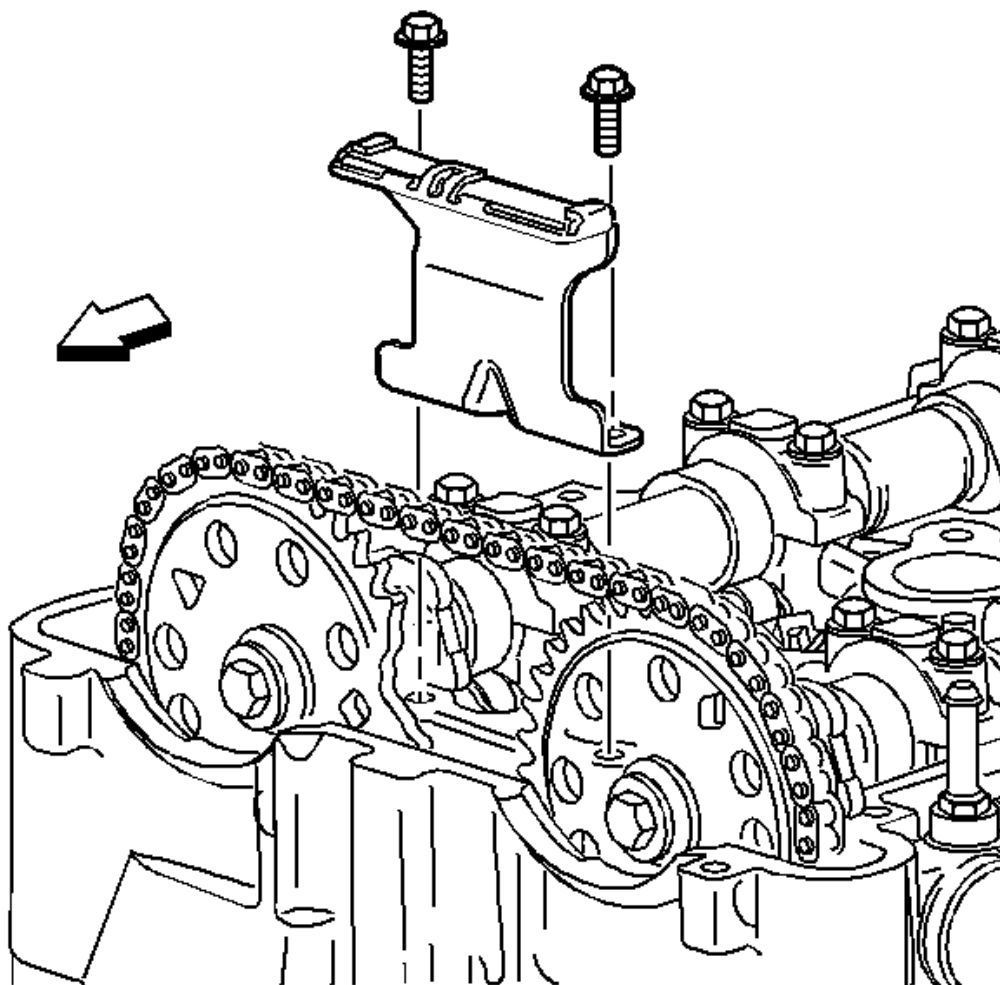


Fig. 116: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

23. Install the timing chain upper guide.

Tighten: Tighten the timing chain upper guide bolts to 10 N.m (89 lb in).

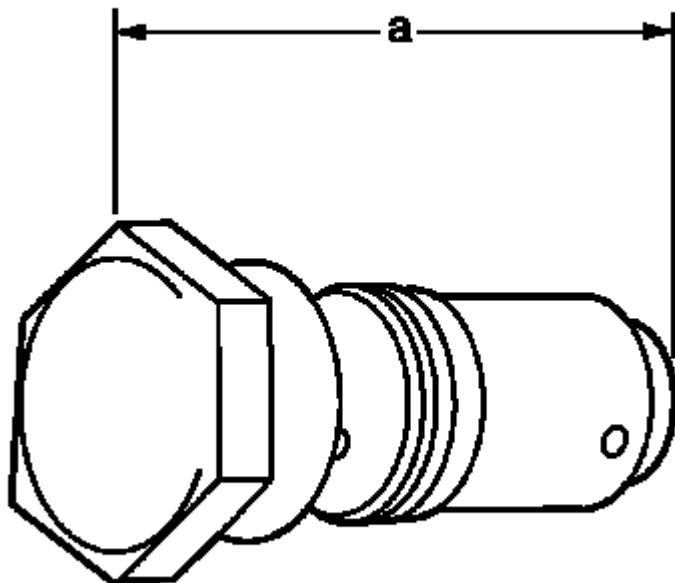


Fig. 117: Measuring Timing Chain Tensioner Assembly
Courtesy of GENERAL MOTORS CORP.

24. Inspect the timing chain tensioner. If the timing chain tensioner, O-ring seal, or washer is damaged, replace the timing chain tensioner.
25. Measure the timing chain tensioner assembly from end to end.

A new tensioner should be supplied in the fully compressed non-active state. A tensioner in the compressed state will measure 72 mm (2.83 in) (a) from end to end. A tensioner in the active state will measure 85 mm (3.35 in) (a) from end to end.

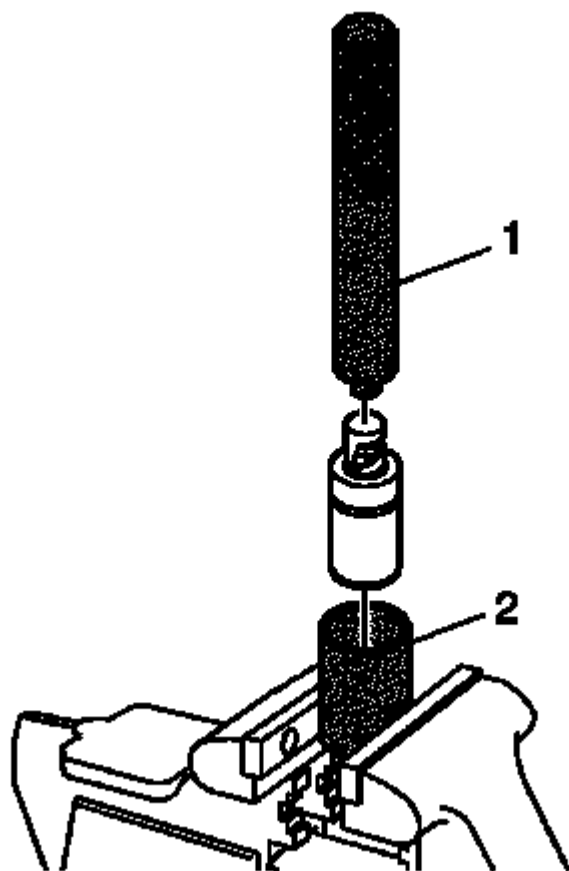


Fig. 118: Compressing Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

26. If the timing chain tensioner is not in the compressed state, perform the following steps:
1. Remove the piston assembly from the body of the timing chain tensioner by pulling it out.
 2. Install the J 45027-2 (2) into a vise.
 3. Install the notch end of the piston assembly into the J 45027-2 (2).
 4. Using the J 45027-1 (1), turn the ratchet cylinder into the piston.

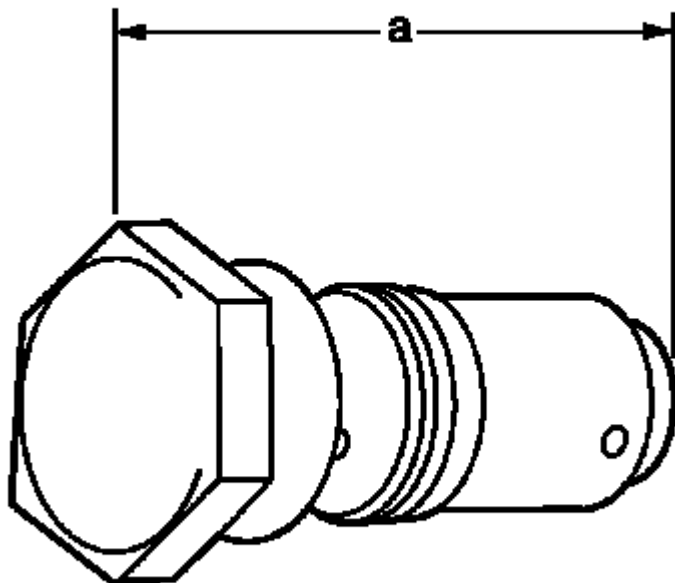


Fig. 119: Measuring Timing Chain Tensioner Assembly
Courtesy of GENERAL MOTORS CORP.

27. Inspect the bore of the tensioner body for dirt, debris, and damage. If any damage appears, replace the tensioner. Clean dirt or debris out with a lint-free cloth.
28. Install the compressed piston assembly back into the timing chain tensioner body until it stops at the bottom of the bore. Do not compress the piston assembly against the bottom of the bore. If the piston assembly is compressed against the bottom of the bore, it will activate the tensioner, which will then need to be reset again.
29. At this point the tensioner should measure approximately 72 mm (2.83 in) (a) from end to end. If the tensioner does not read 72 mm (2.83 in) (a) from end to end repeat steps 26.1 through 26.4.

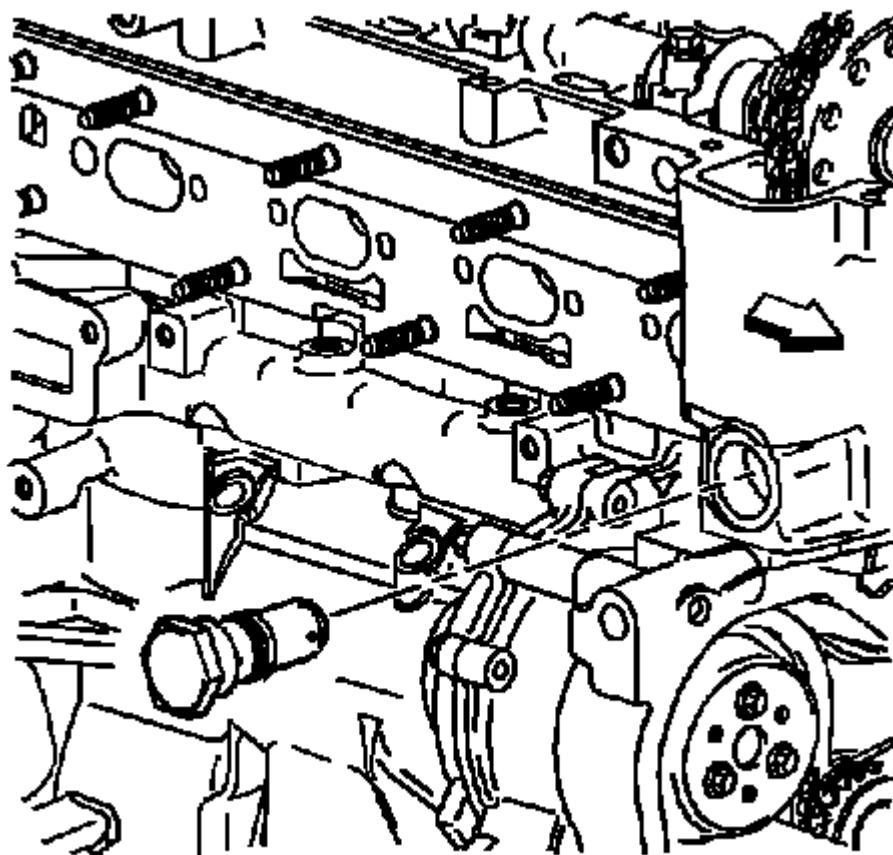


Fig. 120: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

30. Install the timing chain tensioner.

Tighten: Tighten the timing chain tensioner to 75 N.m (55 lb ft).

31. Use a suitable tool with a rubber tip on the end. Feed the tool down through the camshaft drive chain to rest on the timing chain. Then give a sharp jolt diagonally downwards to release the tensioner.

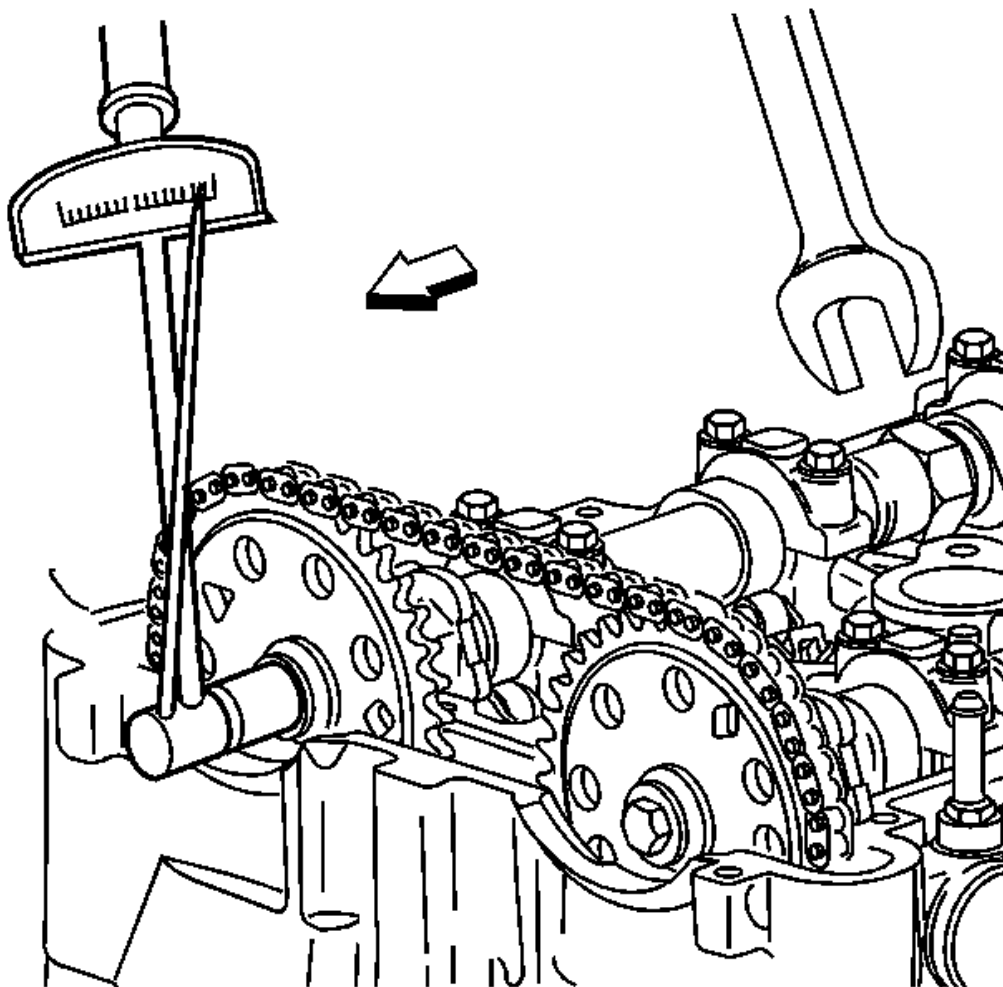


Fig. 121: Holding Camshaft Stationary With Wrench On Hex Casting On Camshaft
 Courtesy of GENERAL MOTORS CORP.

32. Use a 24 mm wrench to hold the camshaft.

Tighten: Tighten the NEW camshaft bolts to 85 N.m (63 lb ft) plus 30 degrees.

33. Install the camshaft cover. Refer to **Camshaft Cover Replacement**.
34. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle**.
35. Install the engine front cover. Refer to **Engine Front Cover Replacement**.
36. Lower the vehicle.
37. Connect negative battery cable. Refer to **Battery Negative Cable Disconnection and Connection**.

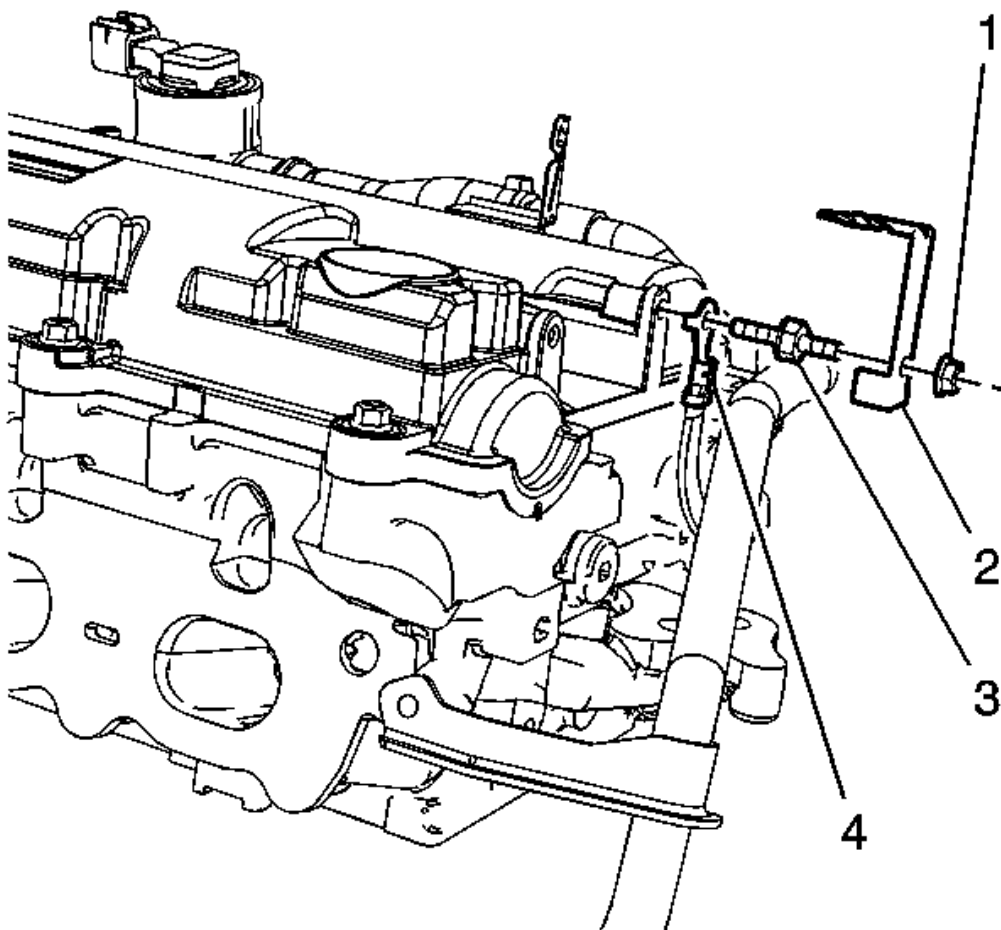
CAMSHAFT COVER REPLACEMENT**Removal Procedure**

Fig. 122: Locating Fuel Pipe, Bracket & Nut
Courtesy of GENERAL MOTORS CORP.

1. Remove the intake manifold cover. Refer to **Intake Manifold Cover Replacement**.
2. Remove the air cleaner outlet resonator. Refer to **Air Cleaner Outlet Resonator Replacement**.
3. Remove the ignition coils. Refer to **Ignition Coil Replacement**.
4. Remove the fuel pipe bracket nut (1).
5. Remove the fuel pipe bracket (2) from the ground strap stud.
6. Remove the ground strap stud (3) from the camshaft cover.

7. Remove the ground strap (4) from the camshaft cover.

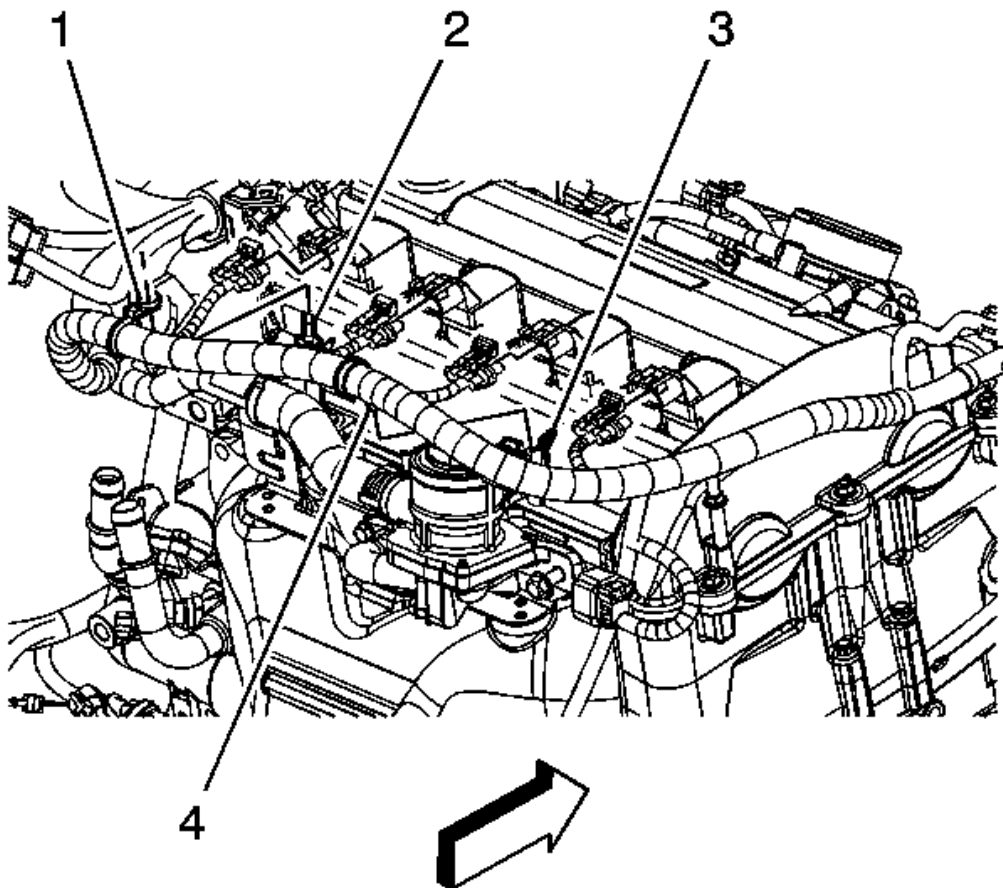


Fig. 123: View Of Engine Wiring Harness Clips
Courtesy of GENERAL MOTORS CORP.

8. Remove the engine wiring harness clips (1 and 4) from the stud (2) and camshaft cover (3).

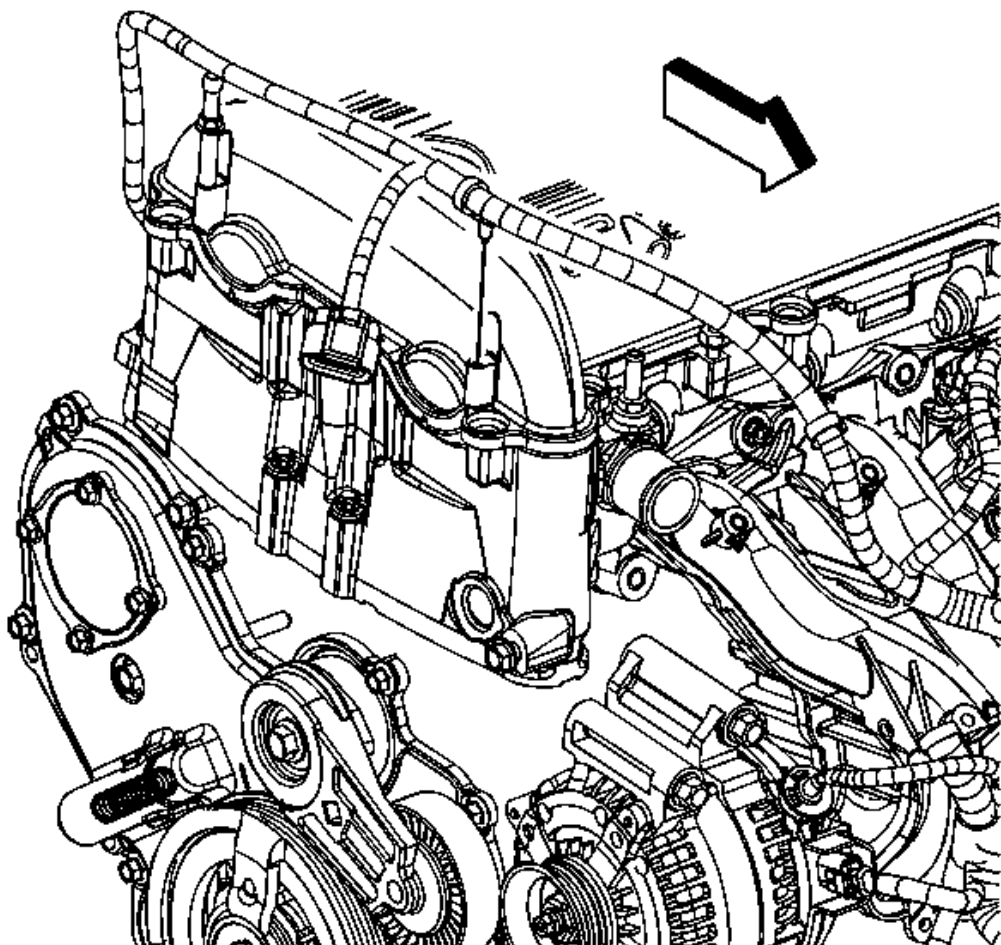


Fig. 124: View Of Engine Wiring Harness Clip At Camshaft Cover
Courtesy of GENERAL MOTORS CORP.

9. Remove the engine wiring harness clip from the camshaft cover.

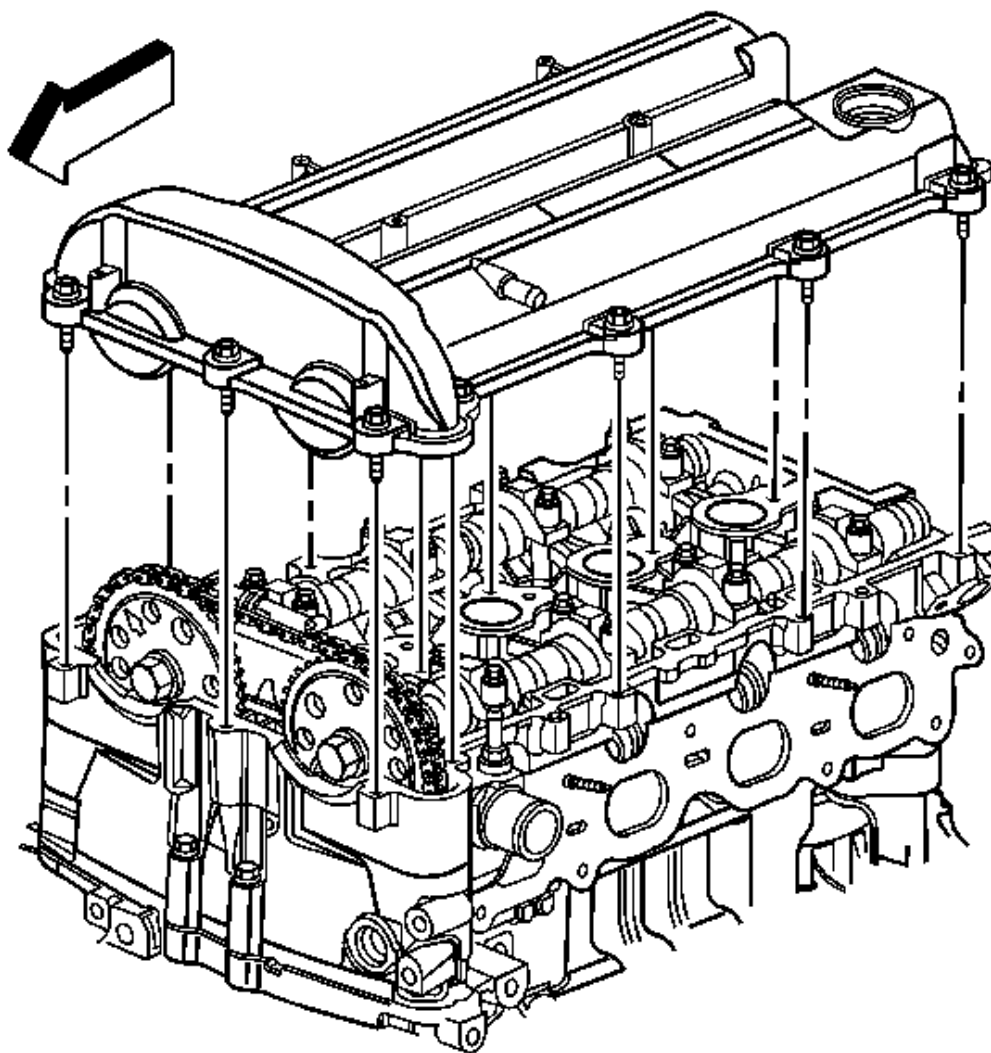


Fig. 125: Identifying Camshaft Cover & Bolts
Courtesy of GENERAL MOTORS CORP.

10. Remove the camshaft cover bolts.
11. Remove the camshaft cover.

Installation Procedure

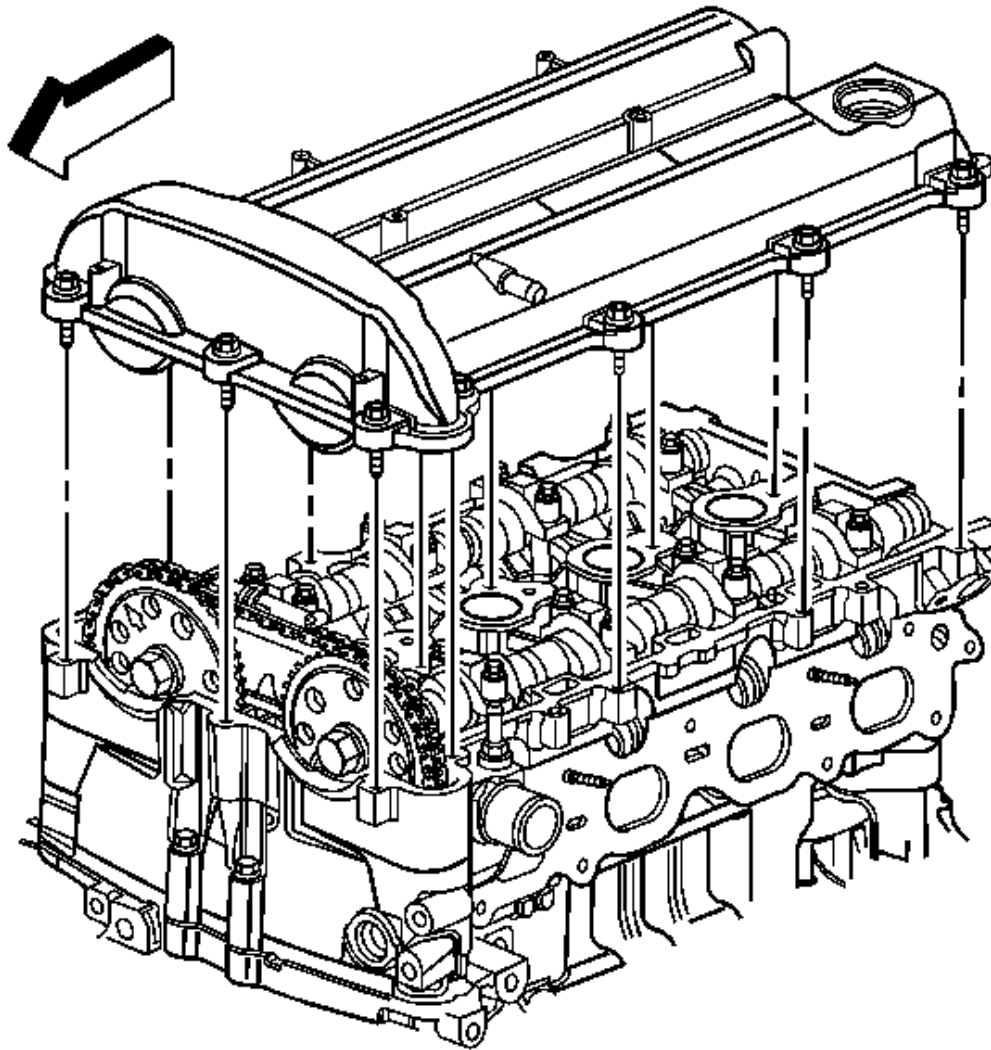


Fig. 126: Identifying Camshaft Cover & Bolts
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

1. Install the camshaft cover and bolts.

Tighten: Tighten the bolts to 10 N.m (89 lb in).

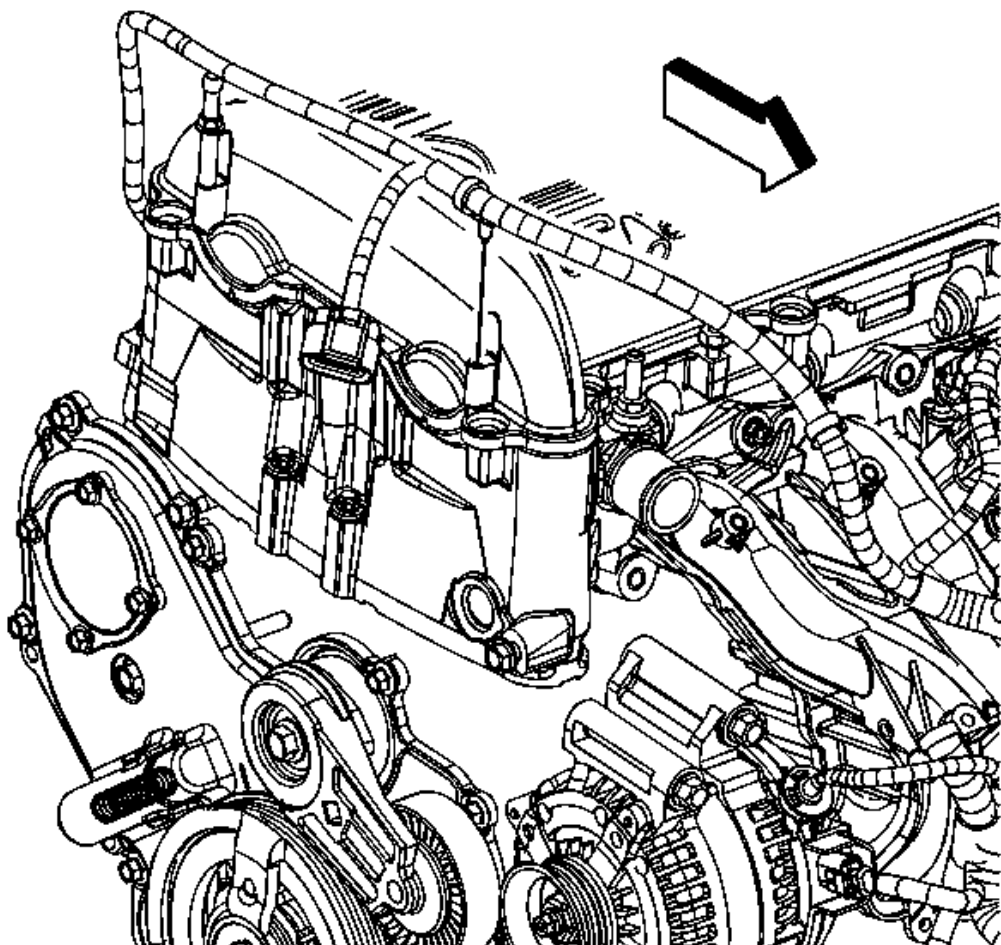


Fig. 127: View Of Engine Wiring Harness Clip At Camshaft Cover
Courtesy of GENERAL MOTORS CORP.

2. Install the engine wiring harness clip to the camshaft cover.

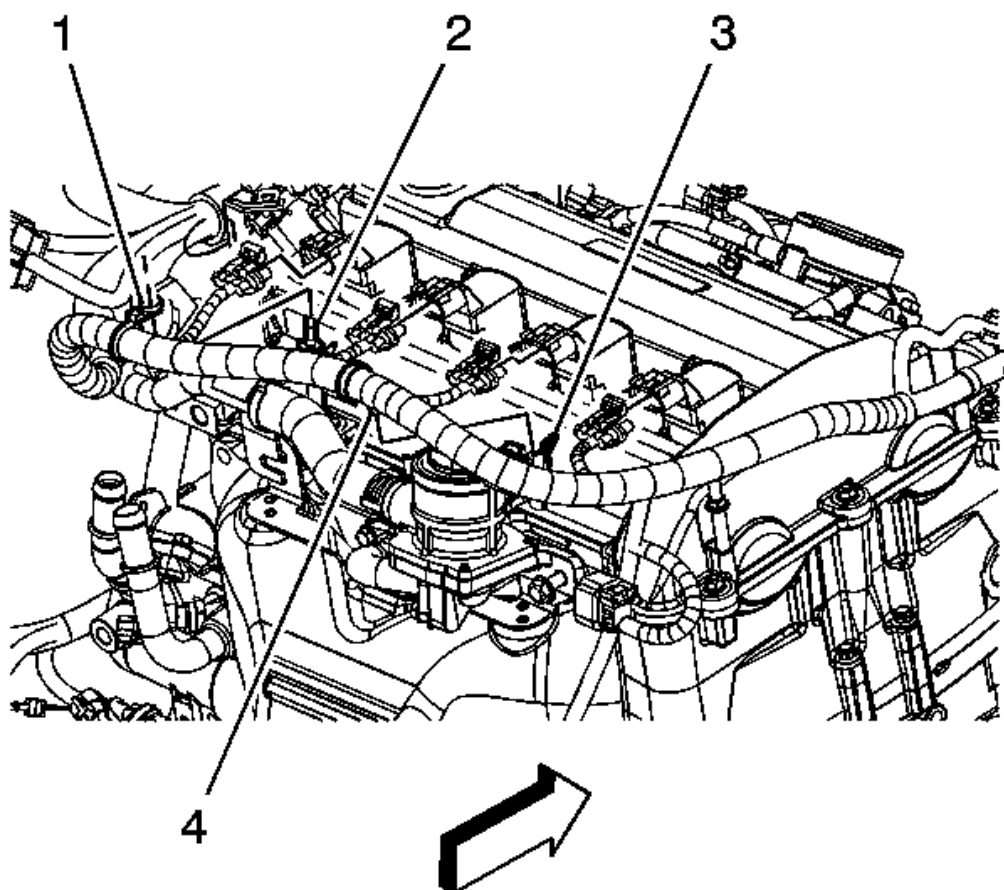


Fig. 128: View Of Engine Wiring Harness Clips
Courtesy of GENERAL MOTORS CORP.

3. Install the engine wiring harness clips (1 and 4) to the stud (2) and camshaft cover (3).

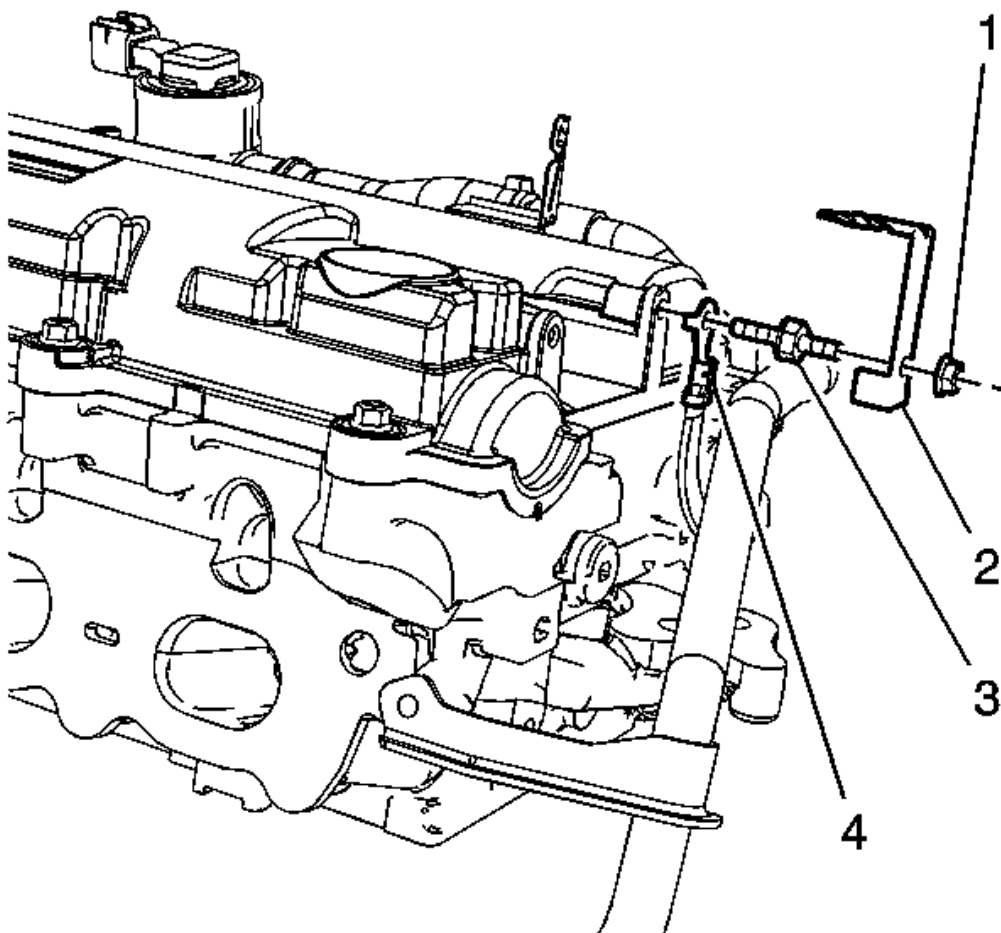


Fig. 129: Locating Fuel Pipe, Bracket & Nut
Courtesy of GENERAL MOTORS CORP.

4. Install the ground strap (4) to the camshaft cover.
5. Install the ground strap stud (3) to the camshaft cover.

Tighten: Tighten the stud to 10 N.m (89 lb in).

6. Install the fuel pipe bracket (2) to the ground strap stud.
7. Install the fuel pipe bracket nut (1).

Tighten: Tighten the nut to 10 N.m (89 lb in).

8. Install the ignition coils. Refer to **Ignition Coil Replacement** .

9. Install the air cleaner outlet resonator. Refer to [Air Cleaner Outlet Resonator Replacement](#).
10. Install the intake manifold cover. Refer to [Intake Manifold Cover Replacement](#).

TIMING CHAIN TENSIONER REPLACEMENT

Tools Required

J 45027 Tensioner Tool

Removal Procedure

1. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
2. Remove the camshaft cover. Refer to [Camshaft Cover Replacement](#).

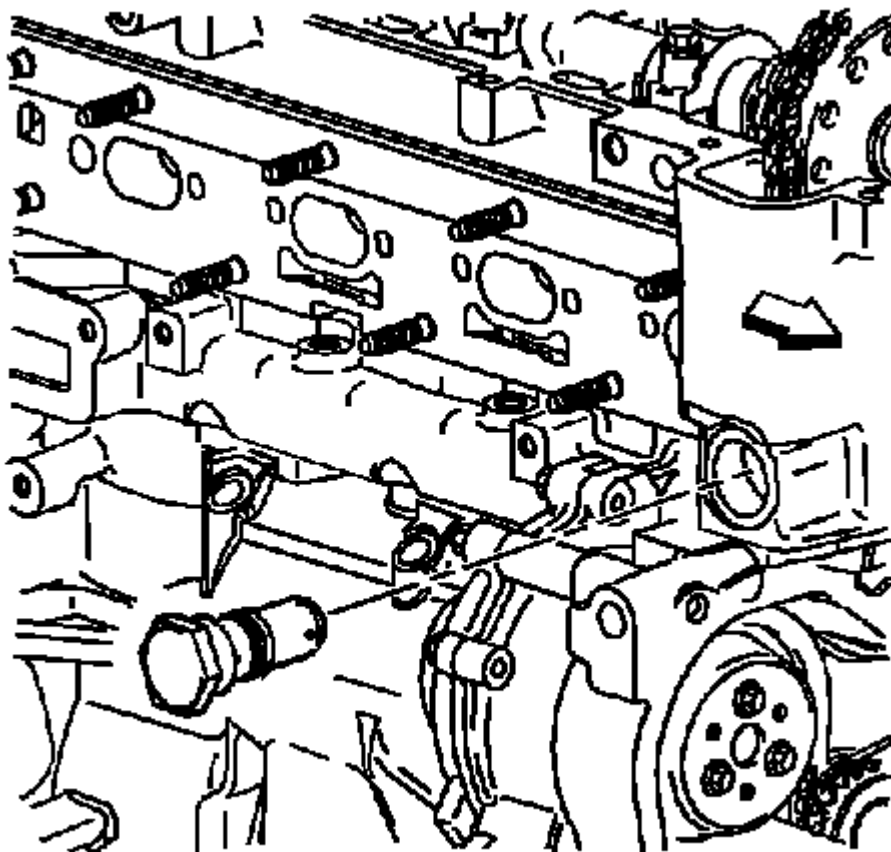


Fig. 130: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

3. Remove the timing chain tensioner.
4. Remove the seal from the tensioner.

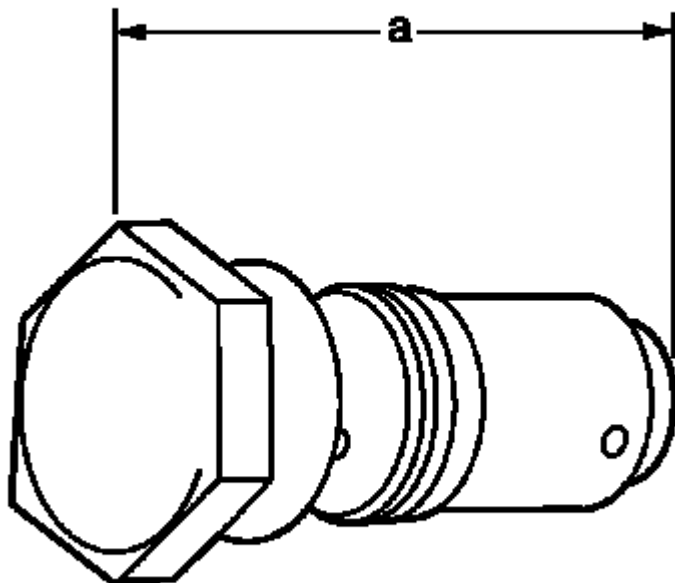
Installation Procedure

Fig. 131: Measuring Timing Chain Tensioner Assembly
Courtesy of GENERAL MOTORS CORP.

1. Inspect the timing chain tensioner. If the timing chain tensioner, O-ring seal, or washer is damaged, replace the timing chain tensioner or O-ring seal as applicable.
2. Measure the timing chain tensioner assembly from end to end. If the timing chain tensioner is to be replaced, a new tensioner should be supplied in the fully compressed non-active state. A tensioner in the compressed state will measure 72 mm (2.83 in) (a) from end to end. A tensioner in the active state will measure 85 mm (3.35 in) (a) from end to end.

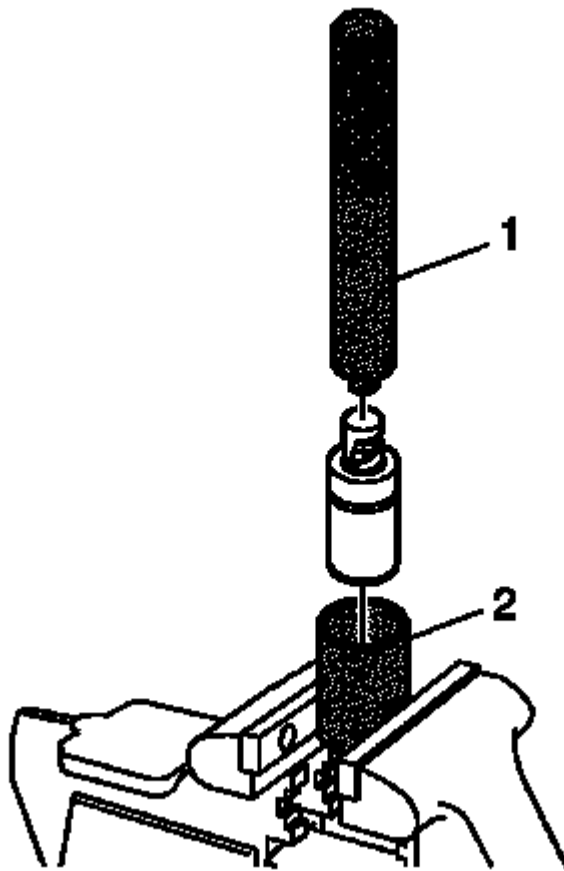


Fig. 132: Compressing Timing Chain Tensioner
 Courtesy of GENERAL MOTORS CORP.

3. If the timing chain tensioner is not in the compressed state, perform the following steps:
 1. Remove the piston assembly from the body of the timing chain tensioner by pulling it out.
 2. Install the J 45027-2 (2) into a vise.
 3. Install the notch end of the piston assembly into the J 45027-2 (2).
 4. Using the J 45027-1 (1), turn the ratchet cylinder into the piston.

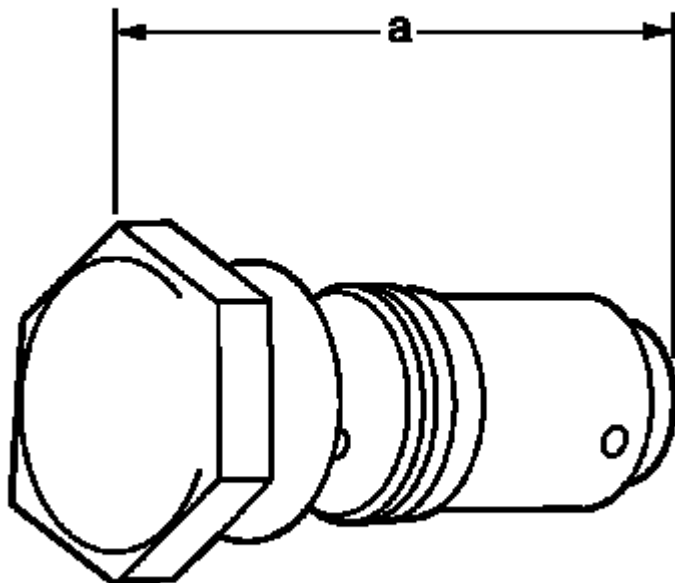


Fig. 133: Measuring Timing Chain Tensioner Assembly
Courtesy of GENERAL MOTORS CORP.

4. Inspect the bore of the tensioner body for dirt, debris, and damage. If any damage appears, replace the tensioner. Clean dirt or debris out with a lint-free cloth.
5. Install the compressed piston assembly back into the timing chain tensioner body until it stops at the bottom of the bore. Do not compress the piston assembly against the bottom of the bore. If the piston assembly is compressed against the bottom of the bore, it will activate the tensioner, which will then need to be reset again.
6. At this point the tensioner should measure approximately 72 mm (2.83 in) (a) from end to end. If the tensioner does not read 72 mm (2.83 in) (a) from end to end, repeat steps 3-5.

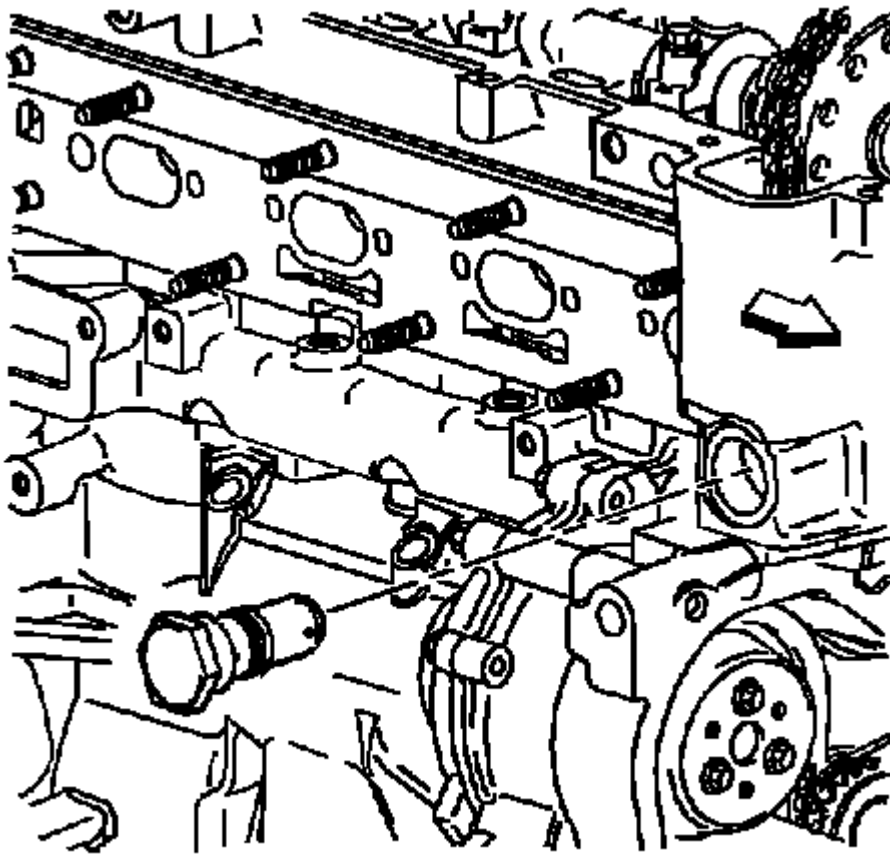


Fig. 134: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

7. Inspect to ensure all dirt and debris is removed from the timing chain tensioner threaded hole in the cylinder head.

NOTE: Refer to Fastener Notice .

IMPORTANT: Ensure the timing chain tensioner seal is centered throughout the torque procedure to eliminate the possibility of an oil leak.

8. Install the timing chain tensioner assembly.

Tighten: Tighten the timing chain tensioner to 75 N.m (55 lb ft).

9. The timing chain tensioner is released by compressing the tensioner 2 mm (0.079 in) which will release the locking mechanism in the ratchet. To release the timing chain tensioner, use a suitable tool with a rubber tip on the end. Feed the tool down through the cam drive chest to rest on the cam chain. Then give a sharp jolt diagonally downwards to release the tensioner.
10. Install the camshaft cover. Refer to Camshaft Cover Replacement.
11. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection .

INTAKE CAMSHAFT AND VALVE LIFTER REPLACEMENT**Tools Required**

J 43655 Sprocket Holding Tool. See **Special Tools**.

Removal Procedure

1. Remove the camshaft cover. Refer to **Camshaft Cover Replacement**.

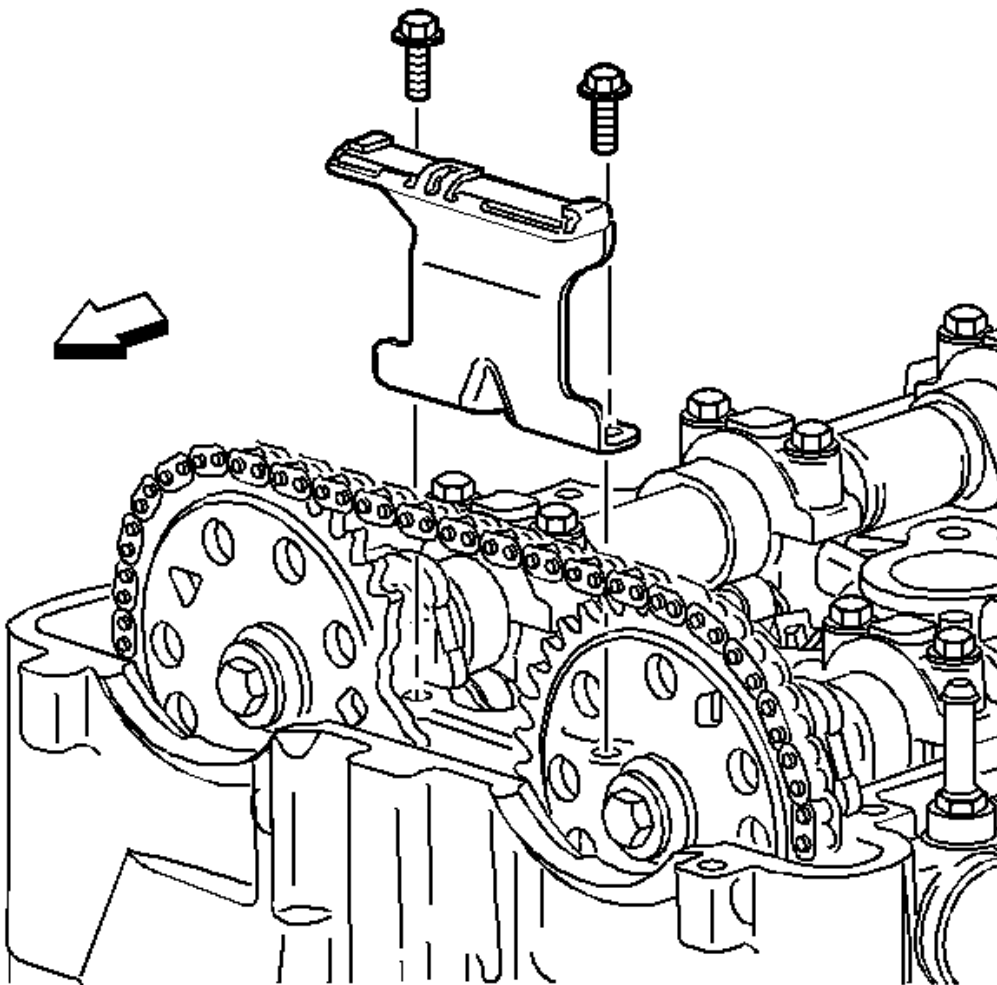


Fig. 135: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

2. Remove the upper timing chain guide.

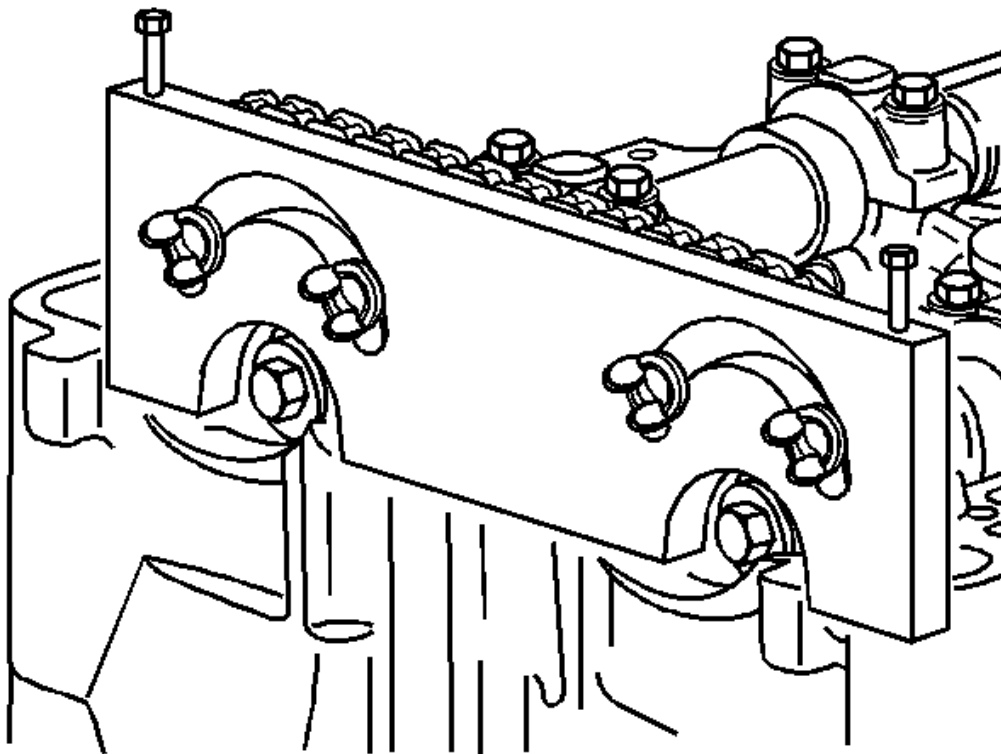


Fig. 136: View Of Camshaft Sprocket Holding Tool
Courtesy of GENERAL MOTORS CORP.

3. Install the J 43655 . See Special Tools.

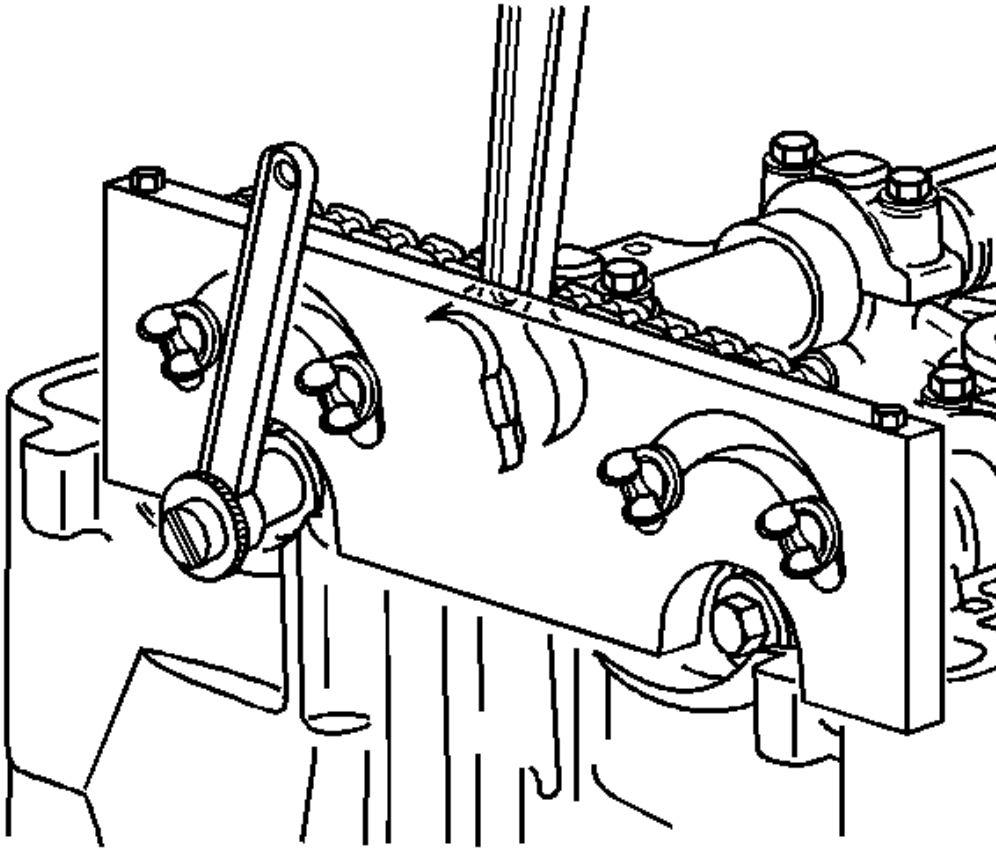


Fig. 137: Removing/Installing Camshaft Timing Sprocket Retaining Bolts & Washers
Courtesy of GENERAL MOTORS CORP.

4. Remove both the intake and exhaust camshaft sprocket bolts and discard.
5. Slide the camshaft sprockets forward.

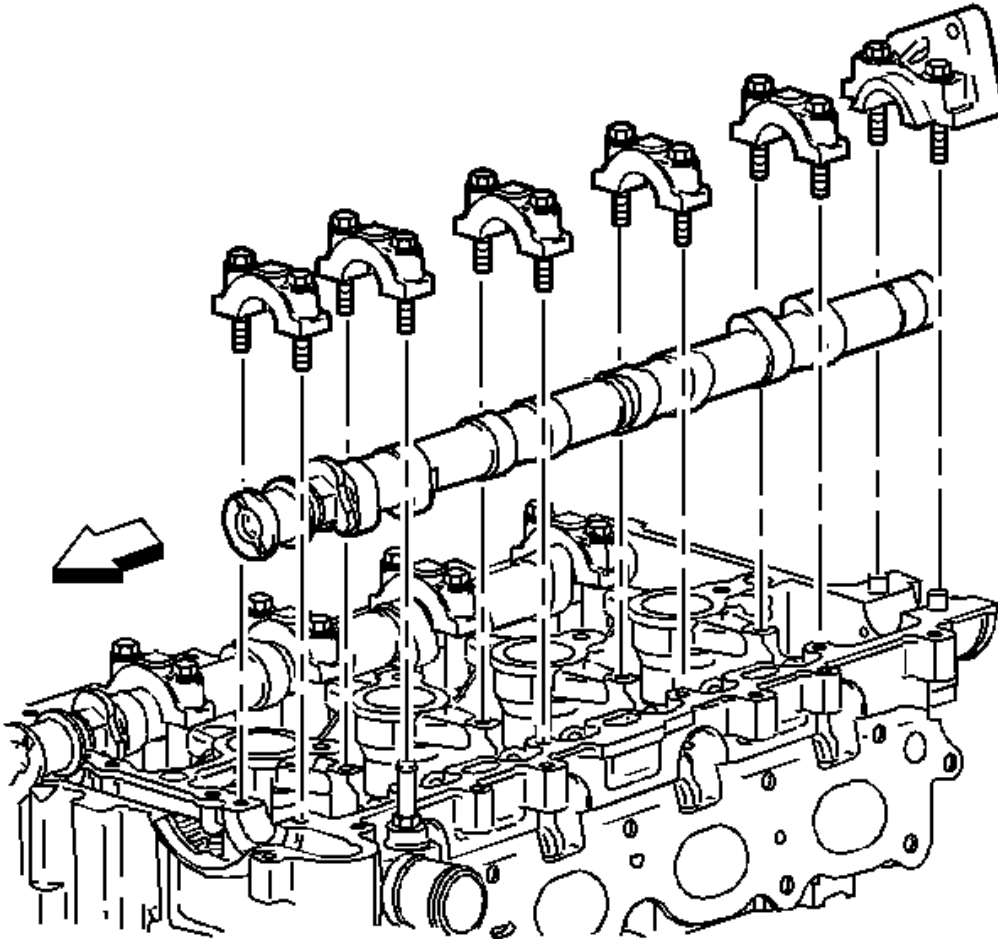


Fig. 138: View Of Intake Camshaft And Caps
Courtesy of GENERAL MOTORS CORP.

6. Mark the caps to ensure they are installed in the original position.

IMPORTANT: Remove each bolt on each cap one turn at a time until there is no spring tension on the camshaft.

7. Remove the caps.
8. Remove the intake camshaft.

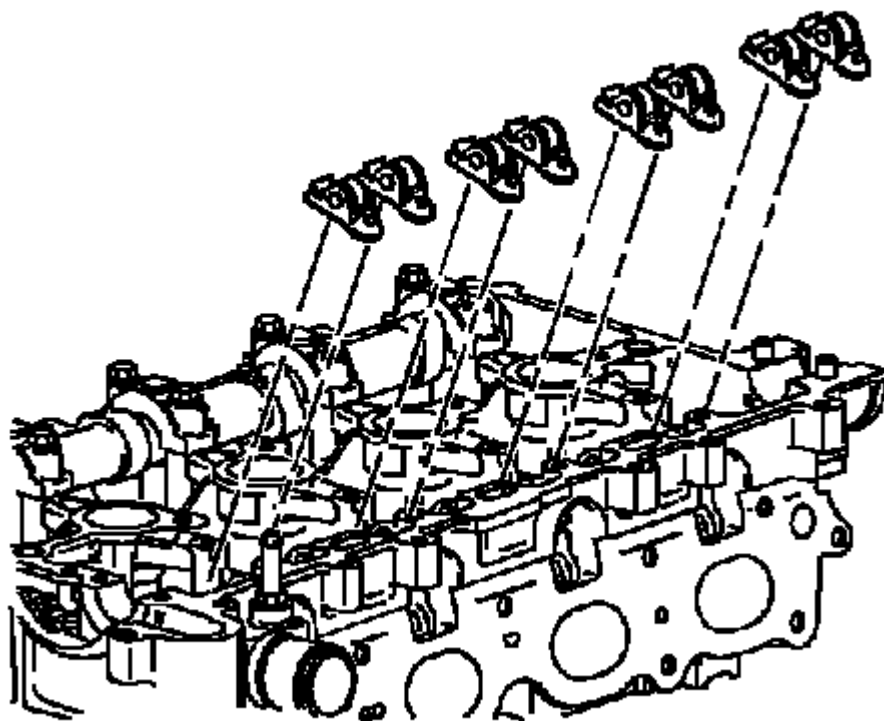


Fig. 139: View Of Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

9. Remove the camshaft roller followers.

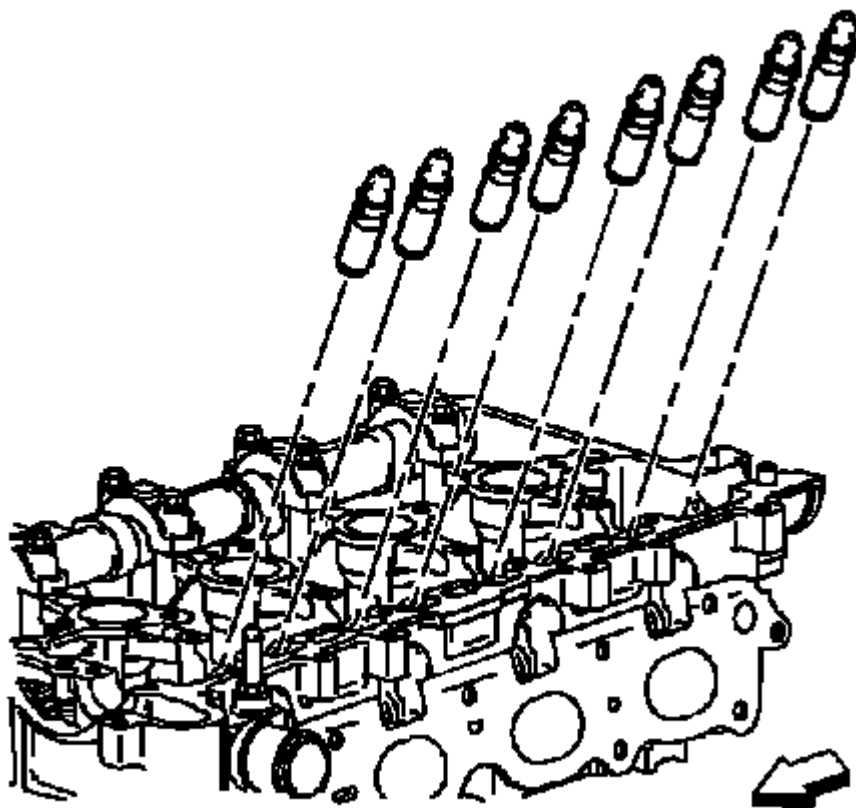


Fig. 140: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

10. Remove the hydraulic lash adjusters.

Installation Procedure

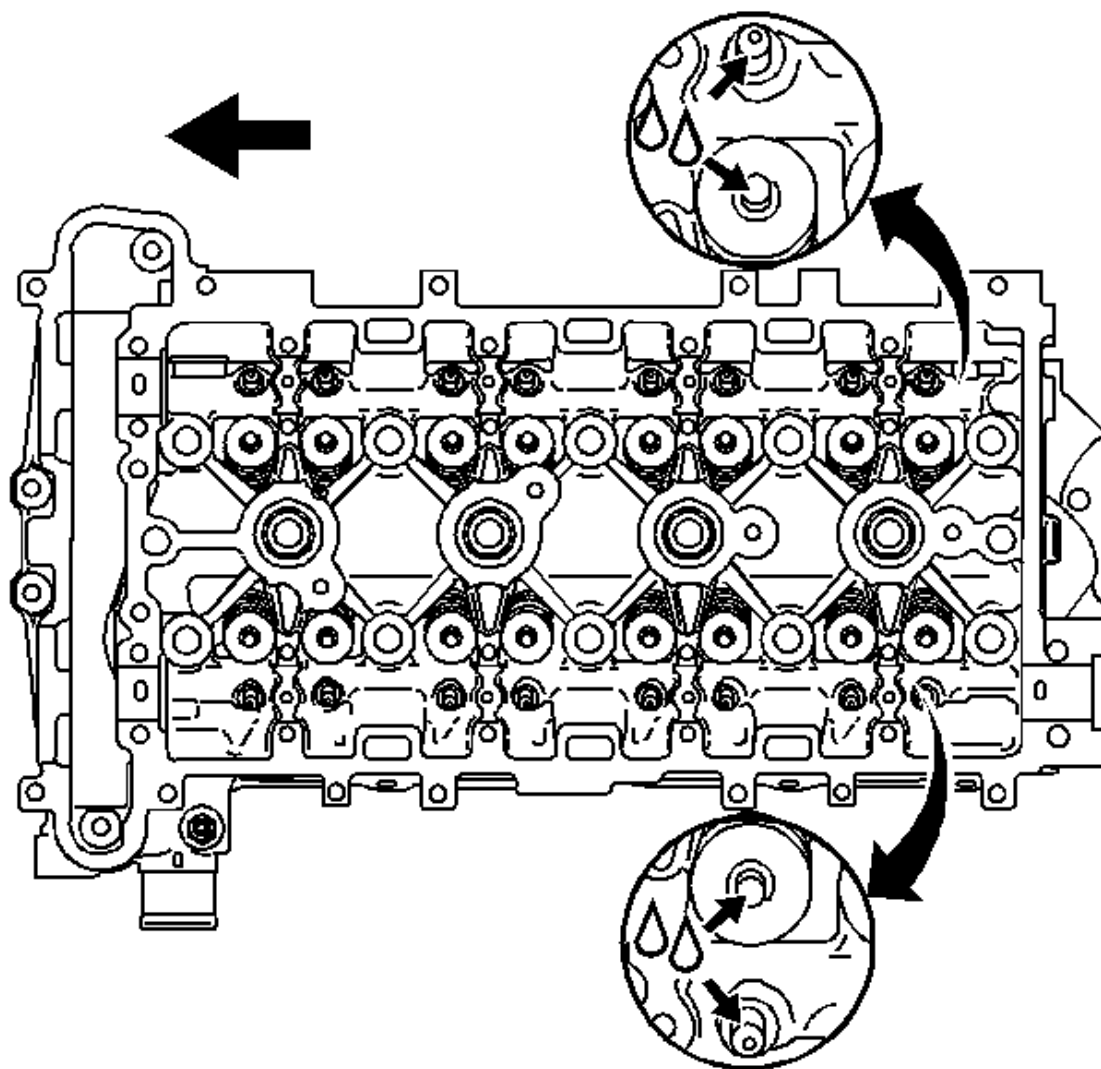


Fig. 141: Lubricating Valve Tips
Courtesy of GENERAL MOTORS CORP.

1. Lubricate the valve tips.

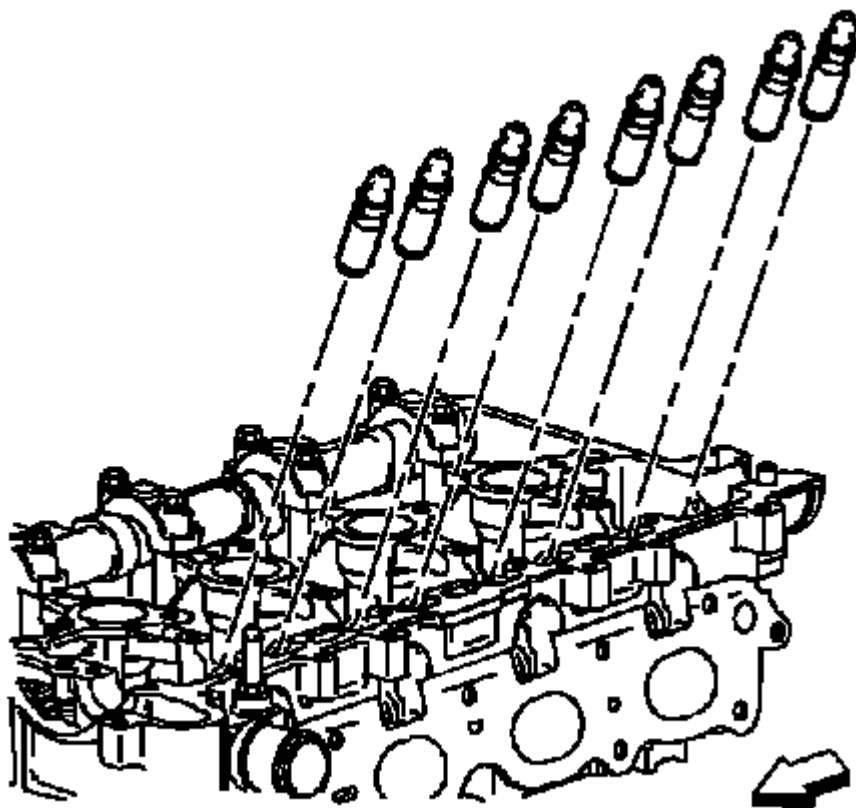


Fig. 142: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

2. Install the hydraulic lash adjusters.

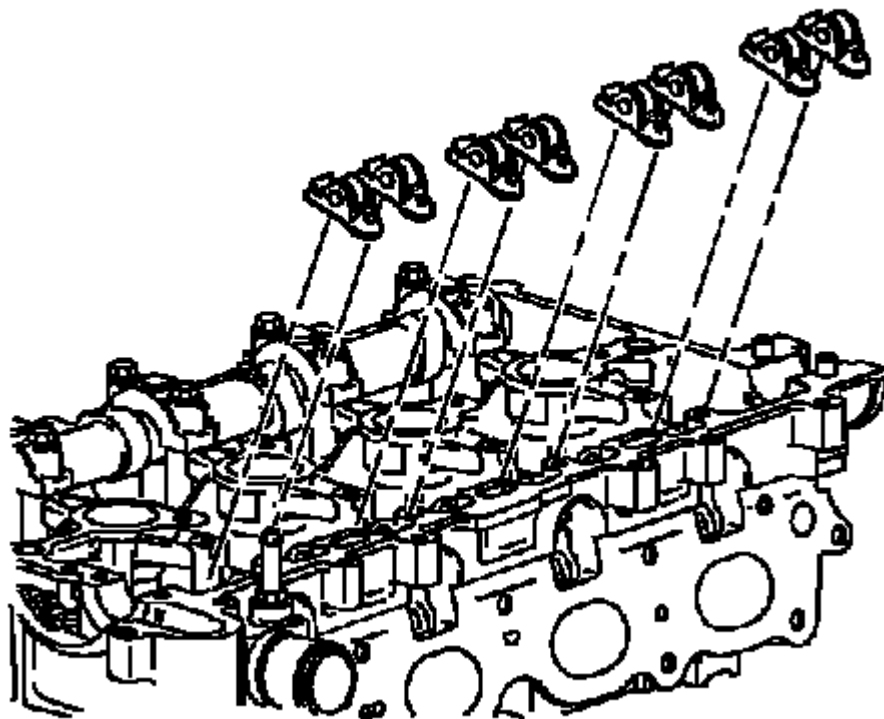


Fig. 143: View Of Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

3. Install the camshaft roller followers.

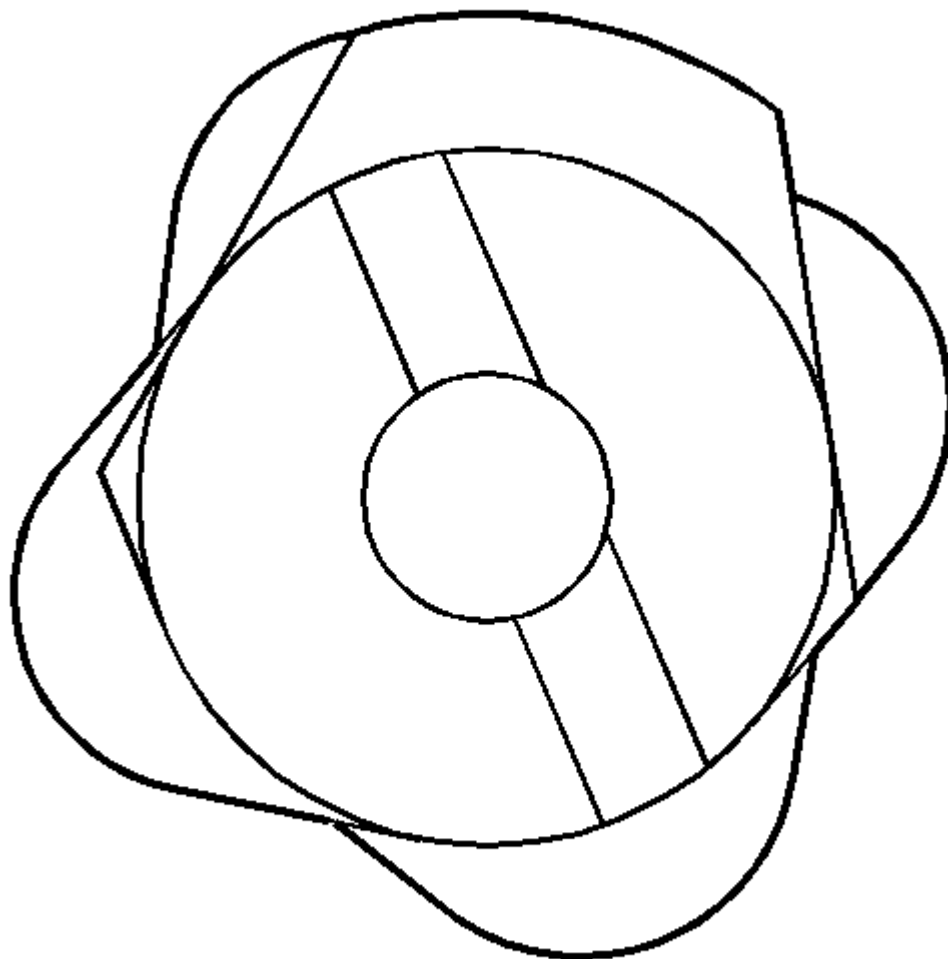


Fig. 144: View Of Camshaft Alignment Notches
Courtesy of GENERAL MOTORS CORP.

4. Ensure that the alignment notches are aligned with the camshaft sprocket.

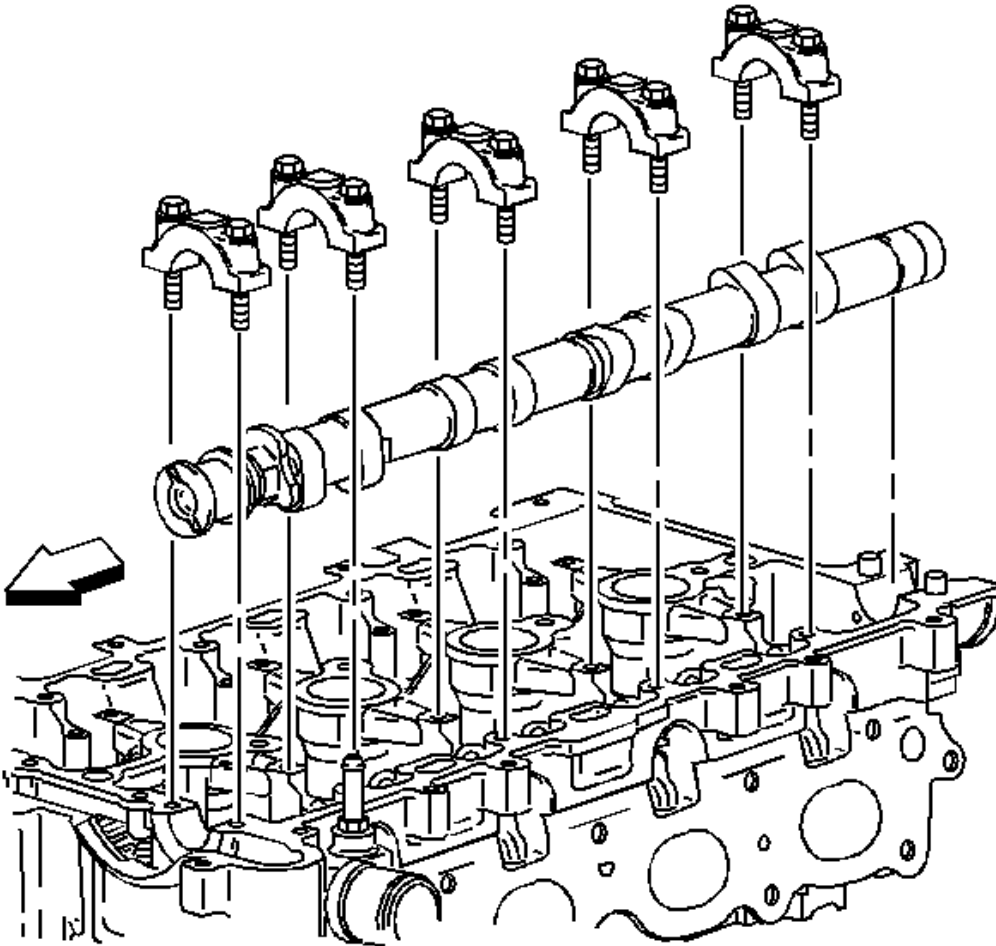


Fig. 145: View Of Camshaft Bearing Caps
Courtesy of GENERAL MOTORS CORP.

5. Install the intake camshaft.
6. Install the camshaft caps.

NOTE: Refer to Fastener Notice .

7. Tighten the camshaft cap bolts in increments of 3 turns until they are seated.

Tighten: Tighten the camshaft cap bolts to 10 N.m (89 lb in).

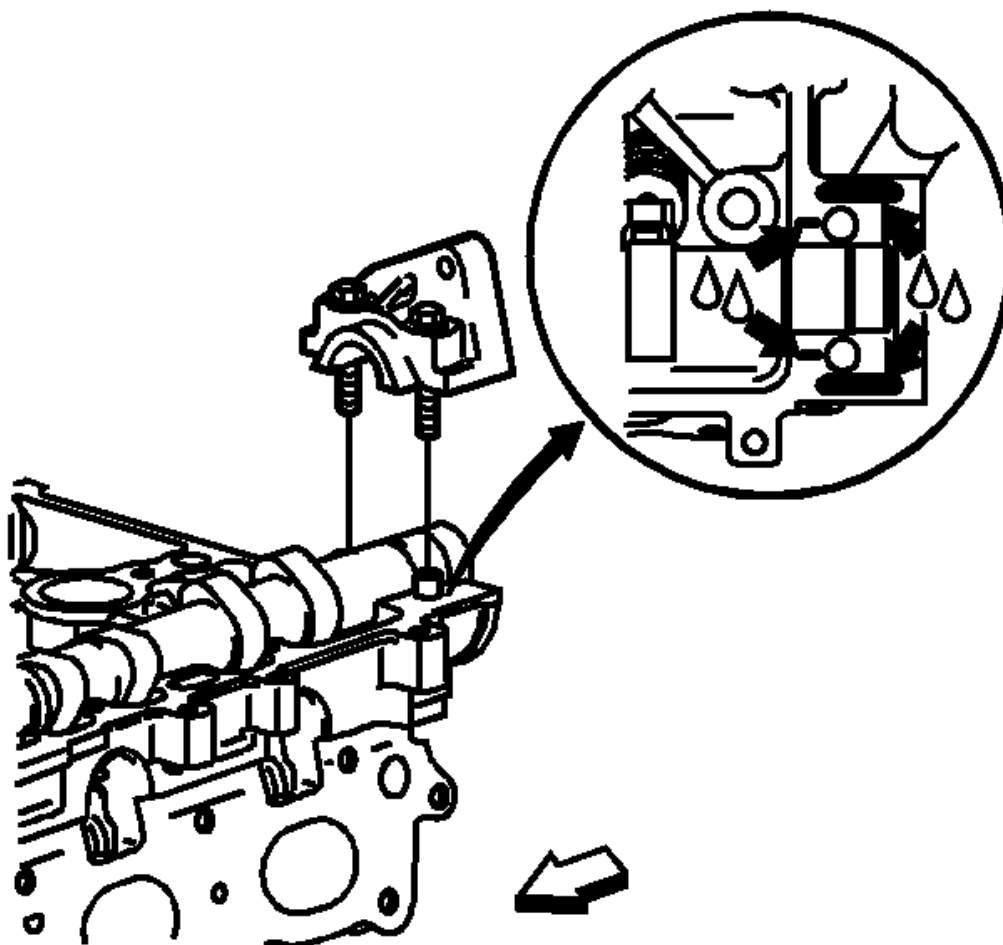


Fig. 146: Applying Camshaft Bearing Cap Sealer To Rear Cap
Courtesy of GENERAL MOTORS CORP.

8. Apply a 3.5 mm (0.138 in) bead of sealant to the rear intake camshaft cap. Refer to **Adhesives, Fluids, Lubricants, and Sealers** for the correct part number.
9. Install the rear intake camshaft cap bolts.

Tighten: Tighten the bolts to 25 N.m (18 lb ft).

10. Install camshaft sprockets onto the camshafts.
11. Hand tighten NEW camshaft sprocket bolts.
12. Remove the **J 43655** . See **Special Tools**.

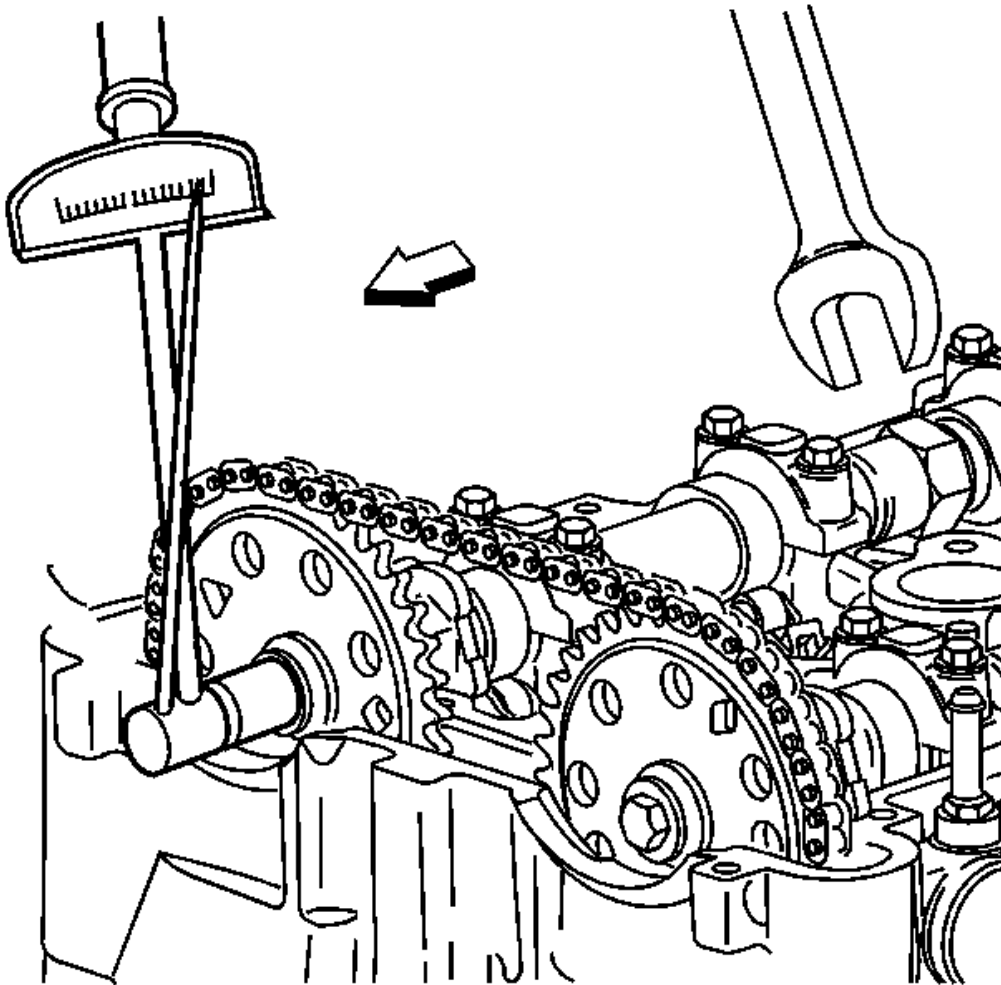


Fig. 147: Holding Camshaft Stationary With Wrench On Hex Casting On Camshaft
Courtesy of GENERAL MOTORS CORP.

13. Tighten the camshaft sprocket bolts.

Tighten: Tighten the bolts to 85 N.m (63 lb ft) plus 30 degrees.

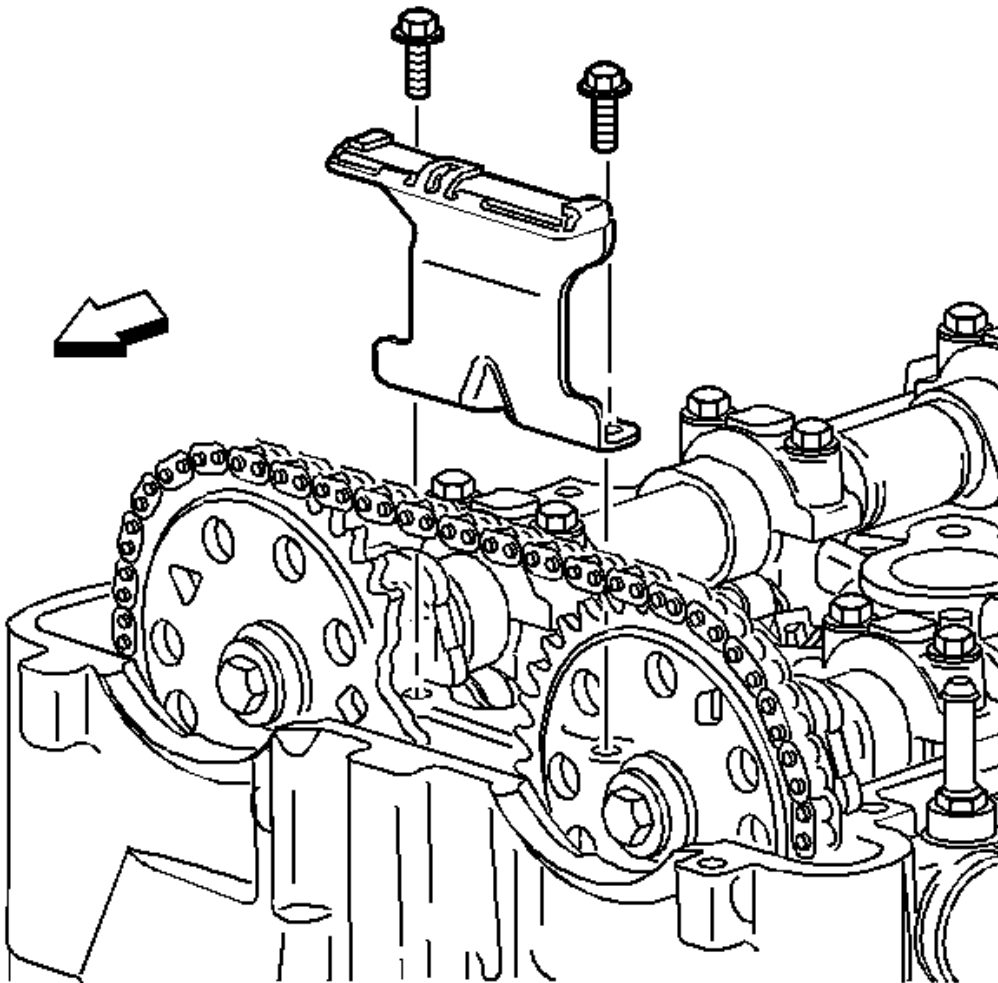


Fig. 148: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

14. Install the upper timing chain guide.

Tighten: Tighten the upper timing chain guide to 10 N.m (89 lb in).

15. Install the camshaft cover. Refer to **Camshaft Cover Replacement**.

EXHAUST CAMSHAFT AND VALVE LIFTER REPLACEMENT

Tools Required

J 43655 Sprocket Holding Tool. See **Special Tools**.

Removal Procedure

1. Remove the camshaft cover. Refer to **Camshaft Cover Replacement**.

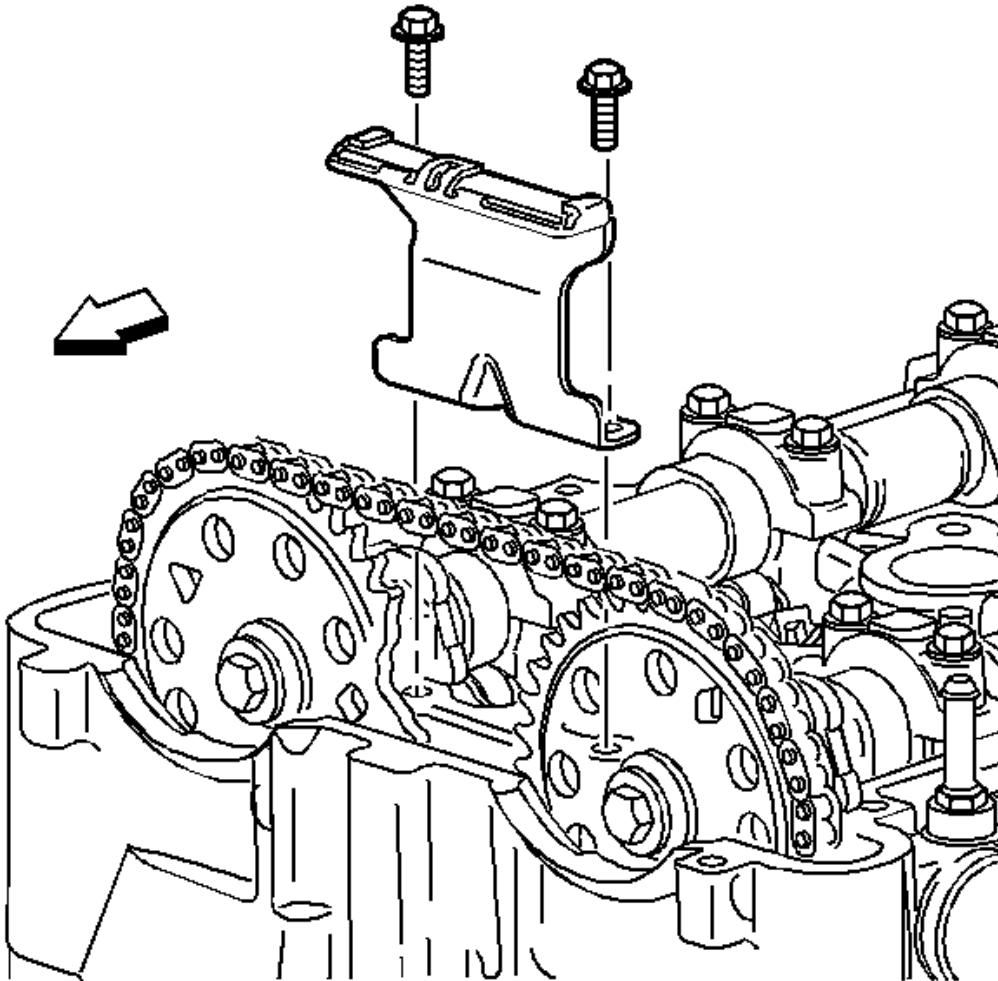


Fig. 149: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

2. Remove the upper timing chain guide.

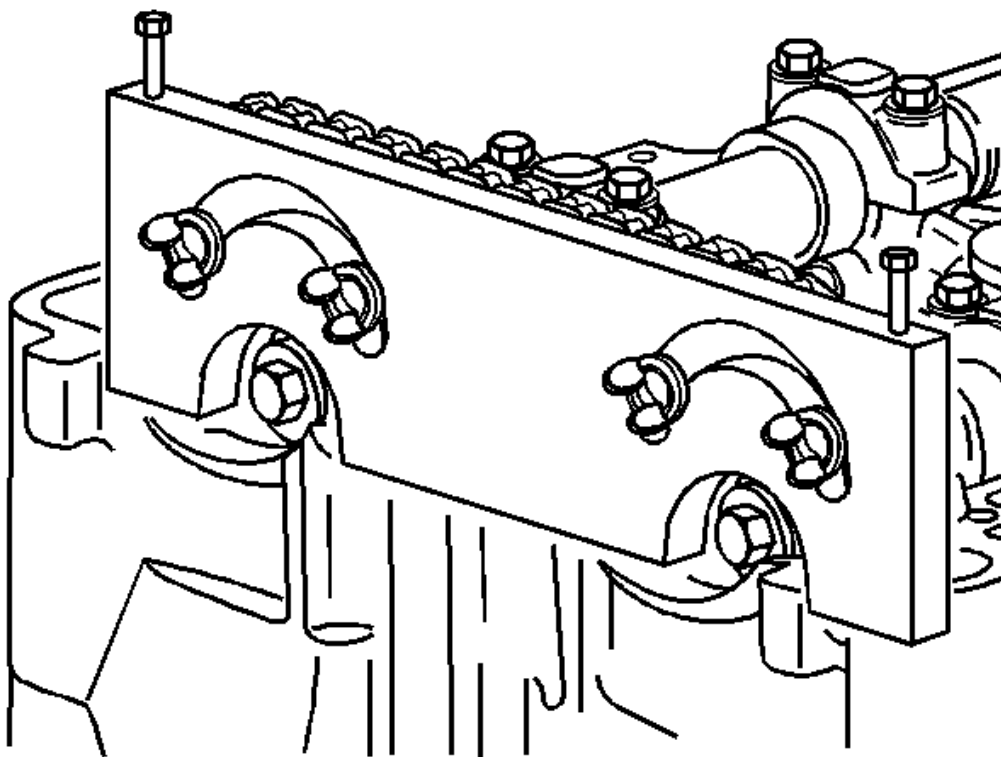


Fig. 150: View Of Camshaft Sprocket Holding Tool
Courtesy of GENERAL MOTORS CORP.

3. Install the **J 43655** . See **Special Tools**.

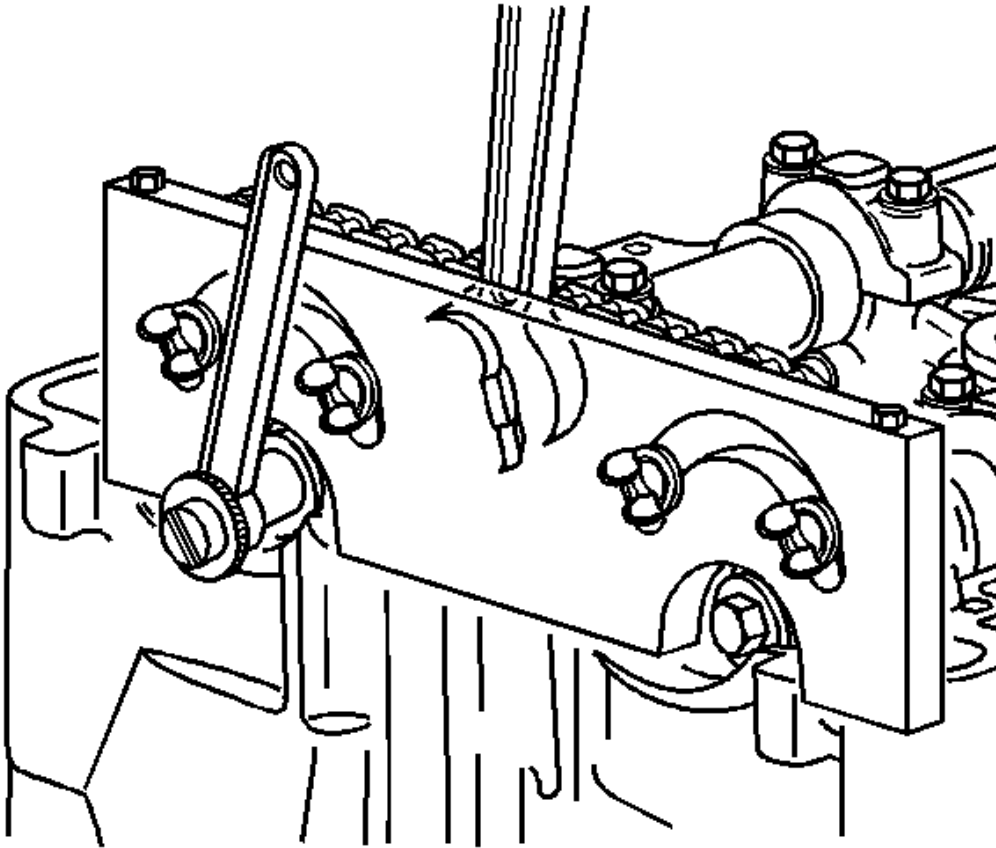


Fig. 151: Removing/Installing Camshaft Timing Sprocket Retaining Bolts & Washers
Courtesy of GENERAL MOTORS CORP.

4. Remove both the intake and the exhaust camshaft sprocket bolts and discard.
5. Slide the camshaft sprockets forward.

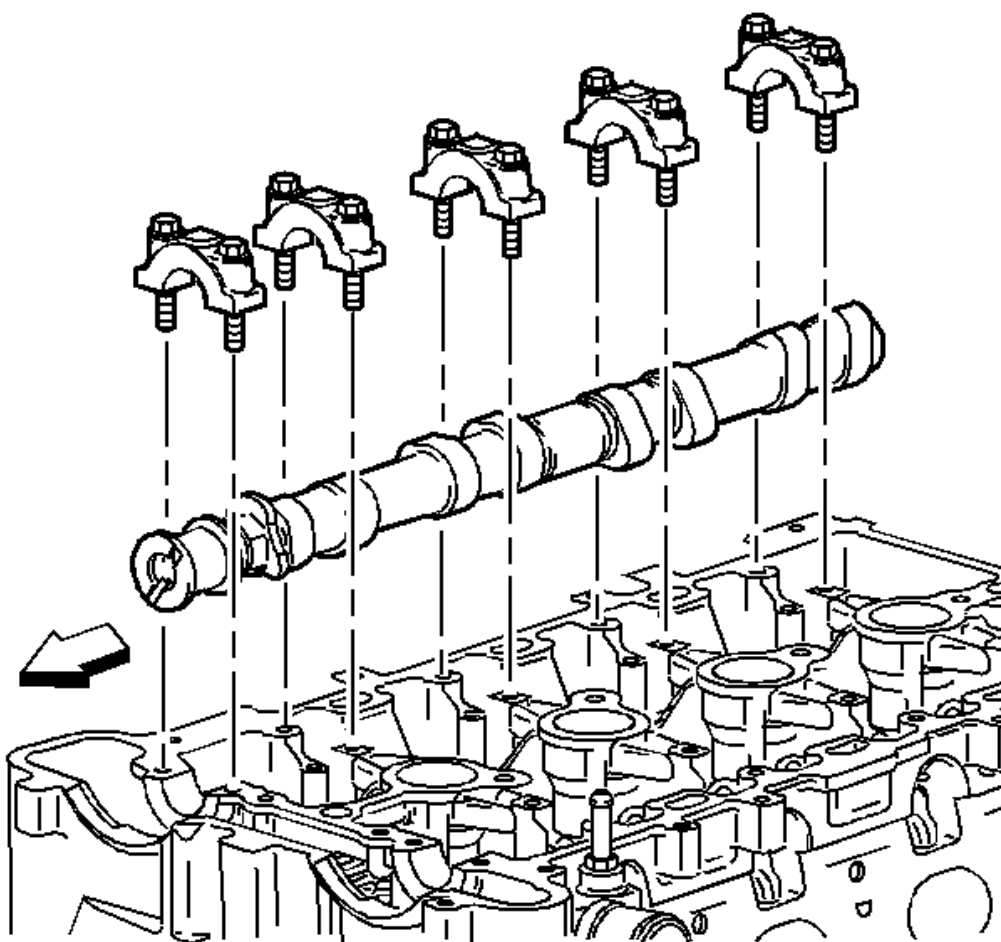


Fig. 152: View Of Camshaft & Bearing Caps
Courtesy of GENERAL MOTORS CORP.

6. Mark the caps to ensure that the caps are installed in the original position.

IMPORTANT: Remove each bolt on each cap one turn at a time until there is no spring tension on the camshaft.

7. Remove the caps.
8. Remove the exhaust camshaft.

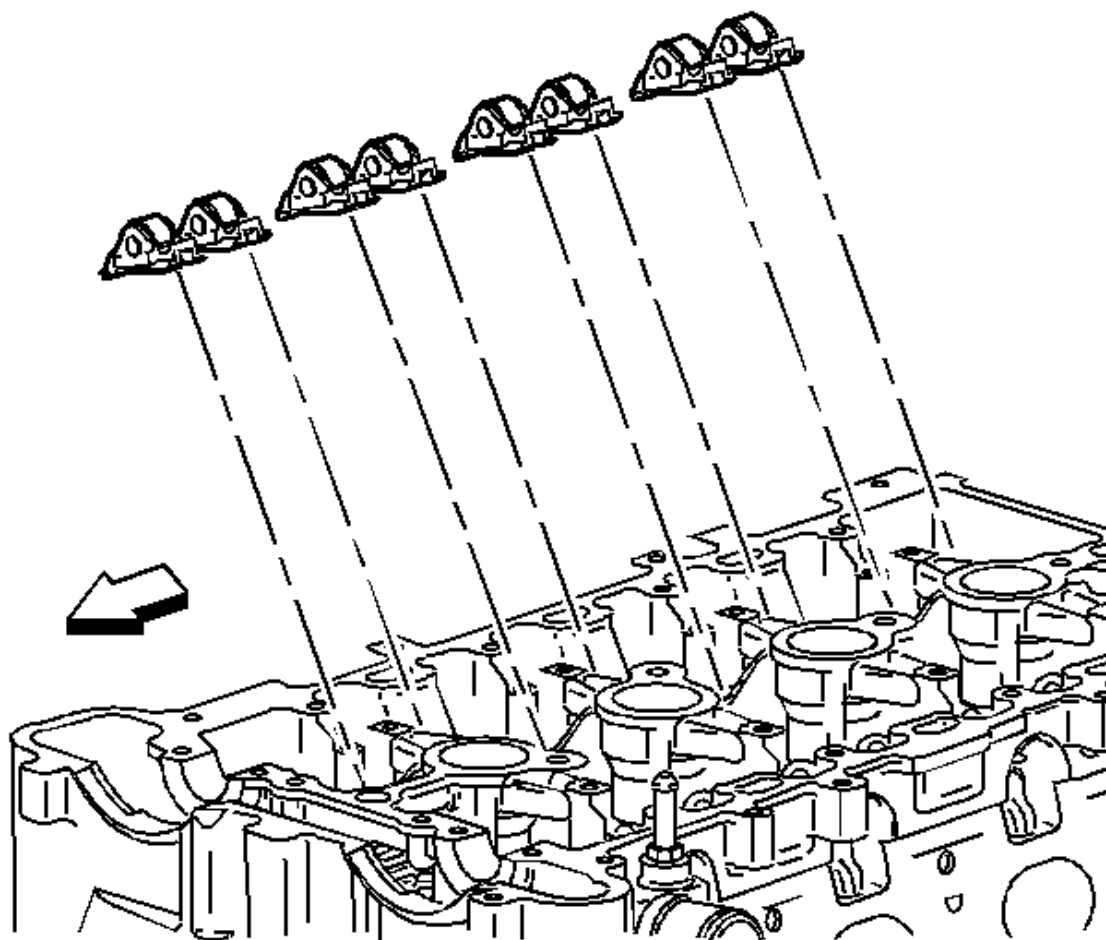


Fig. 153: Identifying Exhaust Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

9. Remove the camshaft roller followers.

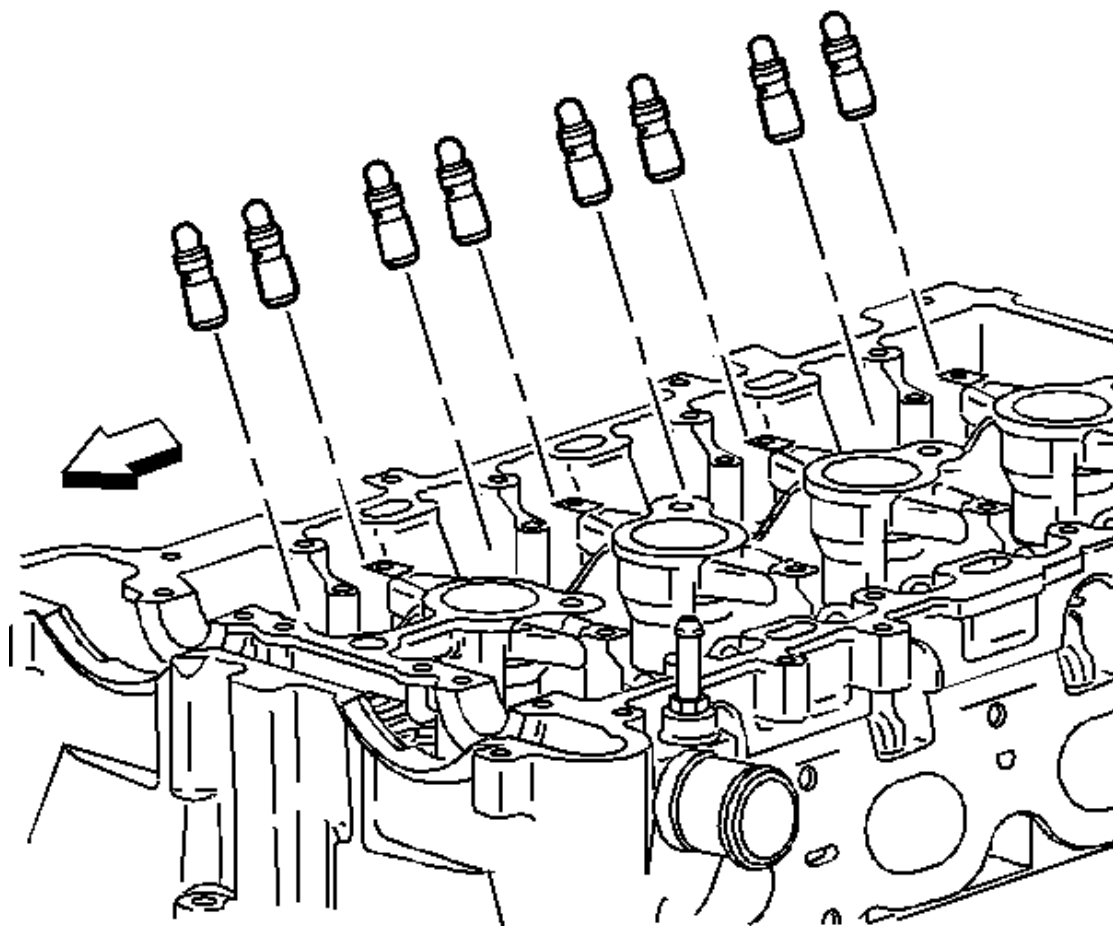


Fig. 154: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

10. Remove the hydraulic lash adjusters.

Installation Procedure

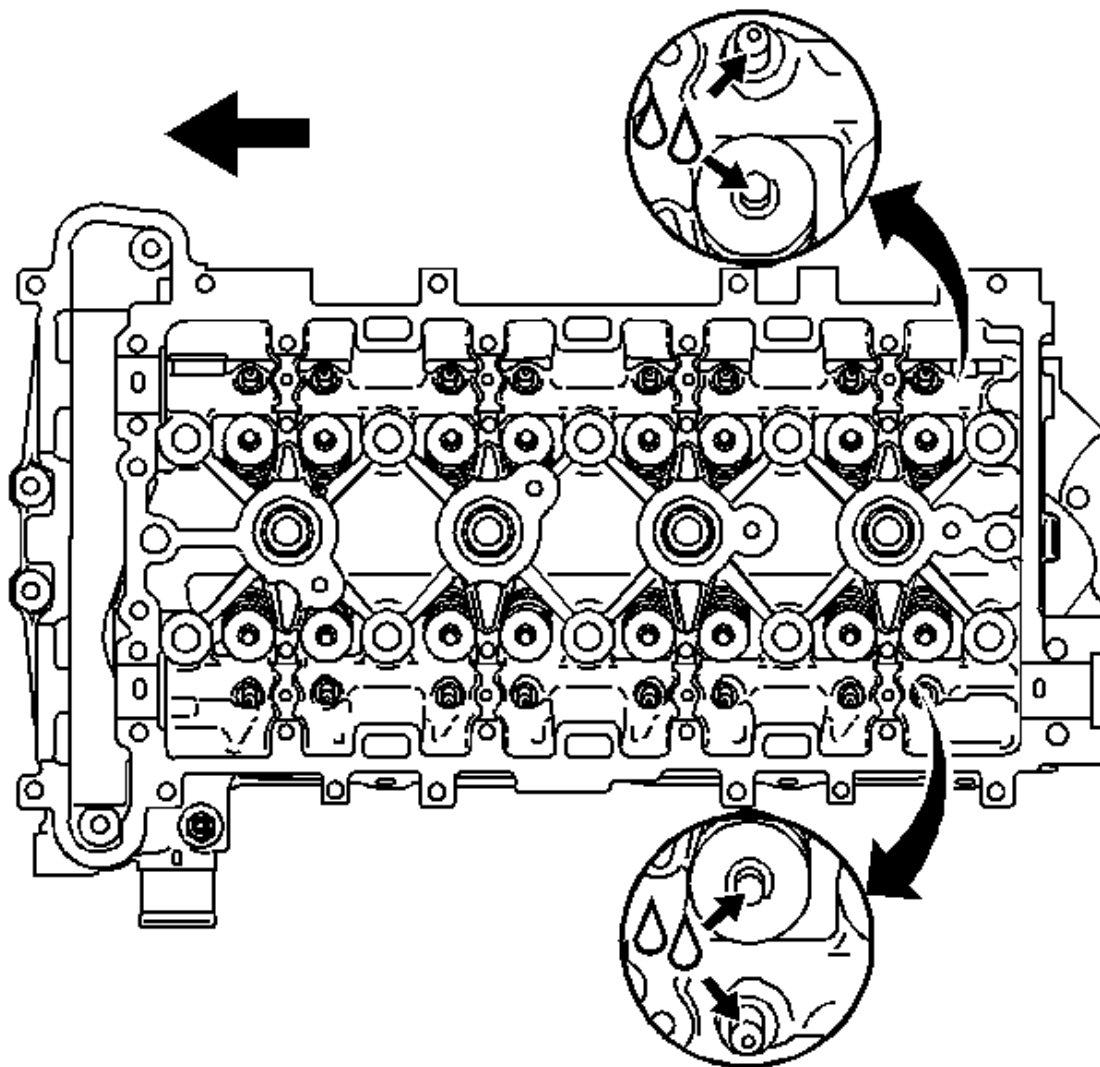


Fig. 155: Lubricating Valve Tips
Courtesy of GENERAL MOTORS CORP.

1. Lubricate the valve tips.

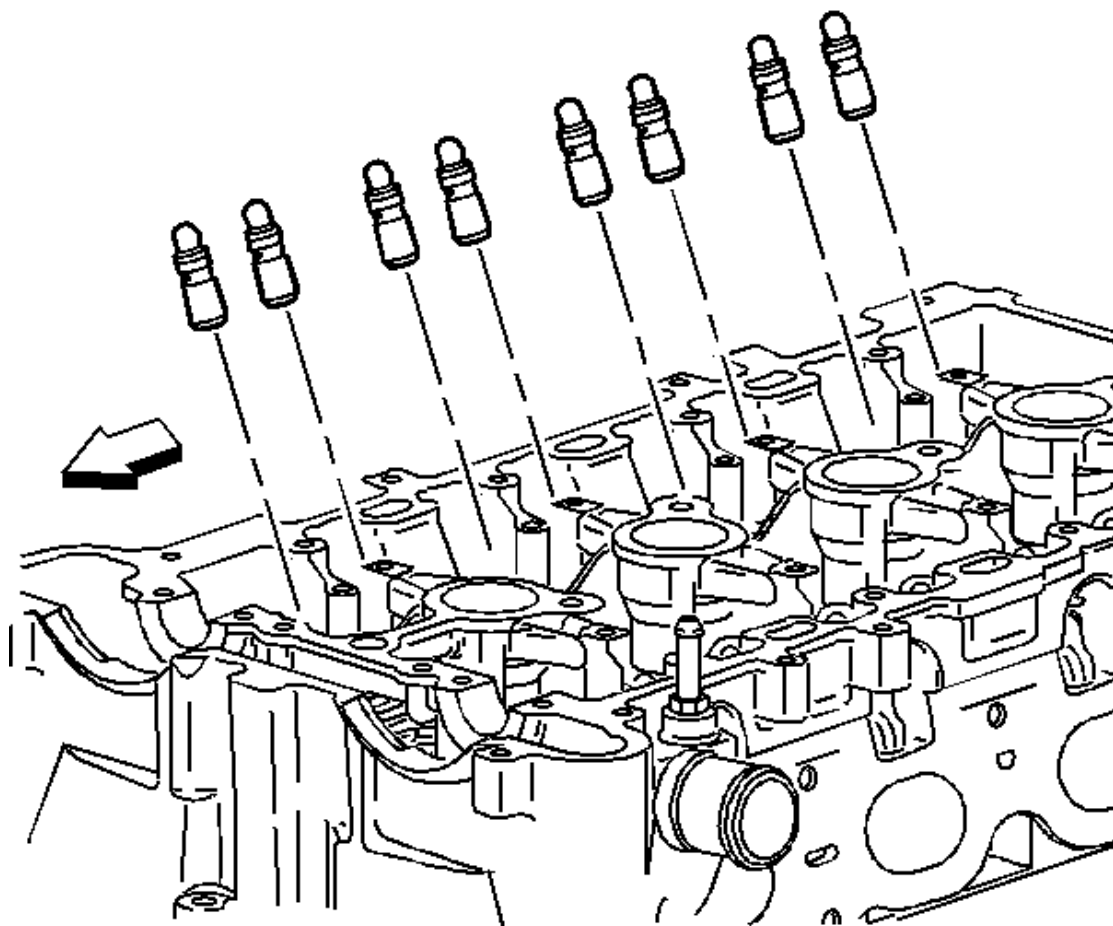


Fig. 156: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

2. Install the hydraulic lash adjusters.

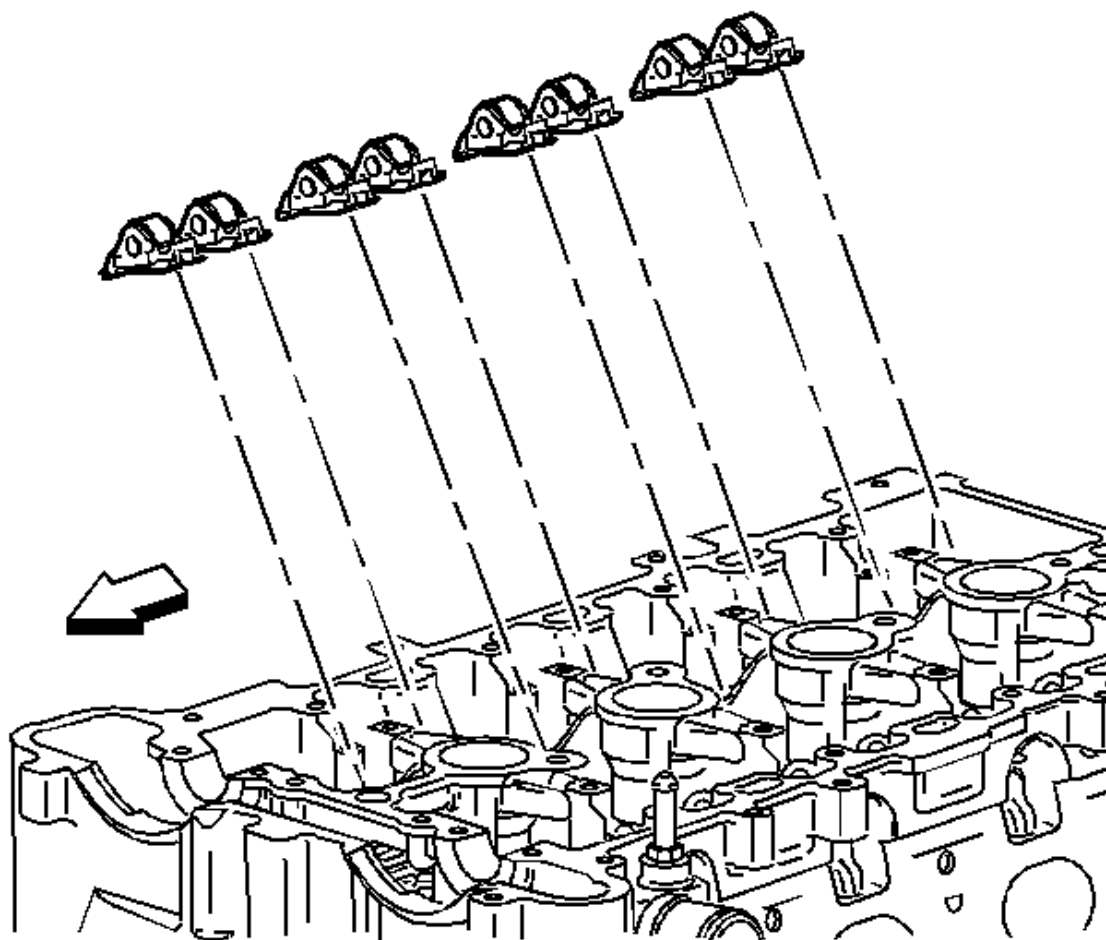


Fig. 157: Identifying Exhaust Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

3. Install the camshaft roller followers.

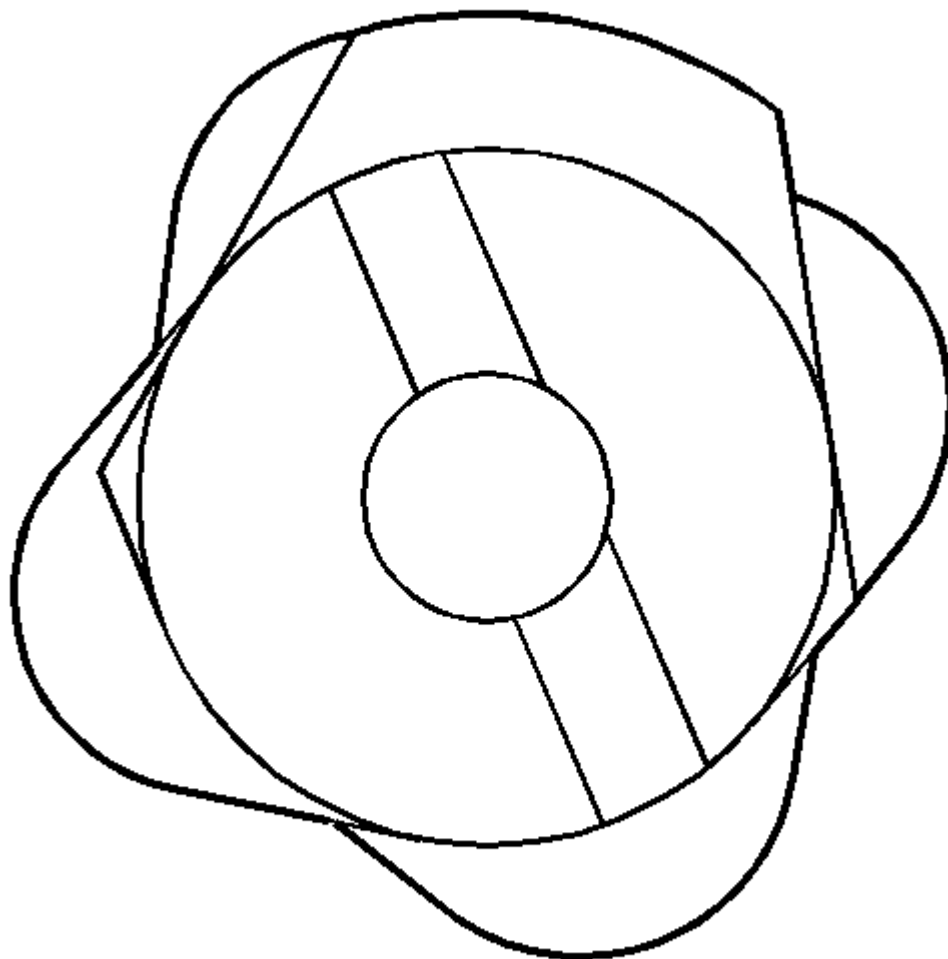


Fig. 158: View Of Camshaft Alignment Notches
Courtesy of GENERAL MOTORS CORP.

4. Ensure that the alignment notches are aligned with the camshaft sprocket.

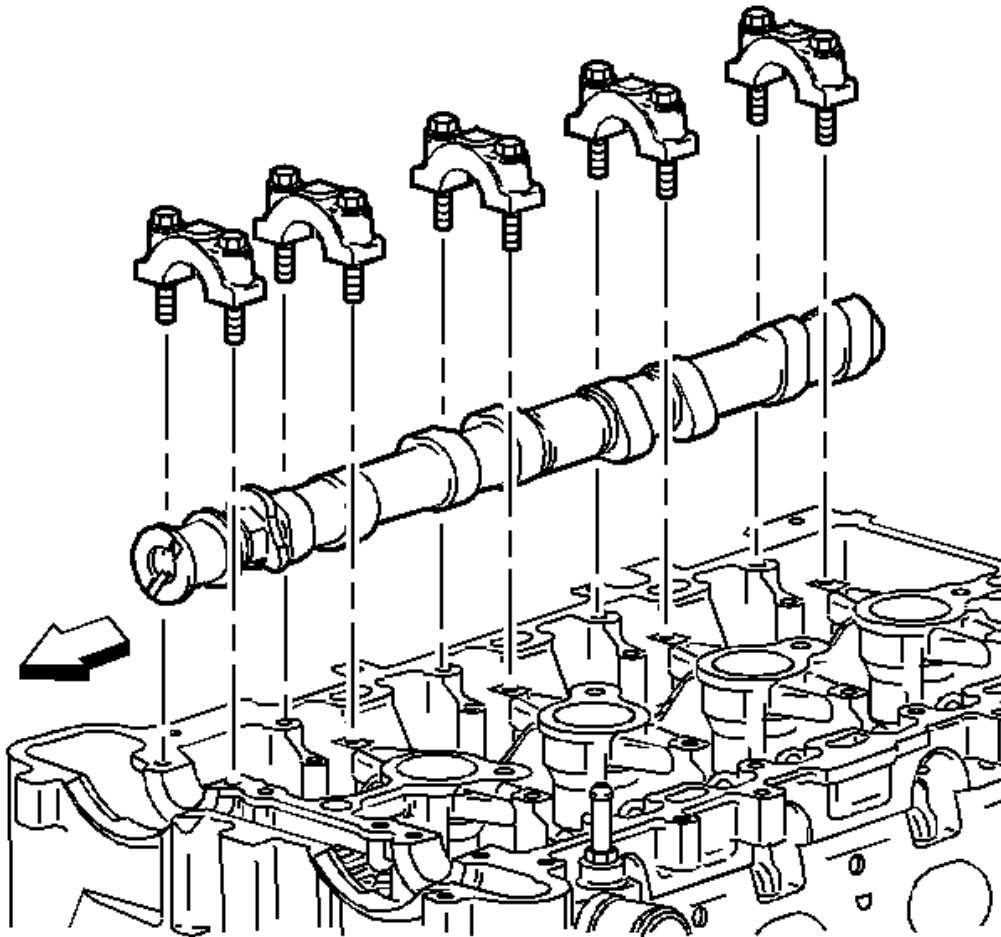


Fig. 159: View Of Camshaft & Bearing Caps
Courtesy of GENERAL MOTORS CORP.

5. Install the exhaust camshaft.
6. Install the camshaft caps.

NOTE: Refer to Fastener Notice.

7. Tighten the camshaft cap bolts in increments of 3 turns until they are seated.

Tighten: Tighten the camshaft cap bolts to 10 N.m (89 lb in).

8. Install camshaft sprockets onto the camshafts.

9. Hand tighten NEW camshaft sprocket bolts.
10. Remove the **J 43655** . See **Special Tools**.

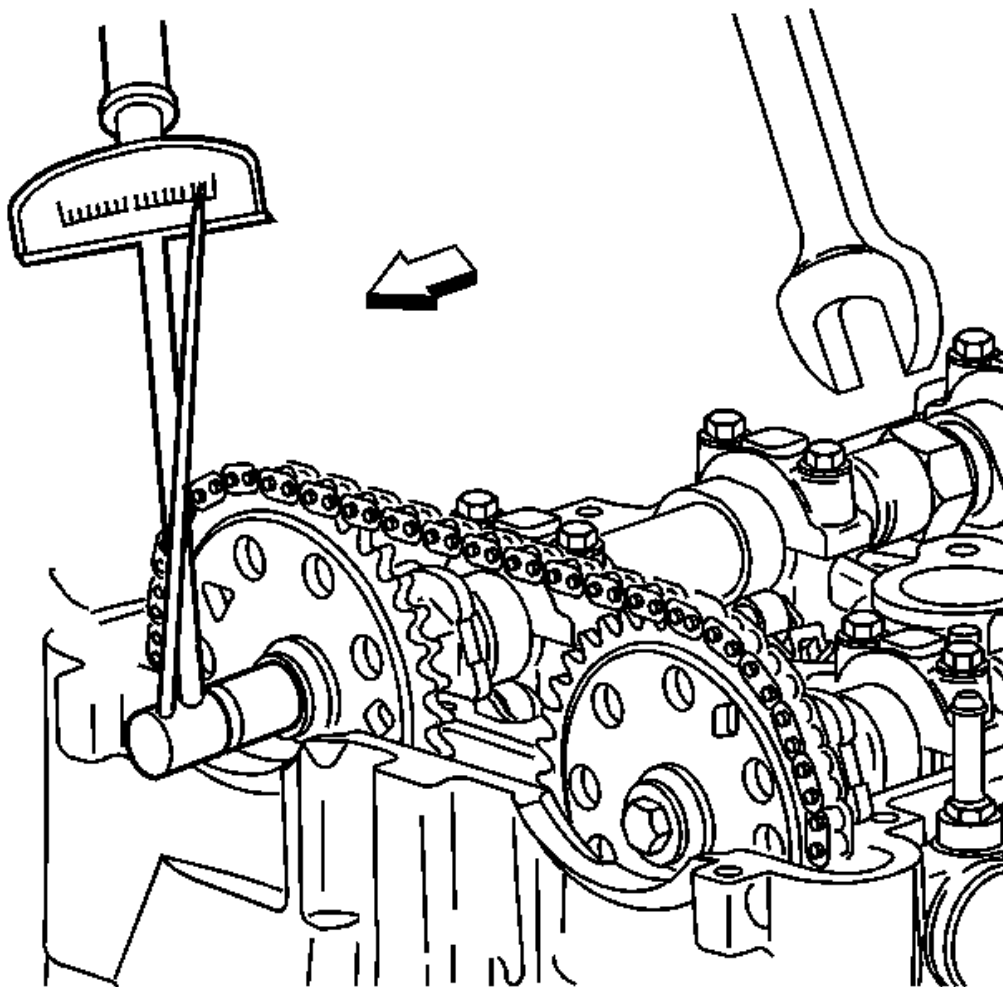


Fig. 160: Holding Camshaft Stationary With Wrench On Hex Casting On Camshaft
Courtesy of GENERAL MOTORS CORP.

11. Tighten the camshaft sprocket bolts.

Tighten: Tighten the bolts to 85 N.m (63 lb ft) plus 30 degrees.

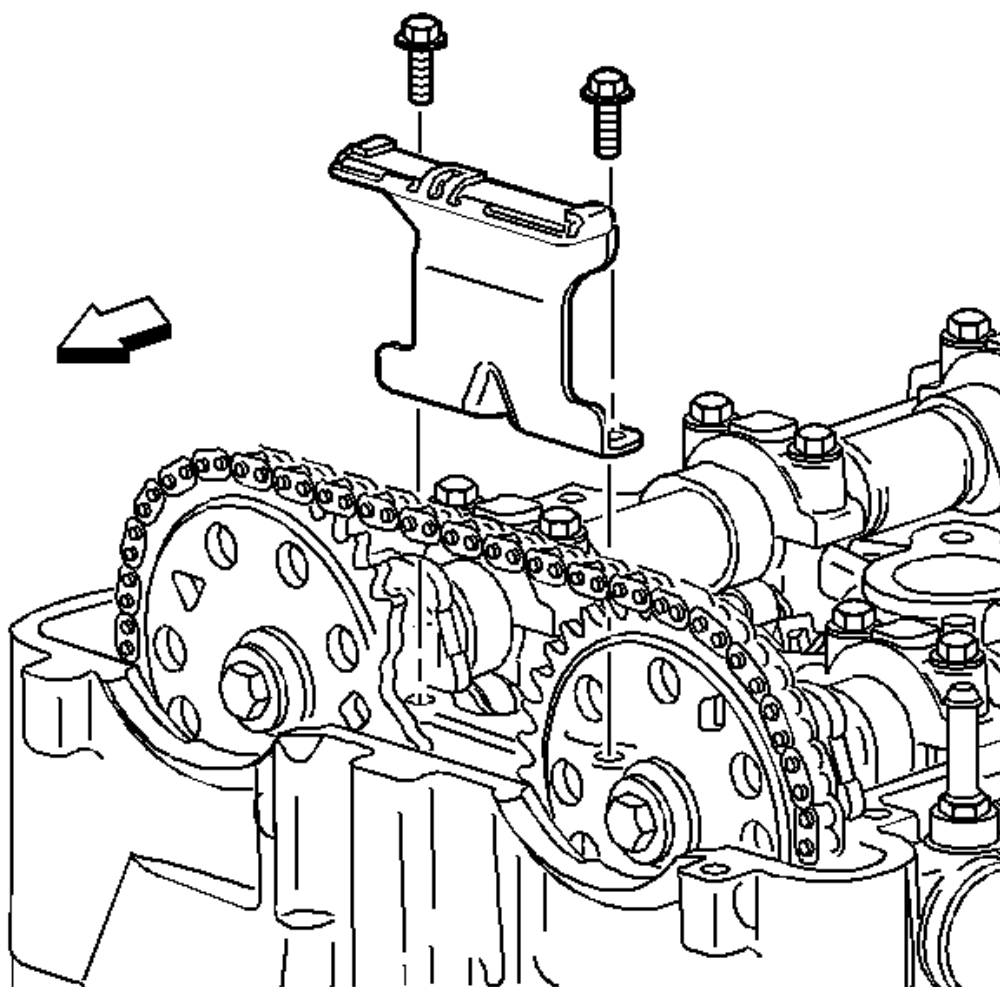


Fig. 161: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

12. Install the upper timing chain guide.

Tighten: Tighten the upper timing chain guide to 10 N.m (89 lb in).

13. Install the camshaft cover. Refer to [Camshaft Cover Replacement](#).

VALVE STEM OIL SEAL AND VALVE SPRING REPLACEMENT

Tools Required

- **J 43649** Valve Spring Compressor
- **J 36017** Valve Guide Seal Remover
- **J 43653** Flywheel Holding Tool. See Special Tools.

Removal Procedure

IMPORTANT: Prevent the crankshaft from rotating clockwise or counterclockwise before using compressed air in the cylinder. Rotation of the crankshaft may cause damage to the **J 43653** . See Special Tools.

1. If equipped with a manual transmission, leave the transmission in first gear with the vehicle on the ground and the parking brake set.
2. If equipped with an automatic transmission, remove the starter. Refer to Starter Motor Replacement .
3. Install the **J 43653** . See Special Tools.
4. Remove the camshaft. Refer to Intake Camshaft and Valve Lifter Replacement or Exhaust Camshaft and Valve Lifter Replacement.

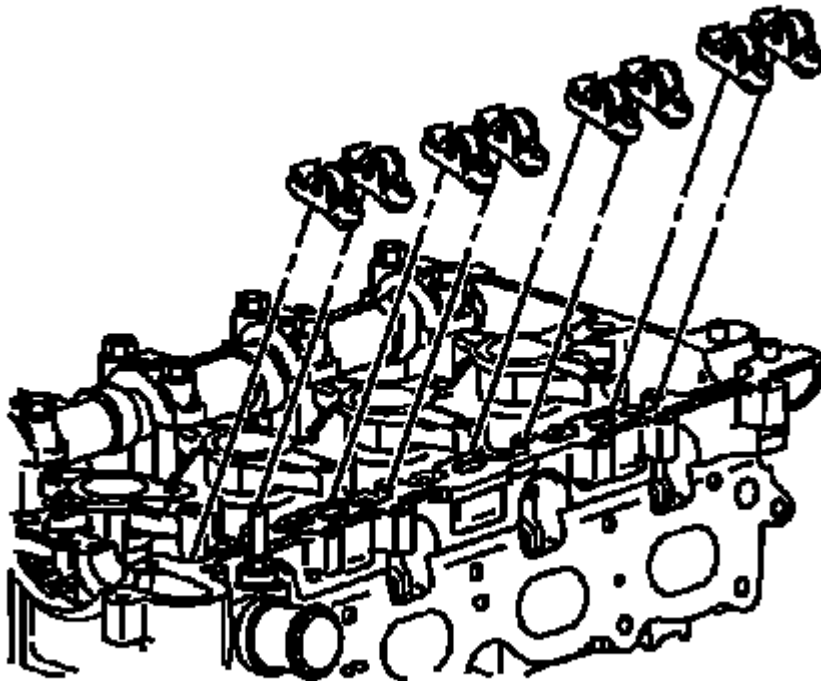


Fig. 162: Identifying Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

5. Remove the camshaft roller followers.

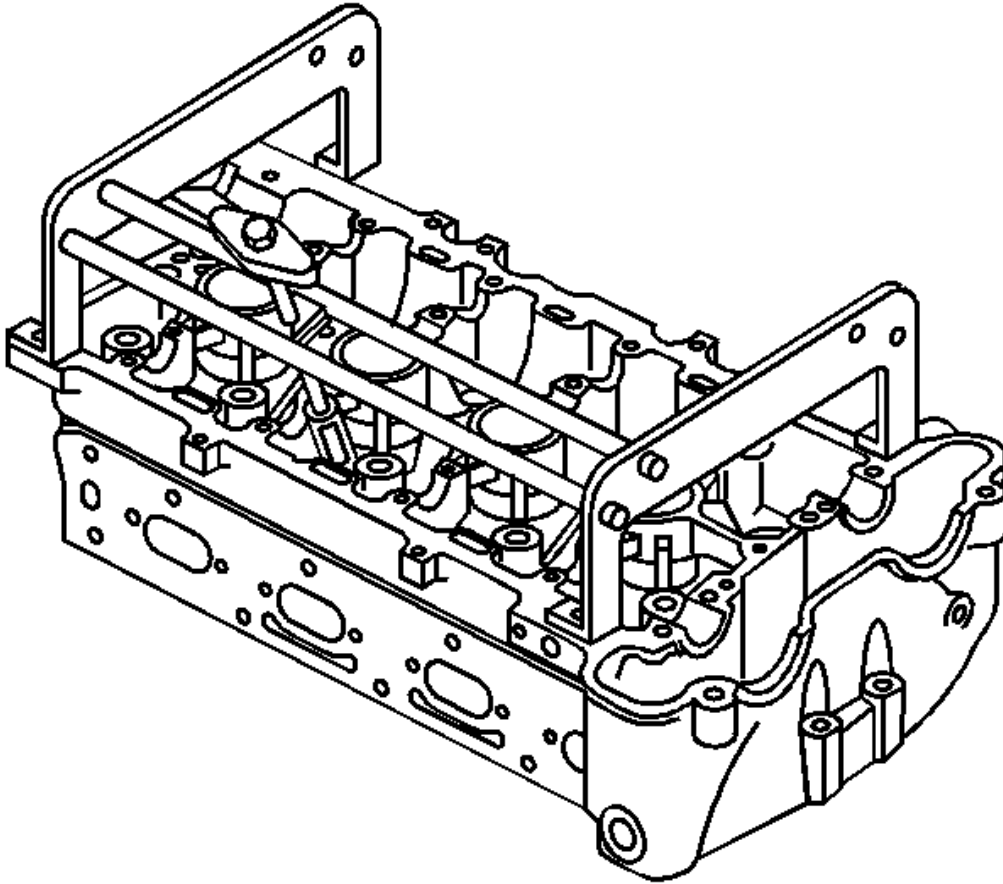


Fig. 163: View Of Valve Spring Compressor
Courtesy of GENERAL MOTORS CORP.

6. Install the **J 43649** to the cylinder head.
7. Remove the spark plugs. Refer to **Spark Plug Replacement**.

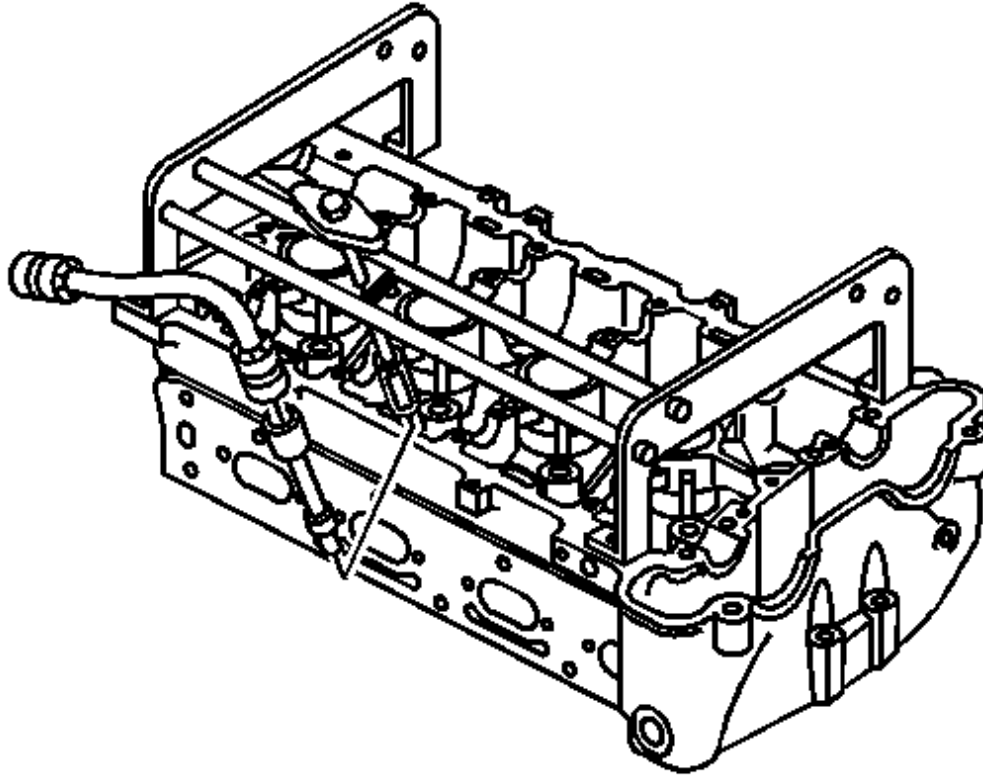


Fig. 164: View Of Air Hose Adaptor
Courtesy of GENERAL MOTORS CORP.

8. Install an air hose adaptor into the spark plug hole.
9. Pressurize the cylinder to 690 kPa (100 psi).
10. Compress the valve spring.
11. Remove the valve spring keepers.
12. Remove the valve spring.

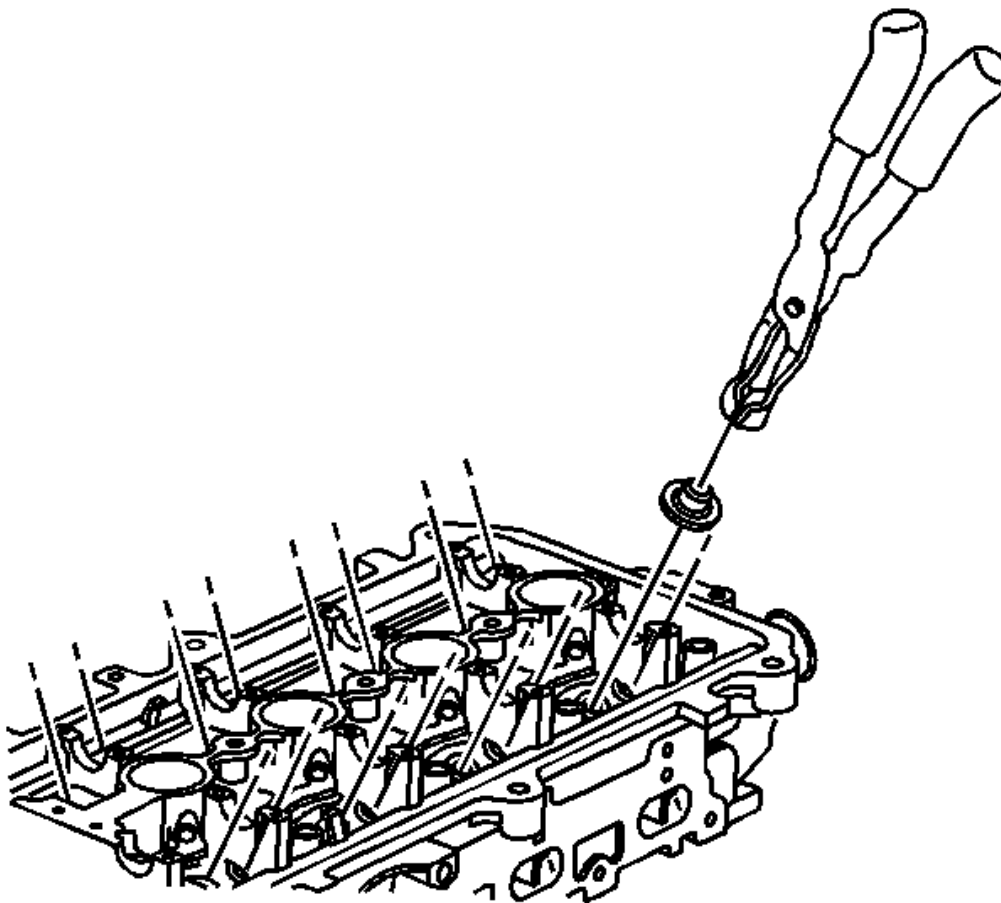


Fig. 165: View Of J 36017 & Valve Seal
Courtesy of GENERAL MOTORS CORP.

13. Using the **J 36017** remove the valve seal.

Installation Procedure

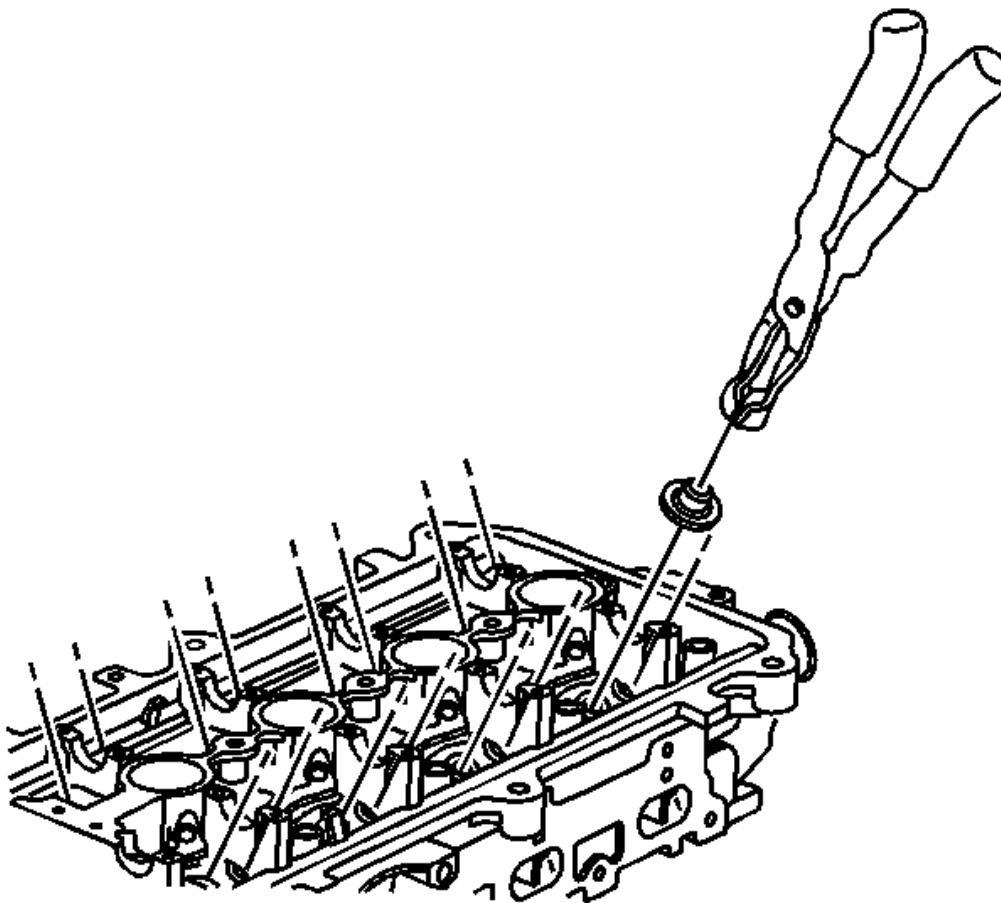


Fig. 166: View Of J 36017 & Valve Seal
Courtesy of GENERAL MOTORS CORP.

1. Using the **J 36017** install the valve seal.

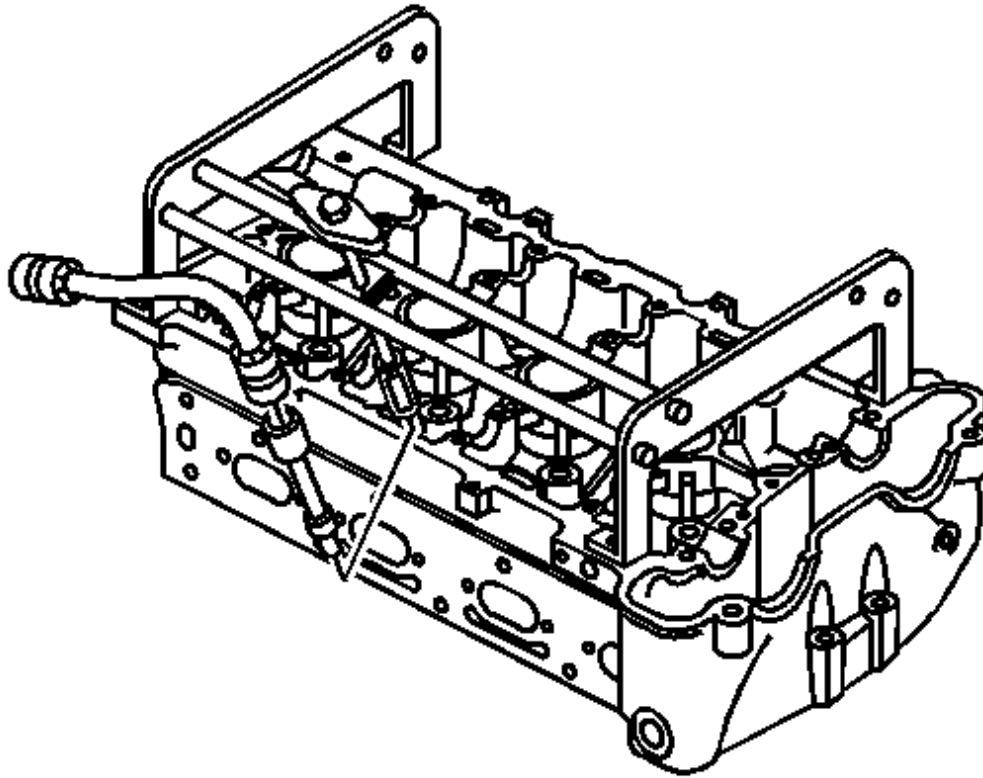


Fig. 167: View Of Air Hose Adaptor
Courtesy of GENERAL MOTORS CORP.

2. Install the valve spring.
3. Compress the valve spring.
4. Install the valve spring keepers.
5. Remove the air hose adaptor into the spark plug hole.

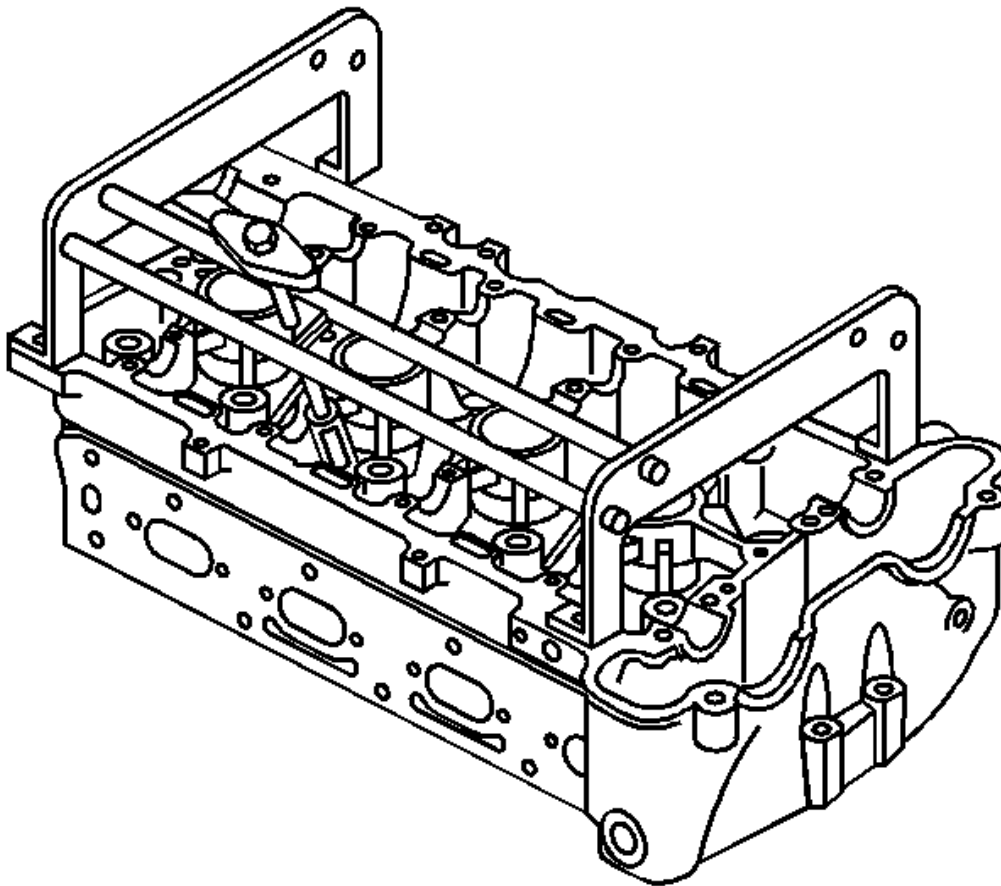


Fig. 168: View Of Valve Spring Compressor
Courtesy of GENERAL MOTORS CORP.

6. Remove the **J 43649** from the cylinder head.
7. Install the spark plugs. Refer to **Spark Plug Replacement** .

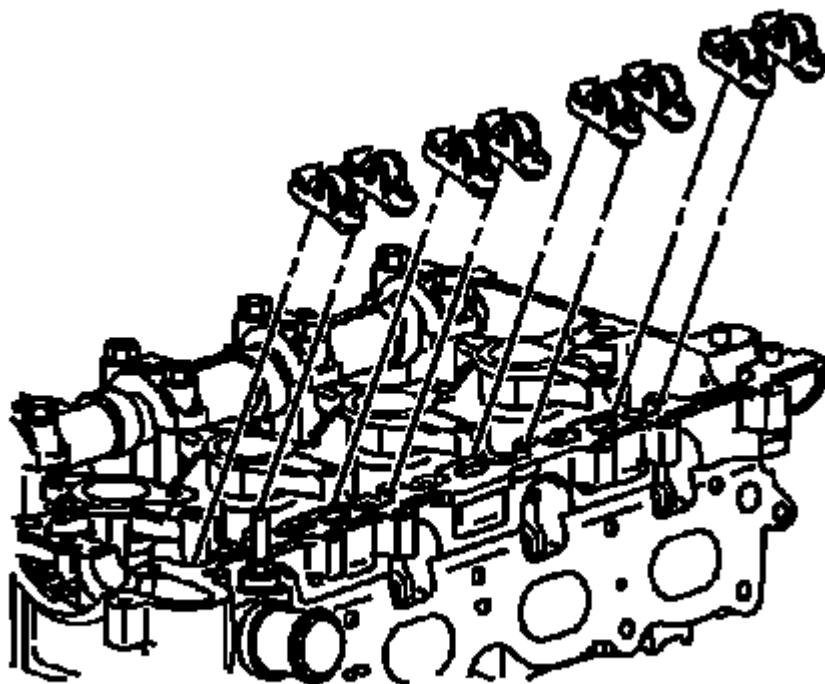


Fig. 169: Identifying Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

8. Install the camshaft roller followers.
9. Install the camshaft. Refer to Intake Camshaft and Valve Lifter Replacement or Exhaust Camshaft and Valve Lifter Replacement.
10. If removed, install the starter. Refer to Starter Motor Replacement.
11. If used, remove the **J 43653**. See Special Tools.

CYLINDER HEAD REPLACEMENT

Tools Required

J 45059 Torque Angle Meter

Removal Procedure

1. Remove the intake manifold. Refer to Intake Manifold Replacement.
2. Remove the exhaust manifold. Refer to EXHAUST MANIFOLD REPLACEMENT (L61).
3. Remove the timing chain. Refer to Camshaft Timing Chain, Sprocket, and Tensioner Replacement.

4. Drain the cooling system. Refer to Cooling System Draining and Filling (GE 47716 Fill) or Cooling System Draining and Filling (Static Fill LE5, L61).

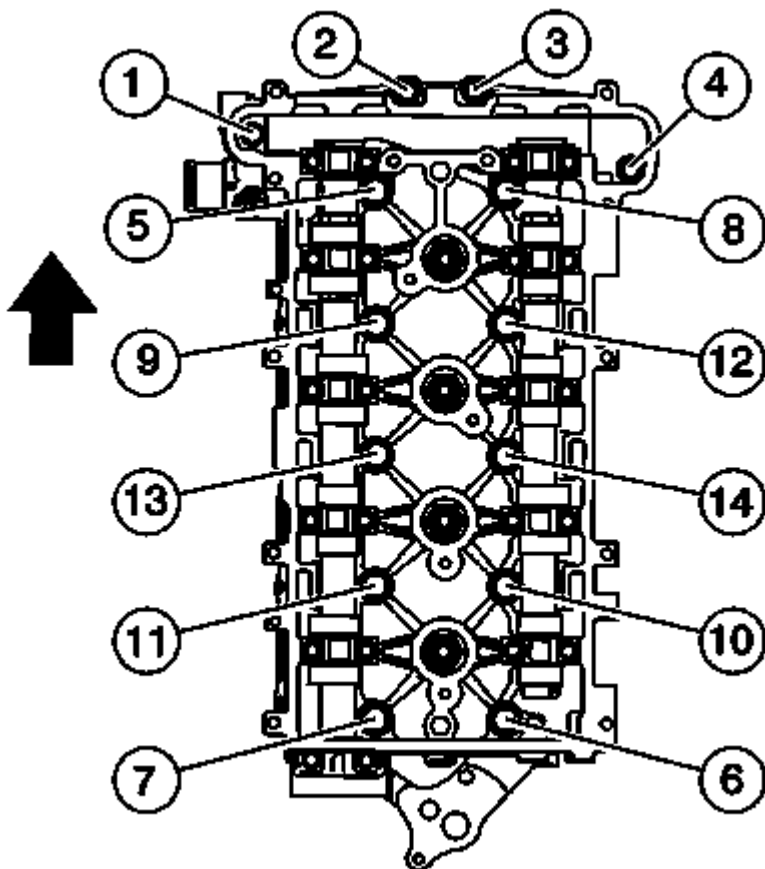


Fig. 170: Cylinder Head Bolt Removal Sequence
Courtesy of GENERAL MOTORS CORP.

5. Remove the cylinder head bolts in sequence and discard.

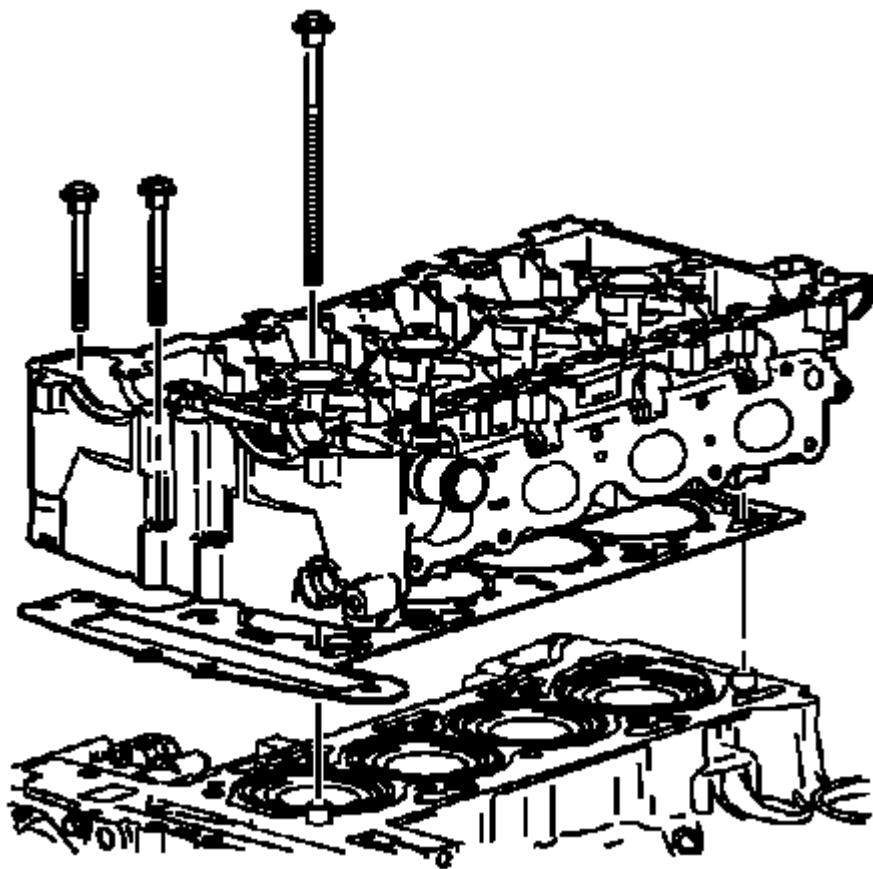


Fig. 171: View Of Cylinder Head And Gasket
Courtesy of GENERAL MOTORS CORP.

6. Remove the cylinder head and gasket.
7. Clean all gasket surfaces.

Installation Procedure

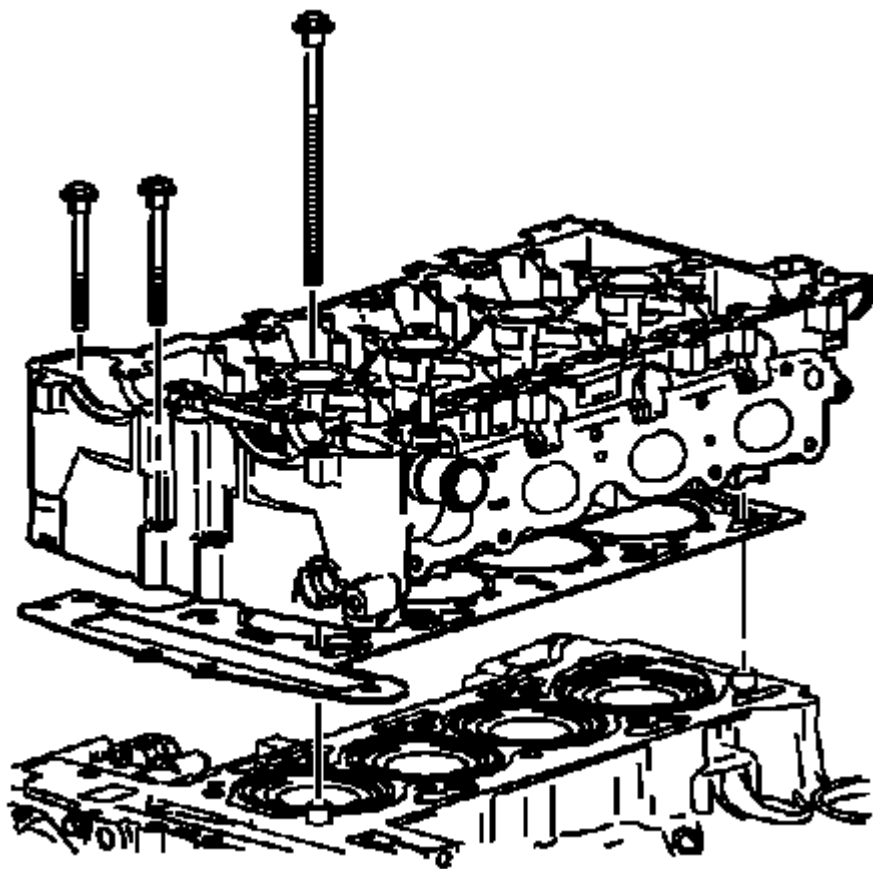


Fig. 172: View Of Cylinder Head And Gasket
Courtesy of GENERAL MOTORS CORP.

1. Install the cylinder head and gasket.
2. Install NEW cylinder head bolts.

NOTE: Refer to FASTENER NOTICE .

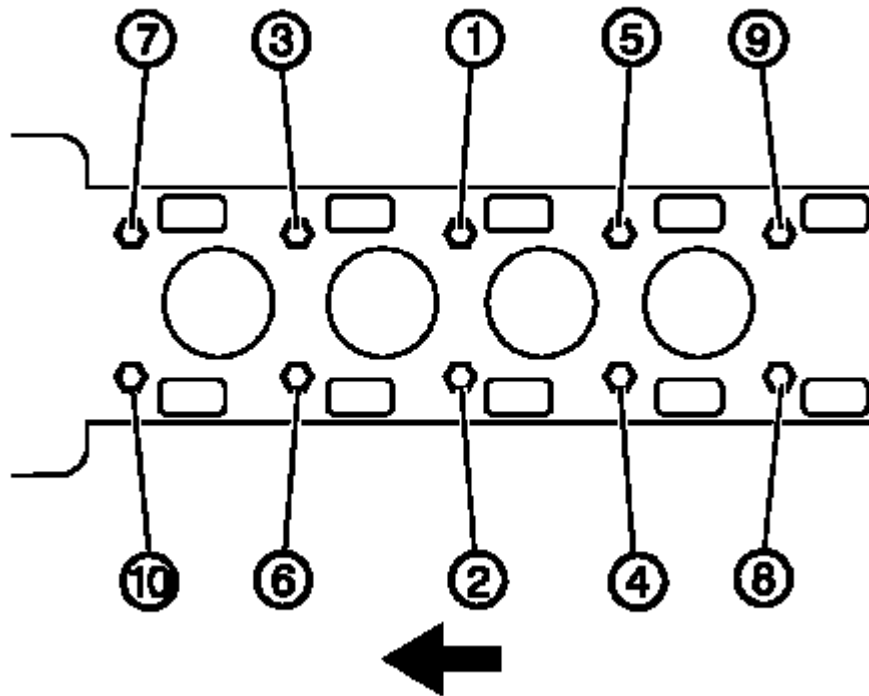


Fig. 173: Identifying Cylinder Head Bolt Tightening Sequence
 Courtesy of GENERAL MOTORS CORP.

3. Tighten the cylinder head bolts in sequence.

Tighten: Tighten the cylinder head bolts to 30 N.m (22 lb ft) plus 155 degrees using **J 45059** .

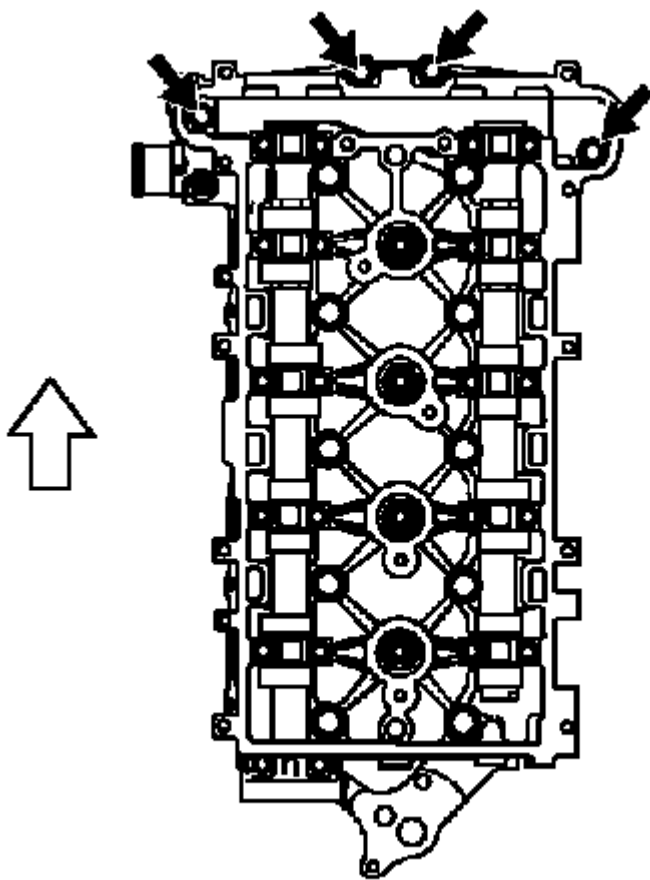


Fig. 174: Locating Front Cylinder Head Bolts
Courtesy of GENERAL MOTORS CORP.

4. Install the NEW front cylinder head bolts.

Tighten: Tighten the front cylinder head bolts to 35 N.m (26 lb ft).

5. Install the timing chain. Refer to Camshaft Timing Chain, Sprocket, and Tensioner Replacement.
6. Install the exhaust manifold. Refer to EXHAUST MANIFOLD REPLACEMENT (L61) .
7. Lower the vehicle.
8. Install the intake manifold. Refer to Intake Manifold Replacement.
9. Fill the cooling system. Refer to Cooling System Draining and Filling (GE 47716 Fill) or Cooling System Draining and Filling (Static Fill LE5, L61) .

OIL PAN REPLACEMENT

Removal Procedure

1. Raise and support the vehicle. Refer to Lifting and Jacking the Vehicle .

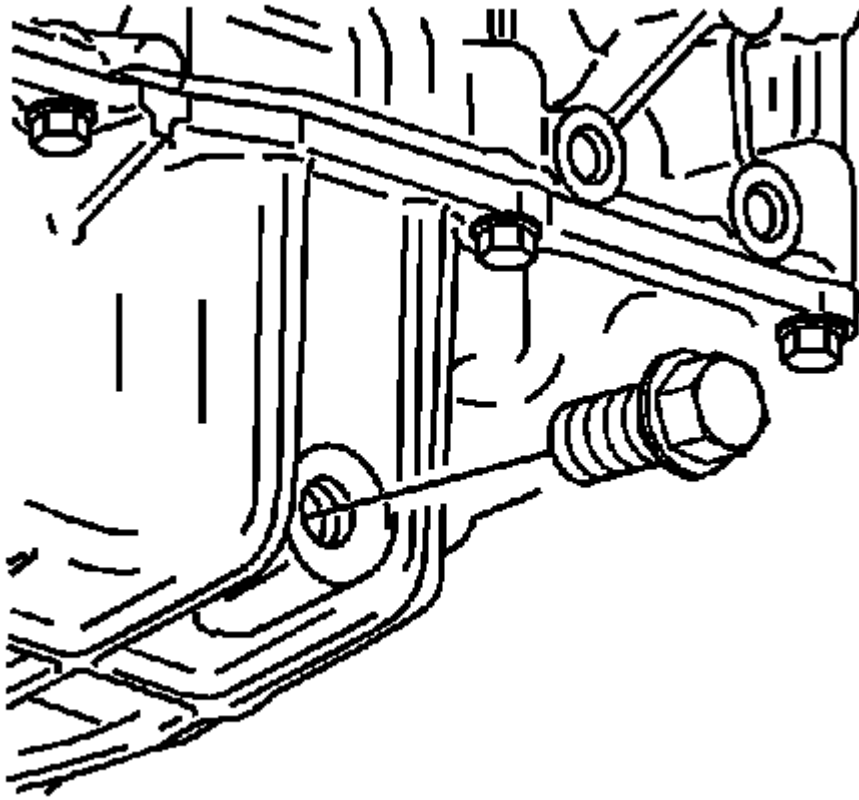


Fig. 175: View Of Oil Pan Drain Bolt
Courtesy of GENERAL MOTORS CORP.

2. Drain the engine oil.
3. Remove the engine drive belt. Refer to **Drive Belt Replacement**.
4. Remove the lower AC compressor bolt.

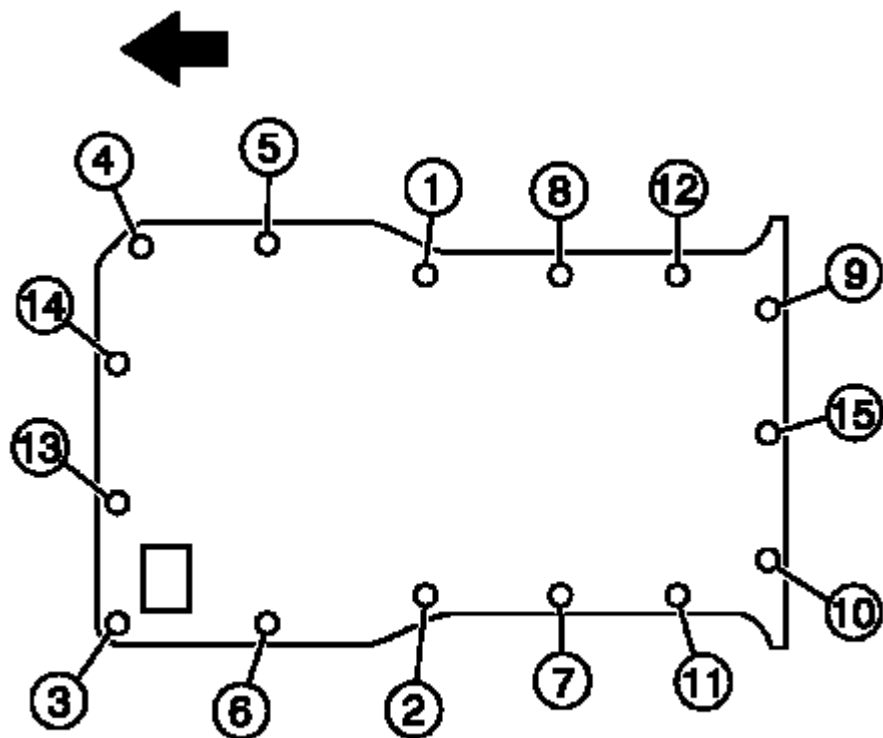


Fig. 176: Identifying Oil Pan Bolts Removal & Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

5. Remove the oil pan bolts.

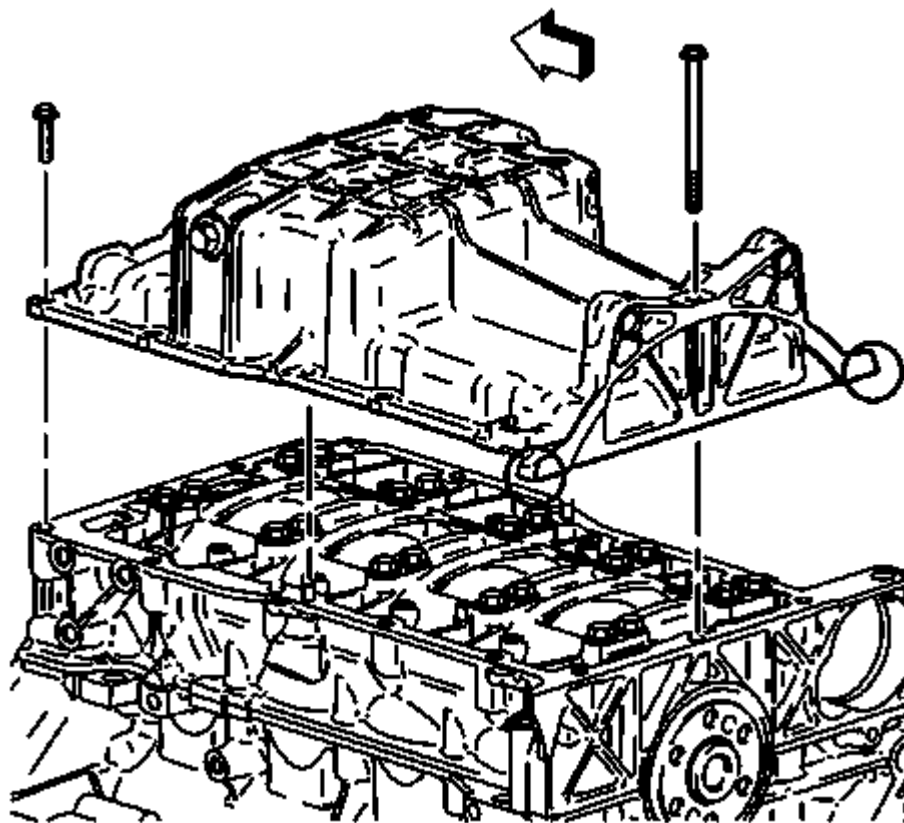


Fig. 177: View Of Oil Pan

Courtesy of GENERAL MOTORS CORP.

6. Remove the oil pan.

Installation Procedure

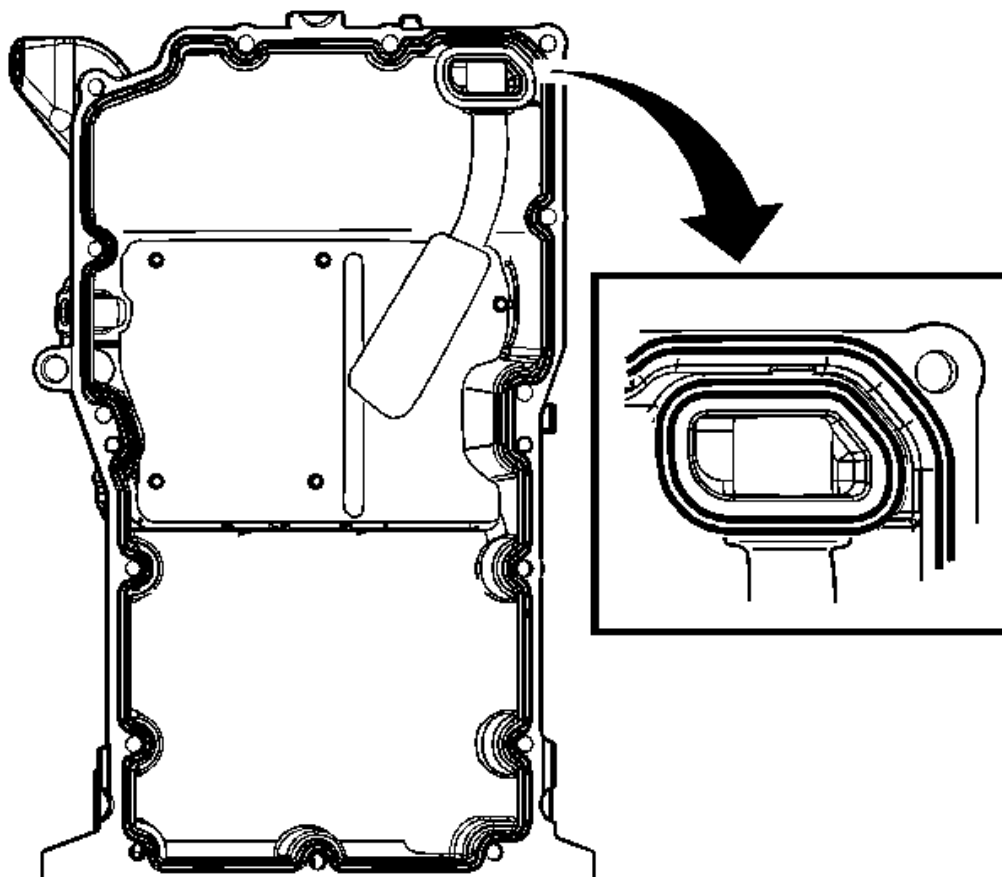


Fig. 178: Applying Oil Pan Adhesive
Courtesy of GENERAL MOTORS CORP.

1. Make sure that the oil pan and mounting surface on the lower crankcase are free of all oil and debris.
2. Apply a 3.5 mm bead of RTV around the perimeter of the oil pan and the oil suction port opening. Refer to **Adhesives, Fluids, Lubricants, and Sealers** for the correct part number.

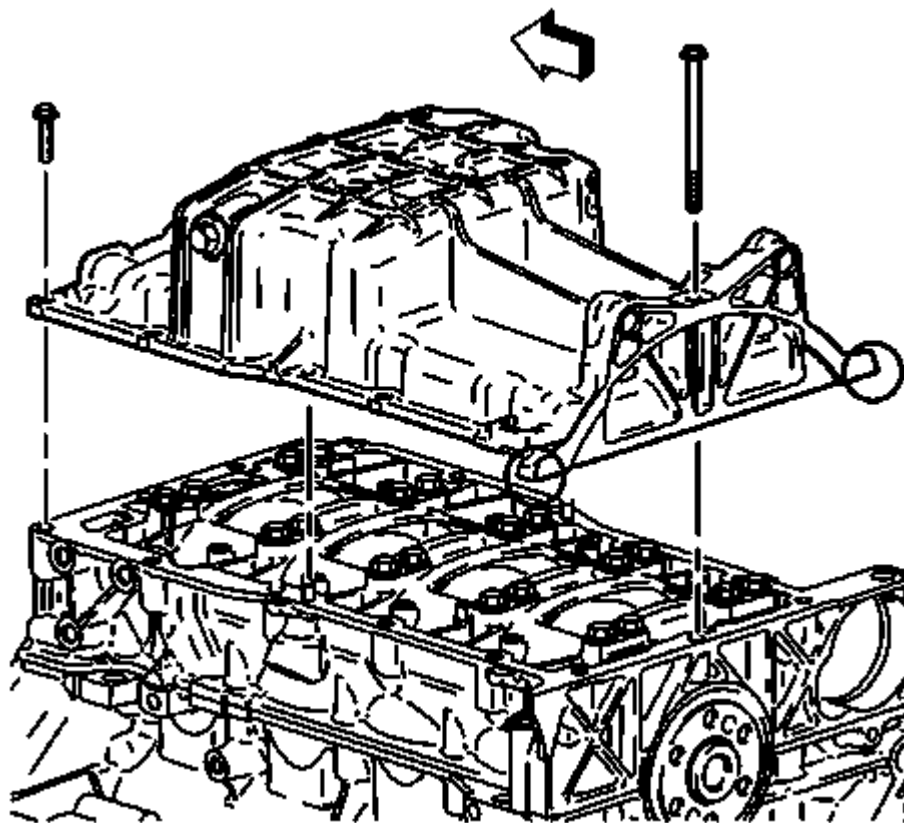


Fig. 179: View Of Oil Pan

Courtesy of GENERAL MOTORS CORP.

3. Install the oil pan.

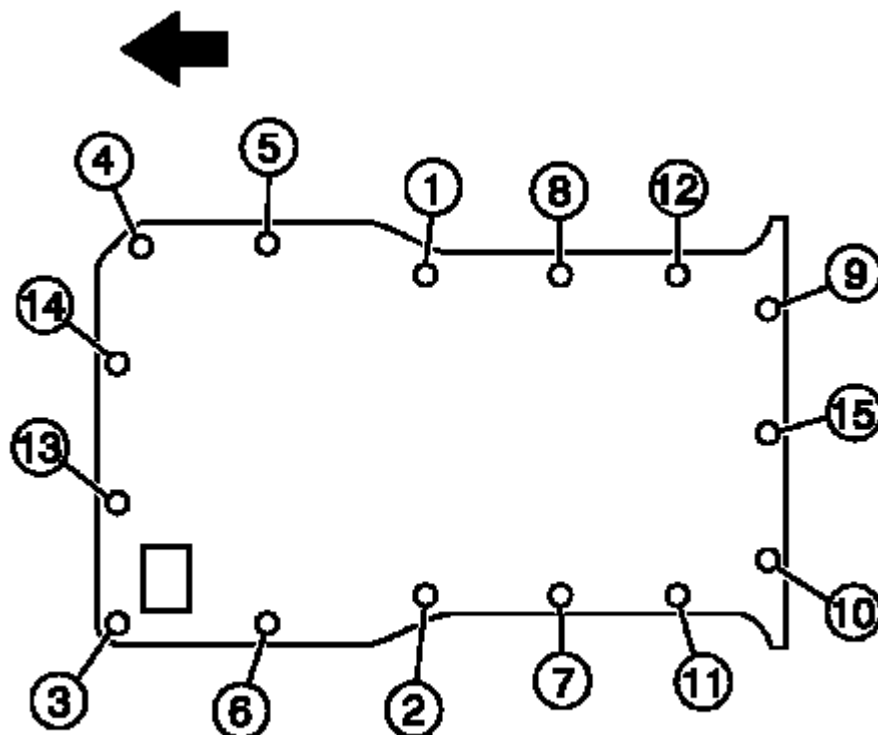


Fig. 180: Identifying Oil Pan Bolts Removal & Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

4. Install the oil pan bolts.

Tighten: Tighten the oil pan bolts to 25 N.m (18 lb ft).

5. Install the AC compressor bolts. Refer to Air Conditioning Compressor Replacement (L61, LE5) .
6. Install the engine drive belt. Refer to Drive Belt Replacement.
7. Lower the vehicle.
8. Fill the engine oil to the proper level.

SEALANT REPLACEMENT - LOWER CRANKCASE TO ENGINE BLOCK

Special Tools

J 45059 Angle Meter

Removal Procedure

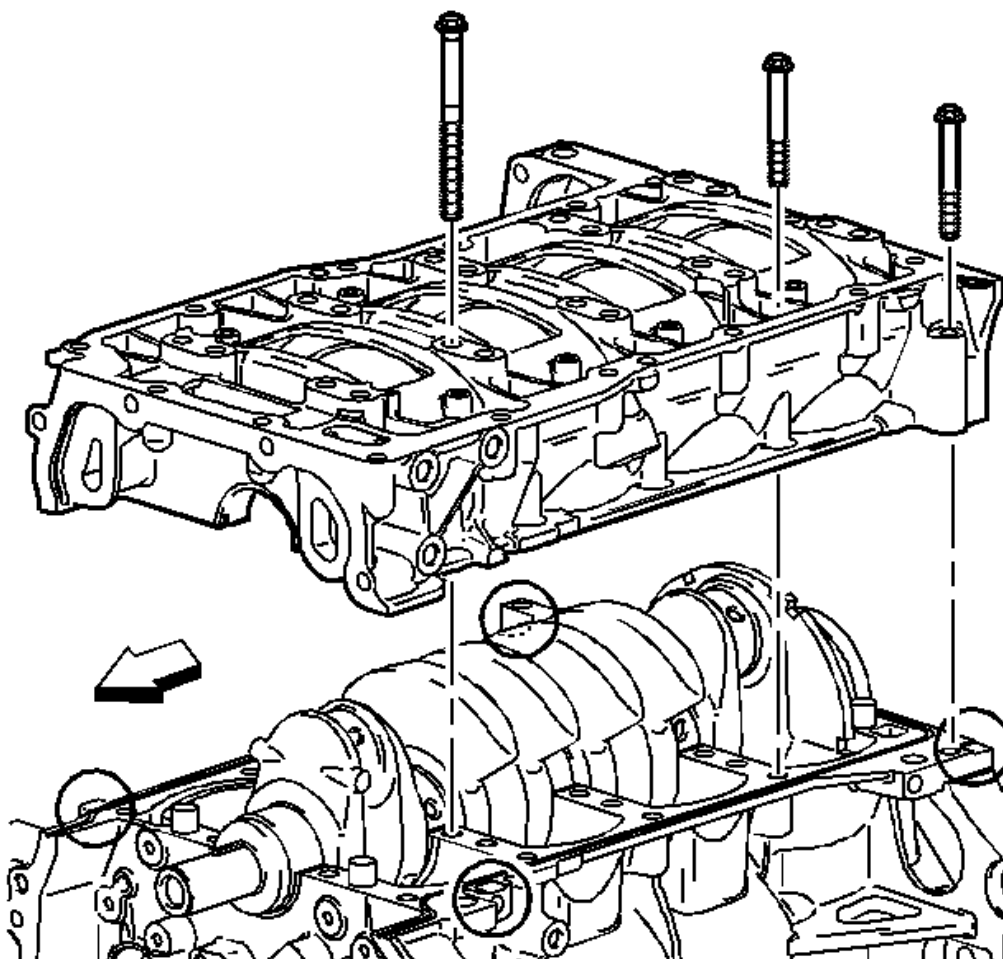


Fig. 181: View Of Upper & Lower Crankcase W/Bolts
 Courtesy of GENERAL MOTORS CORP.

1. Remove the engine from the vehicle. Refer to **Engine Replacement** for the 2.2L engine.
2. Remove the crankshaft balancer. Refer to **Crankshaft Balancer Removal** .
3. Remove the engine front cover. Refer to **Engine Front Cover and Oil Pump Removal**.
4. Remove the engine oil pan. Refer to **Oil Pan Removal** .
5. Remove the 3 perimeter bolts.

IMPORTANT: Do not forget the 2 outside rear bolts.

6. Remove and discard the crankshaft bearing bolts.

IMPORTANT: Keep the bearing halves in order upon removal for proper installation.

7. Using the pry points and an appropriate prying tool, gently separate the upper and lower crankcase.
8. Clean the sealing material from the engine block and lower the crankcase.

Installation Procedure

1. Apply oil to the crankshaft bearing surfaces.

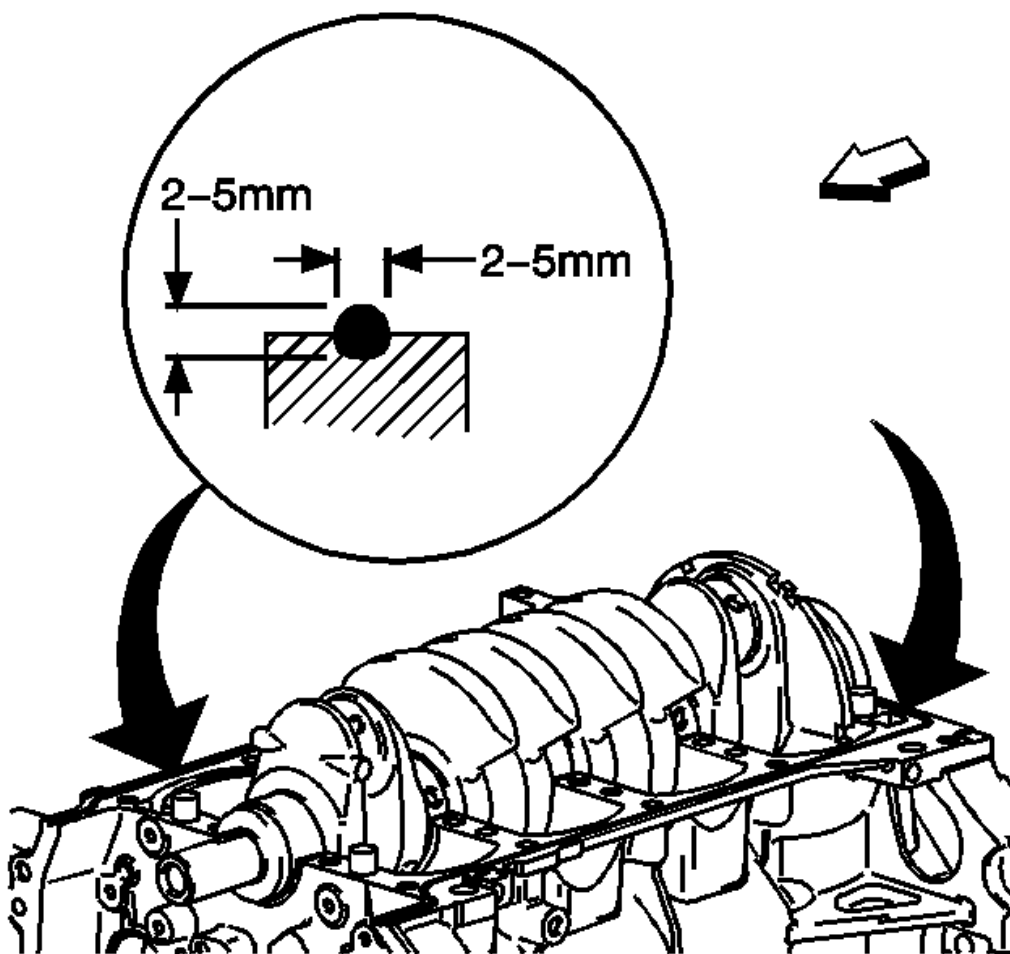


Fig. 182: Applying Sealer To Engine Block Bedplate Mating Surfaces
Courtesy of GENERAL MOTORS CORP.

2. Apply a 2-5 mm (0.08-0.20 in) bead (a) of sealer GM P/N 12378521 (Canadian P/N 88901148) to the surface of the engine block-to-lower crankcase mating surface.

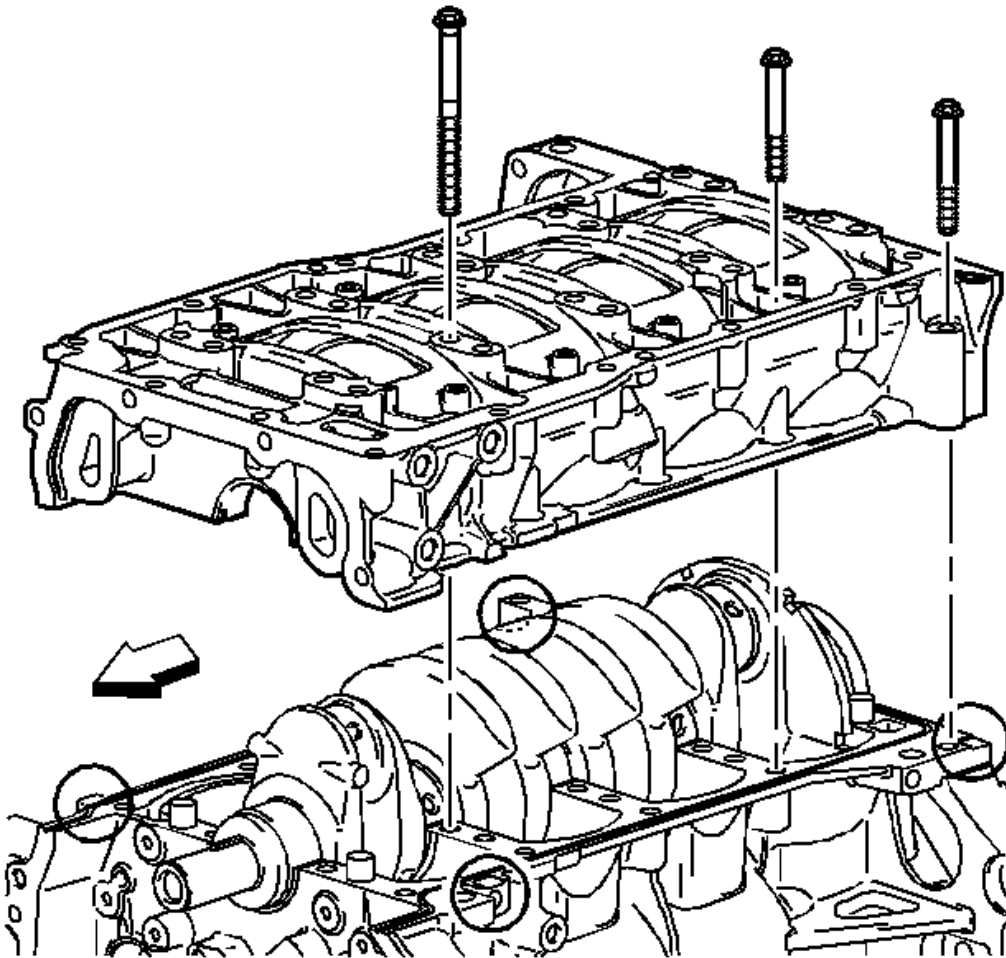


Fig. 183: View Of Upper & Lower Crankcase W/Bolts
Courtesy of GENERAL MOTORS CORP.

3. Install the lower crankcase.

Tap gently into place with a suitable tool, if necessary. Ensure it is aligned properly on the dowels.

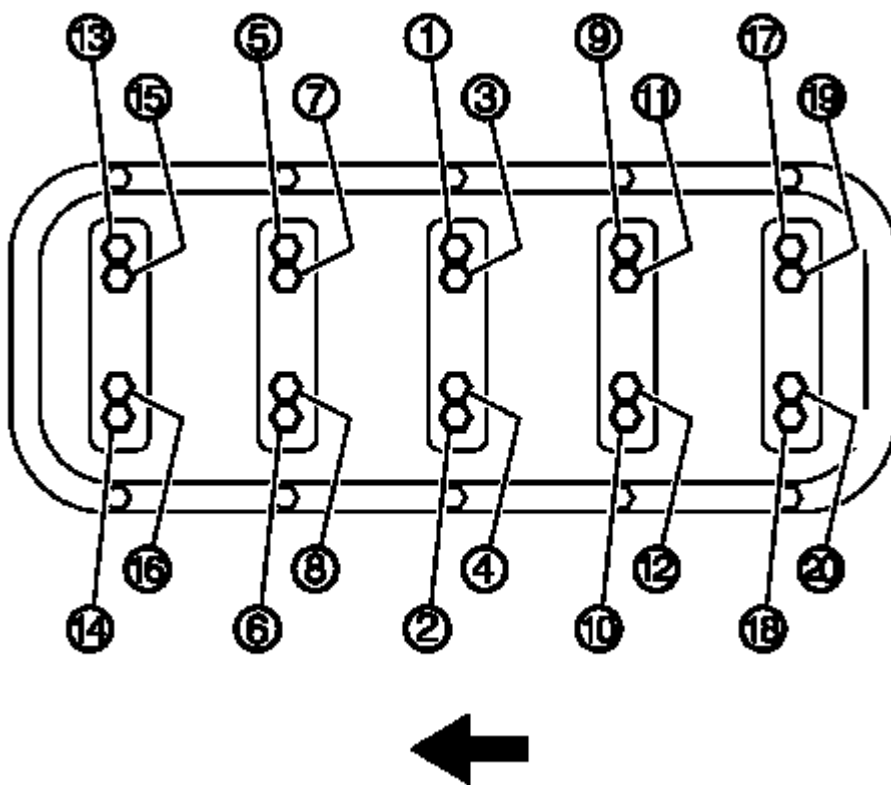


Fig. 184: Identifying Crankshaft Bearing Bolt Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

4. Install the NEW crankshaft bearing bolts in sequence finger tight.
 1. Tighten the crankshaft bearing bolts in sequence.

Tighten: Tighten the crankshaft bearing bolts to 20 N.m (15 lb ft).

2. Tighten the crankshaft bearing bolts in sequence using the **J 45059** .

Tighten: Tighten the crankshaft bearing bolts to 70 degrees using the **J 45059** .

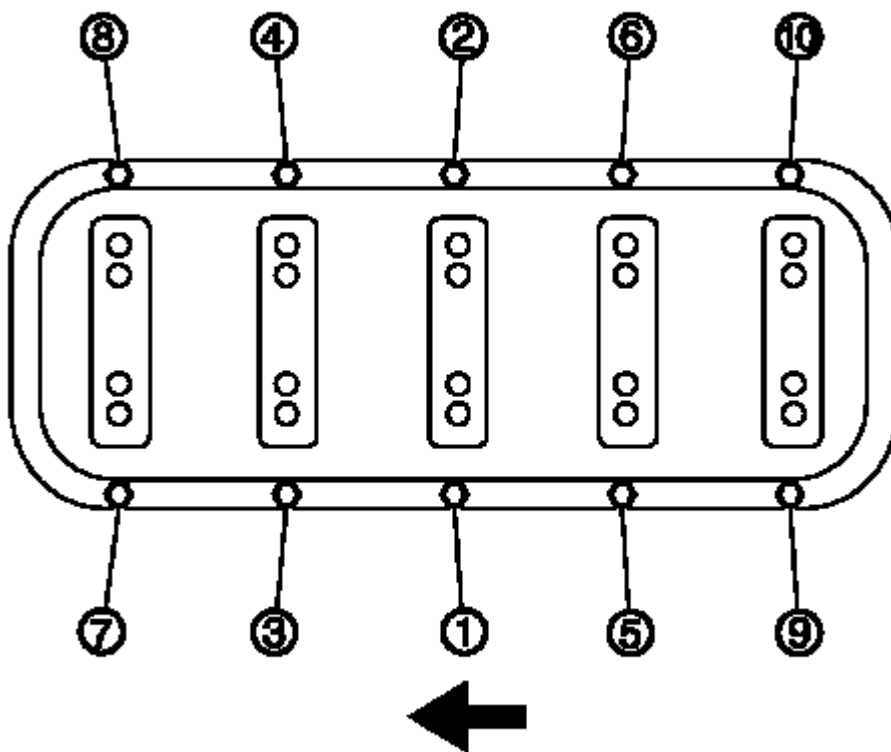


Fig. 185: Lower Crankcase Perimeter Bolt Tightening Sequence
 Courtesy of GENERAL MOTORS CORP.

5. Tighten the lower crankcase perimeter bolts in sequence.

Tighten: Tighten the lower crankcase perimeter bolts to 25 N.m (18 lb ft).

6. Install the engine front cover. Refer to **Engine Front Cover and Oil Pump Installation**.
7. Install the crankshaft balancer. Refer to **Crankshaft Balancer Installation**
8. Install the engine oil pan. Refer to **Oil Pan Installation**.
9. Install the engine. Refer to **Engine Replacement** for the 2.2L engine.

PISTON, CONNECTING ROD, AND BEARING REPLACEMENT

Special Tools

- **J 43953** Connecting Rod Guide Pin. See **Special Tools**.
- **J 43953** Piston Ring Compressor. See **Special Tools**.
- **J-43966-1** Connecting Rod Guides
- **J 45059** Angle Meter

Removal Procedure

1. Remove the oil pan. Refer to **Oil Pan Replacement**.
2. Remove the cylinder head. Refer to **Cylinder Head Replacement**.

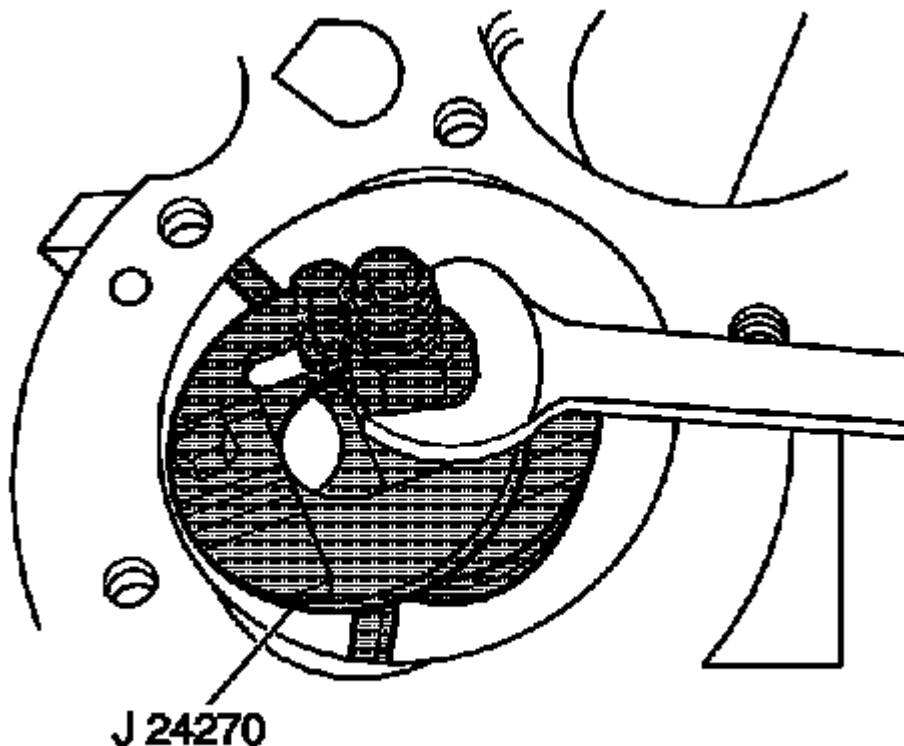


Fig. 186: Removing Cylinder Bore Ring Ridge
Courtesy of GENERAL MOTORS CORP.

3. If a ring ridge is present, remove the ring ridge as follows:
 1. Turn the crankshaft until the piston is at the bottom of the stroke.
 2. Place a cloth on top of the piston.
 3. Use a ridge reamer to remove the ring ridge.
 4. Turn the crankshaft so the piston is at top of the stroke.
 5. Remove the cloth and cutting debris.

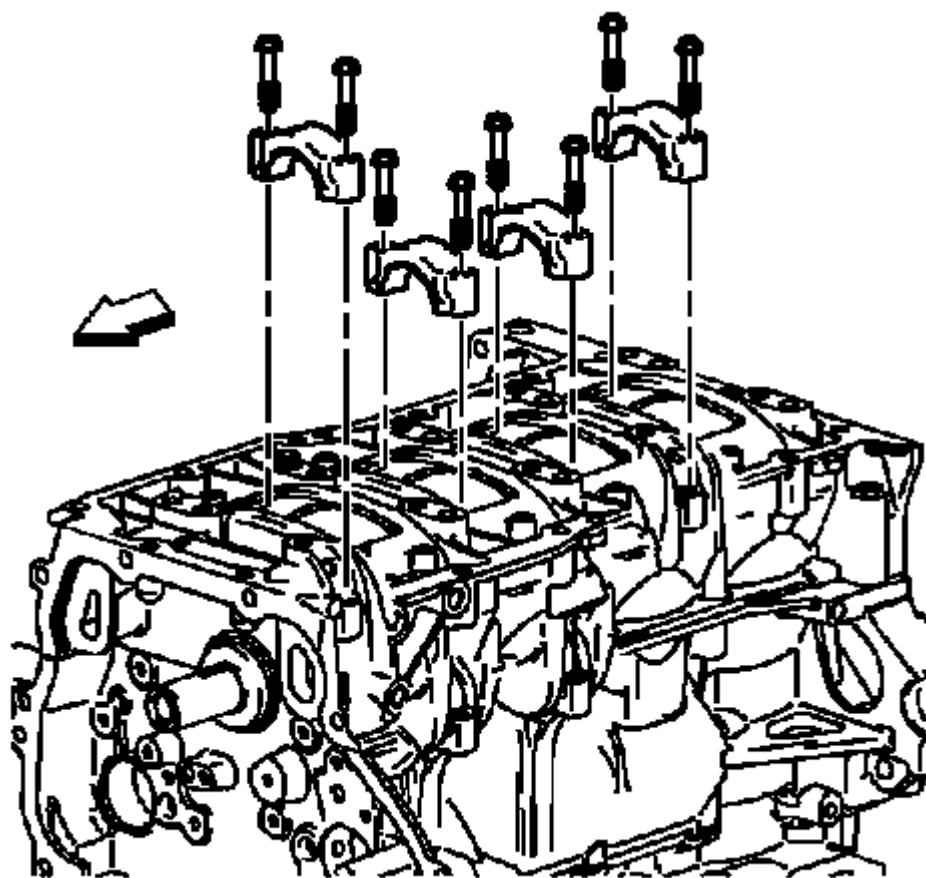


Fig. 187: View Of Connecting Rod Nuts And Caps
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Place the numbers on connecting rods and the connecting rod caps. The connecting rod caps must be assembled to their original connecting rods.

4. Remove the connecting rod nuts and the connecting rod cap.

Discard the bolts and nuts.

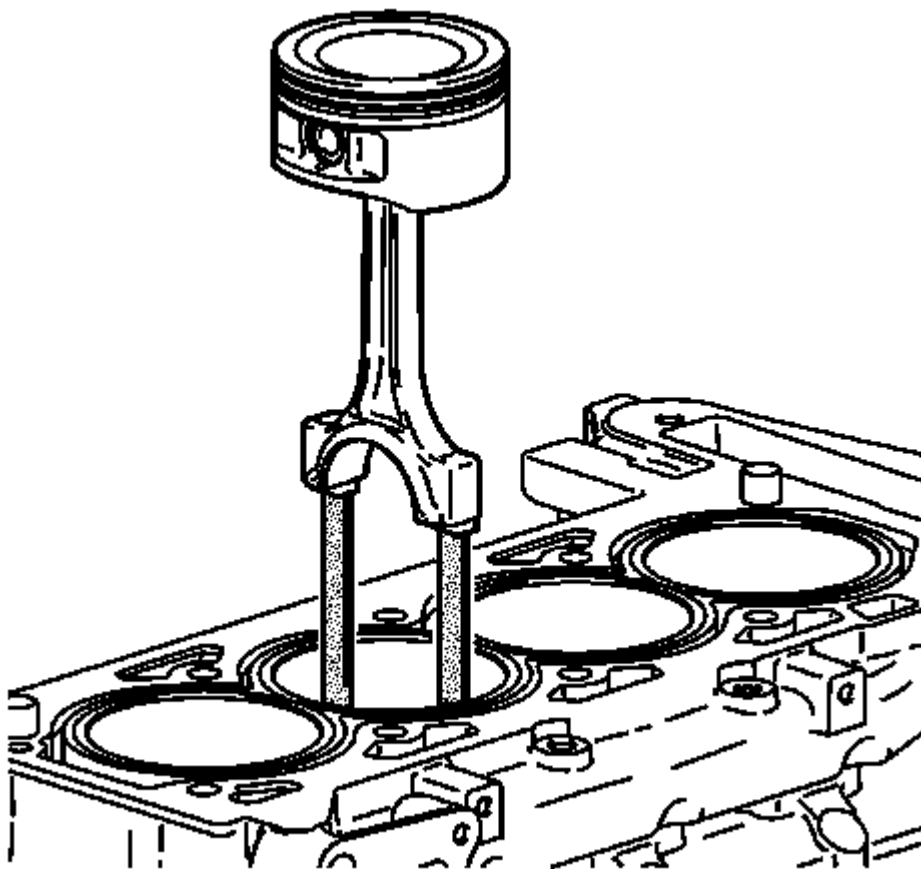


Fig. 188: J-43966-1 Installed On Connecting Rod Bolts
Courtesy of GENERAL MOTORS CORP.

5. Remove the connecting rod and the piston out of the top of the engine block using the **J 41742** and. See **Special Tools.J-43966-1** .
6. Clean the cylinder bores with hot water and detergent or with a light honing.
7. Swab the bores with the engine oil and a clean, dry cloth.

Installation Procedure

1. Coat the following parts with engine oil:
 - The piston
 - The piston rings
 - The cylinder bore
 - The bearing surfaces

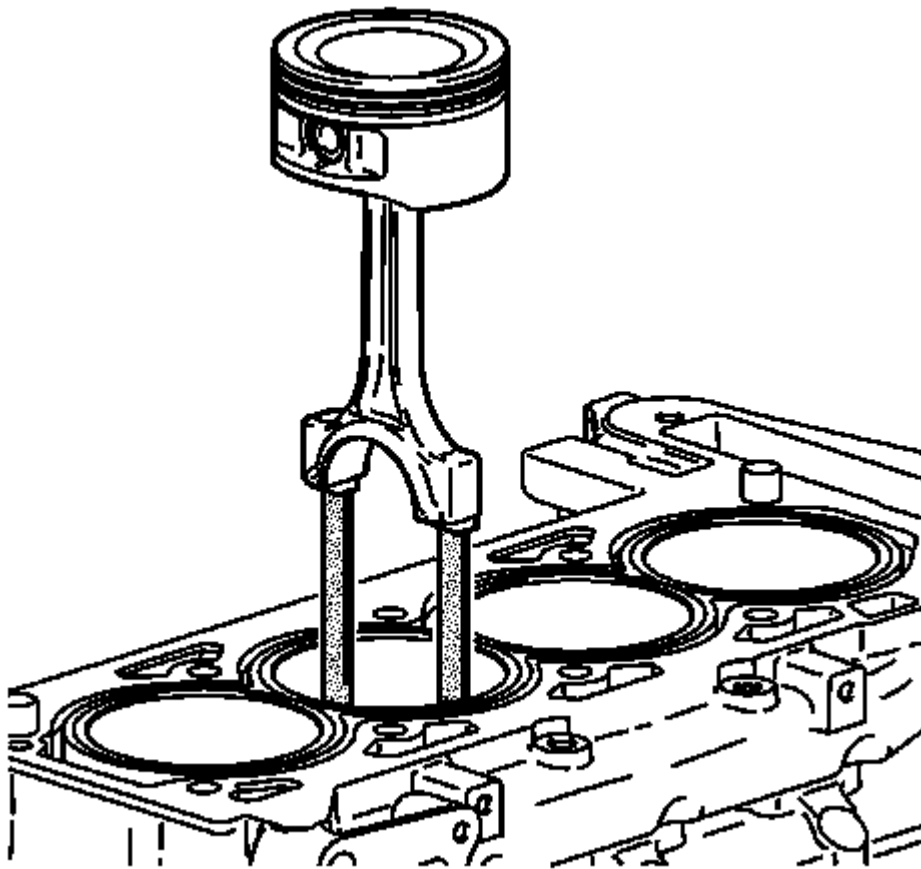


Fig. 189: J-43966-1 Installed On Connecting Rod Bolts
 Courtesy of GENERAL MOTORS CORP.

2. Install the piston into its original bore using the **J-43966-1** , **J 43953** and **J 41742** . See **Special Tools**.
3. Lightly tap the top of the piston with a wooden hammer handle.
4. When installing the piston and the connecting rod, the stamped mark on the piston must point to the front of the engine.
5. Hold the **J 43953** firmly against the engine block until all the piston rings have entered the cylinder bore. See **Special Tools**.
6. Install the connecting rod caps onto their original connecting rods.
7. Align the numbers placed on the connecting rod and the connecting rod cap during removal.

NOTE: Refer to **Fastener Notice** .

8. Install the new connecting rod bolts and nuts.

Tighten:

- On the first pass, tighten the nuts evenly to 25 N.m (18 lb ft).
- On the final pass, use the **J 45059** in order to tighten the nuts an additional 100 degrees.

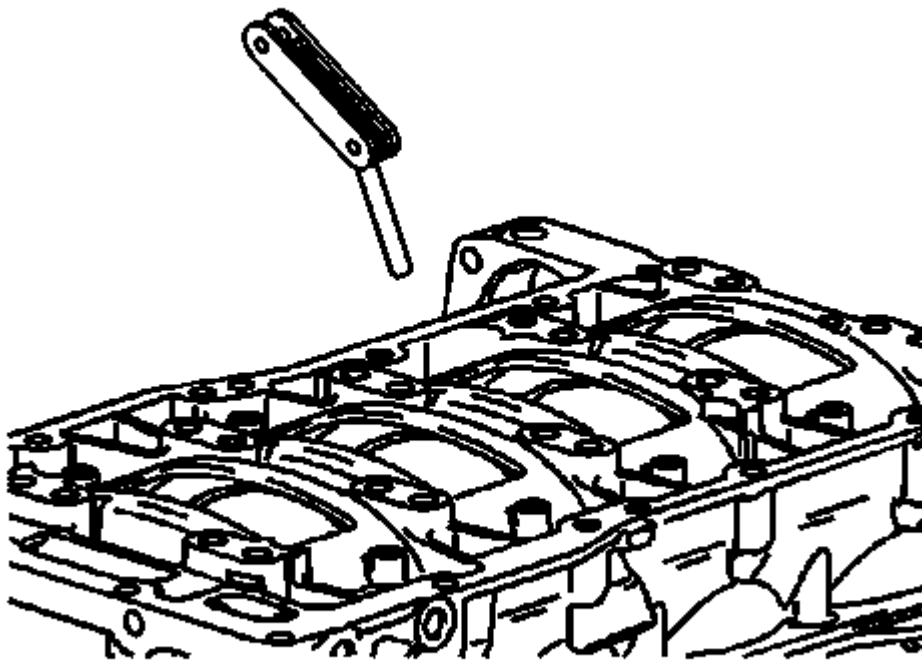


Fig. 190: Measuring Connecting Rod Side Clearance
Courtesy of GENERAL MOTORS CORP.

9. Measure the connecting rod side clearance with a feeler gage.

The correct clearance is 0.070-0.370 mm (0.0027-0.0145 in).

10. Install the cylinder head. Refer to **Cylinder Head Replacement**.
11. Install the oil pan. Refer to **Oil Pan Replacement**.

CYLINDER SLEEVE REPLACEMENT

Tools Required

EN 45680-850 Cylinder Sleeve Removal and Installation Kit

Removal Procedure

1. Remove the piston and connecting rod. Refer to **Piston, Connecting Rod, and Bearing Replacement**.
2. Inspect the condition of the piston. Refer to **Piston, Connecting Rod, and Bearing Cleaning and Inspection**.

NOTE: Do not chill or heat the cylinder bore sleeve or the cylinder block when removing or installing a new cylinder bore sleeve. Chilling or heating the cylinder bore sleeve or the cylinder block will cause engine damage and will not aid the removal or installation of the new cylinder bore sleeve.

NOTE: Do not damage the crankshaft connecting rod journals or reluctor ring or engine damage will occur.

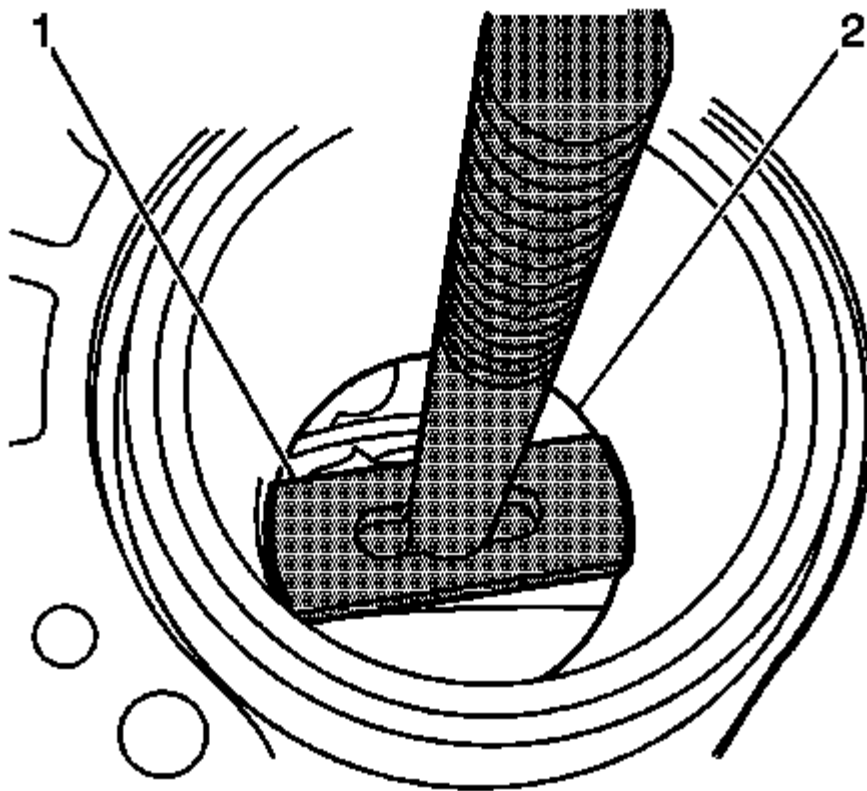


Fig. 191: View Of Cylinder Bore Sleeve Puller
Courtesy of GENERAL MOTORS CORP.

3. Rotate the crankshaft so that the counterweight is to the right side and the connecting rod journal is to the left side and not in alignment with the cylinder bore.
4. Install the cylinder bore sleeve puller EN 45680-852 (1) through the cylinder bore.

NOTE: Ensure that the shoe is flat against the bottom of the cylinder bore liner or damage to the cylinder bore liner puller EN45680-852 will occur.

5. Align the shoe (1) of the cylinder bore sleeve puller EN 45680-852 to the bottom of the cylinder bore sleeve (2).

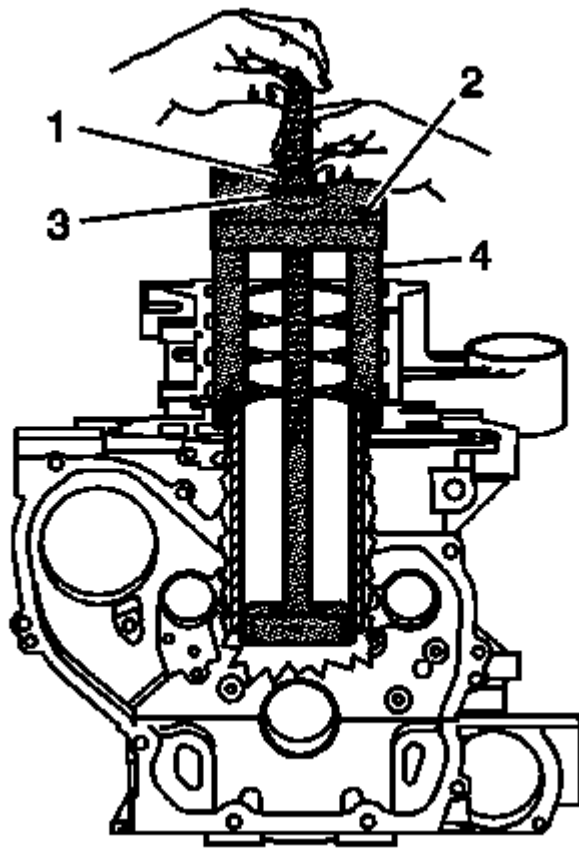


Fig. 192: Aligning Cylinder Bore Sleeve Puller
Courtesy of GENERAL MOTORS CORP.

6. Hold the threaded shaft of the cylinder bore sleeve puller EN 45680-852 upward in order to retain the shoe alignment to the bottom of the cylinder bore sleeve.
7. Install the fixture EN 456850-851 (4) onto the threaded shaft of the cylinder bore sleeve puller EN 456850-852 and the engine block.
8. Install the bearing (3) and the nut (1).
9. Tighten the nut (1) to the bearing (3).

NOTE: Refer to Fastener Notice .

IMPORTANT: Use four old cylinder head bolts for the attaching bolts.

10. Install and tighten the 4 attaching bolts (2) into the cylinder head bolt holes of the block.

Tighten: Tighten the bolts to 15 N.m (11 lb ft).

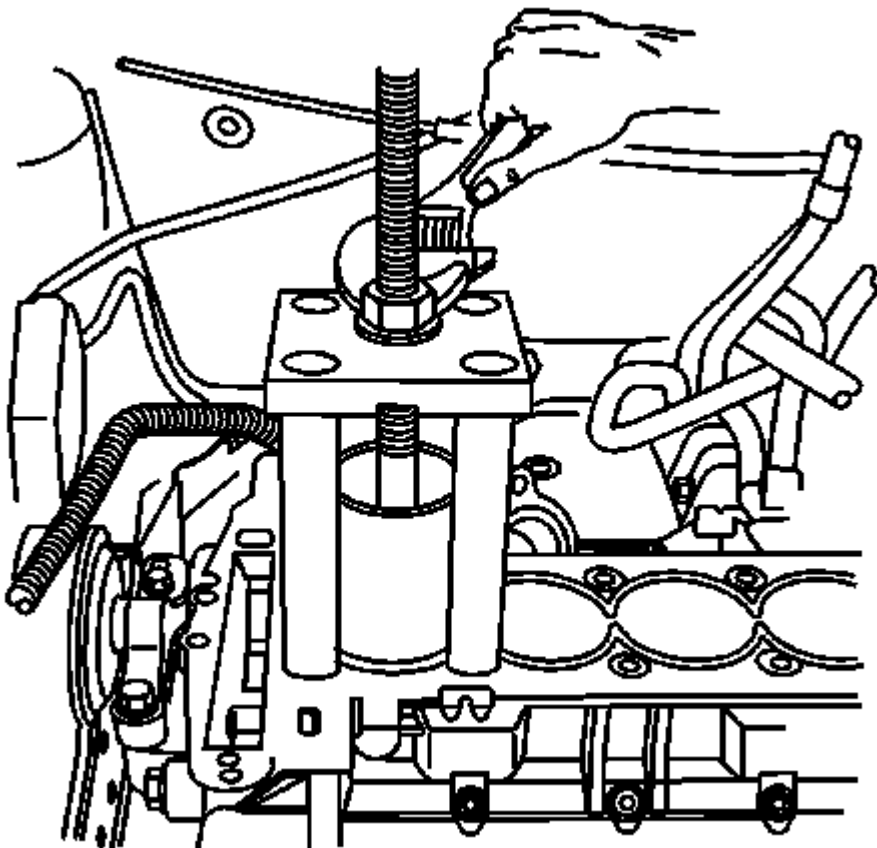


Fig. 193: Rotating Nut Clockwise To Remove Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

11. Rotate the nut clockwise in order to remove the cylinder bore sleeve.

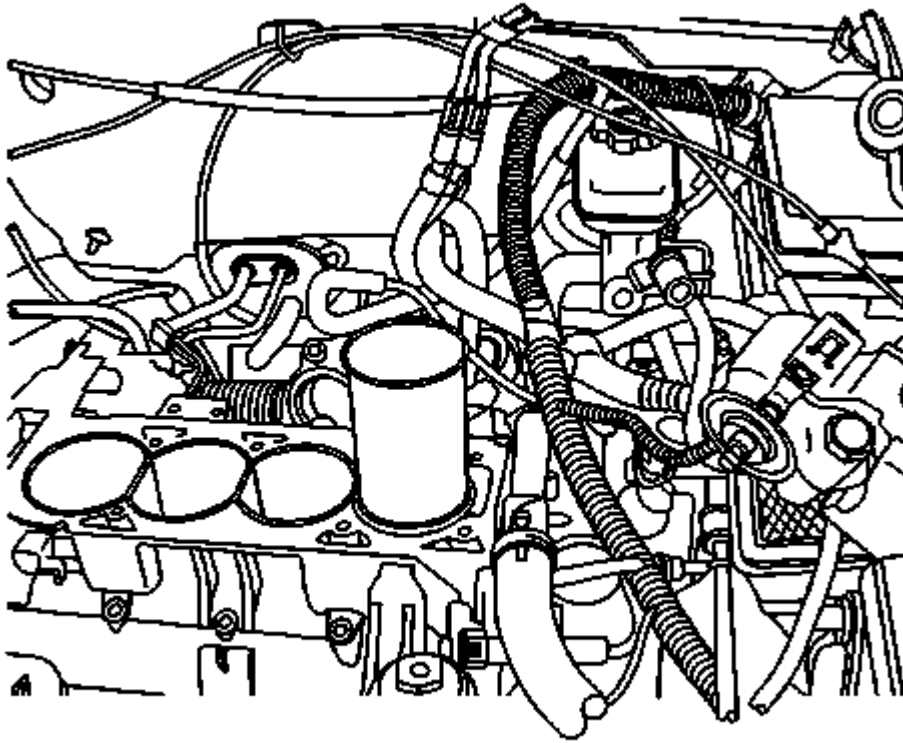


Fig. 194: Cylinder Bore Sleeve

Courtesy of GENERAL MOTORS CORP.

NOTE: Do not damage the cylinder block surface. Damage to the cylinder block surface can cause engine failure.

12. Remove fixture EN 45680-851, cylinder bore liner sleeve EN 45680-852, and the cylinder bore liner from the engine block.
13. Inspect the cylinder bore in the cylinder block for cracks or damage. If cracked or damaged, replace the cylinder block.

Installation Procedure

NOTE: Do not use assembly aids or lubricants on the cylinder bore sleeve or the cylinder bore block when installing a new cylinder bore sleeve, or engine damage will occur. These items will not aid in the installation of the new cylinder bore sleeve.

NOTE: Do not chill or heat the cylinder bore sleeve or the cylinder block when removing or installing a new cylinder bore sleeve. Chilling or heating the cylinder bore sleeve or the cylinder block will cause engine damage and

will not aid the removal or installation of the new cylinder bore sleeve.

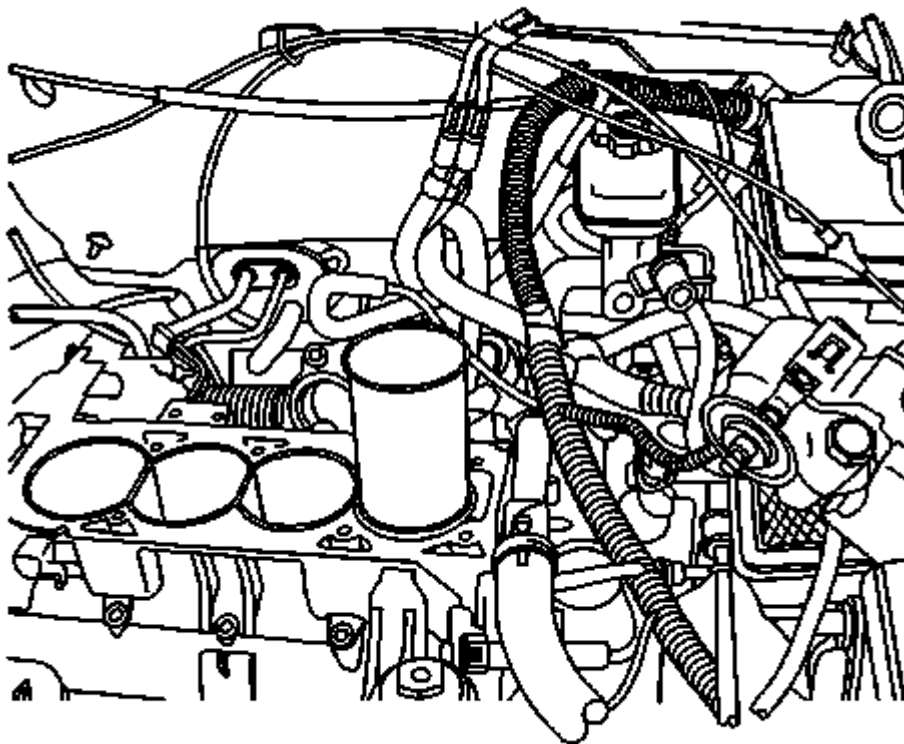


Fig. 195: Cylinder Bore Sleeve

Courtesy of GENERAL MOTORS CORP.

1. Place the NEW cylinder bore sleeve onto the cylinder block.
2. Install fixture EN 45680-851/cylinder bore sleeve installer EN 45680-853 assembly over the cylinder bore sleeve and onto the cylinder block. Do not apply downward pressure to the cylinder bore sleeve.

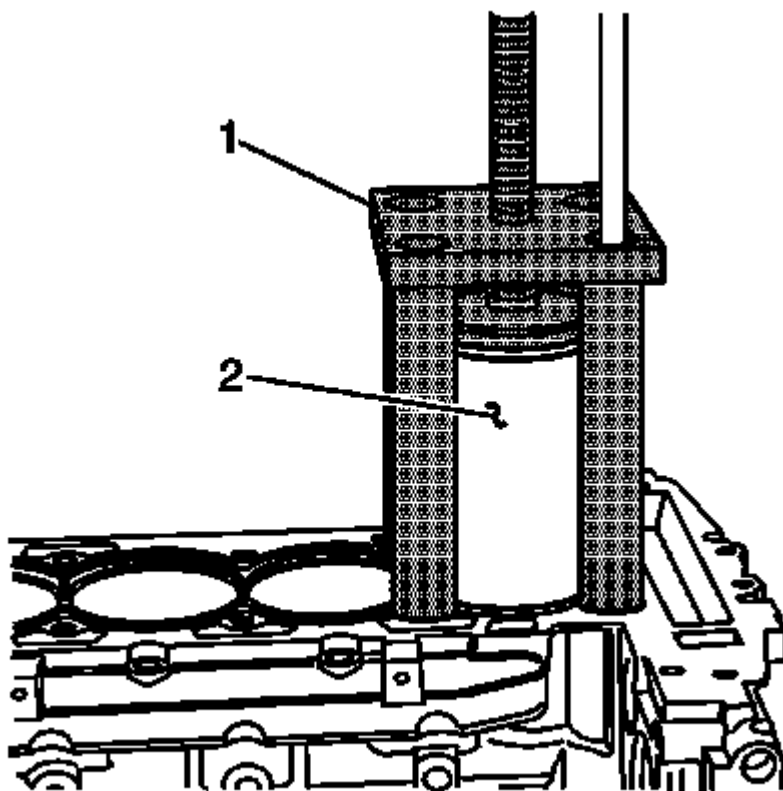


Fig. 196: View Of Cylinder Bore Sleeve Installer
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

IMPORTANT: Use 4 old cylinder head bolts for the attaching bolts.

3. Insert the 4 attachment bolts into the legs of the fixture EN 45680-851 (1). Do not apply downward pressure to the cylinder bore sleeve (2).

Tighten: Tighten the 4 attachment bolts to 15 N.m (11 lb ft).

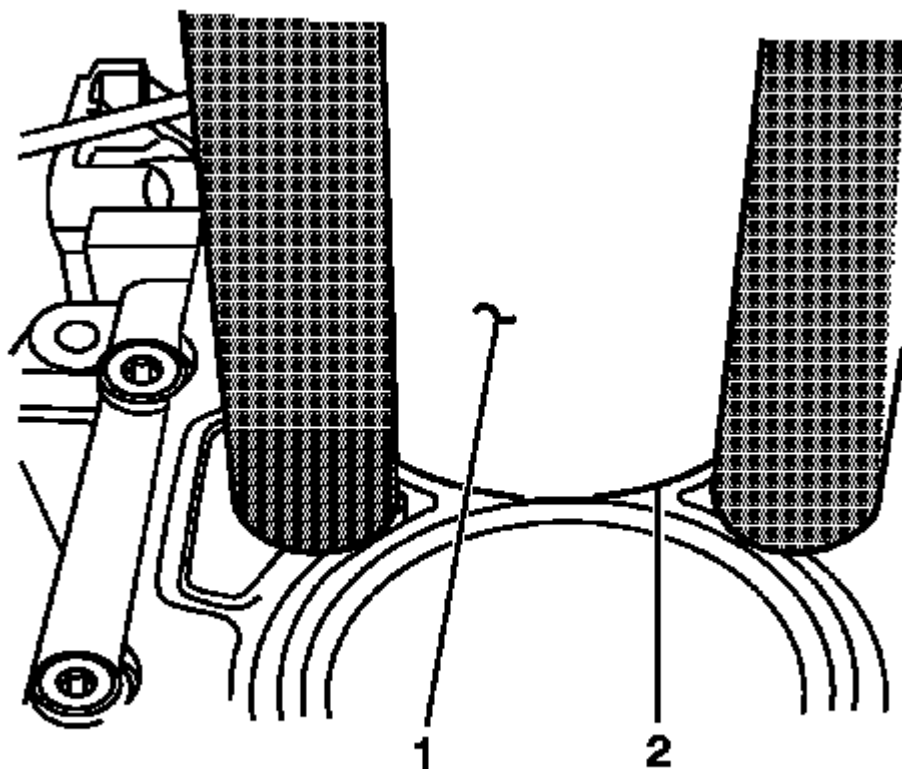


Fig. 197: Aligning Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

4. Align the bottom of the cylinder bore sleeve (1) with the cylinder bore of the block (2).

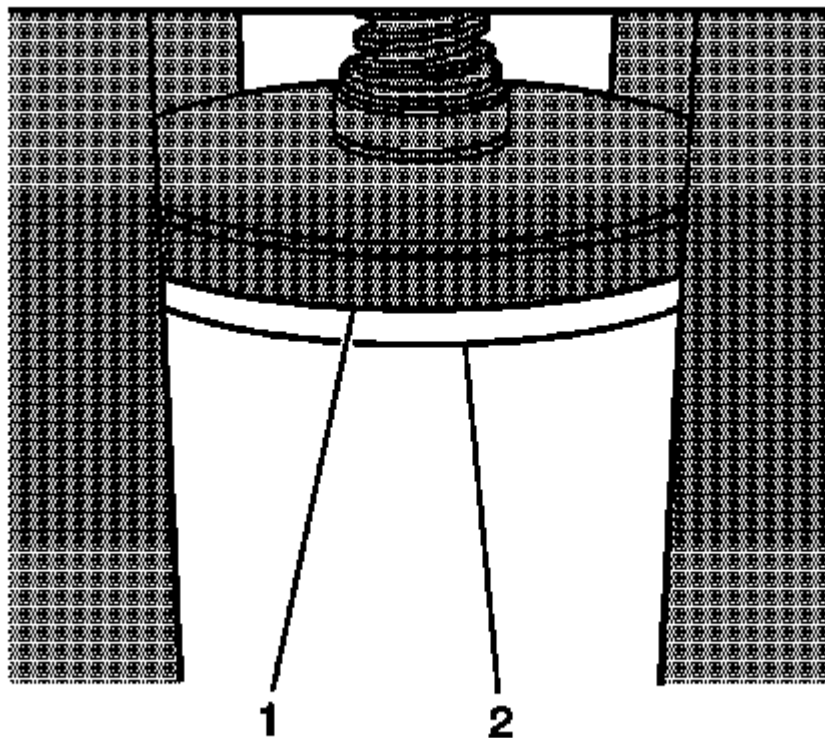


Fig. 198: Aligning Installation Arbor
Courtesy of GENERAL MOTORS CORP.

5. Align the installation arbor (1) onto the top of the cylinder bore sleeve (2).

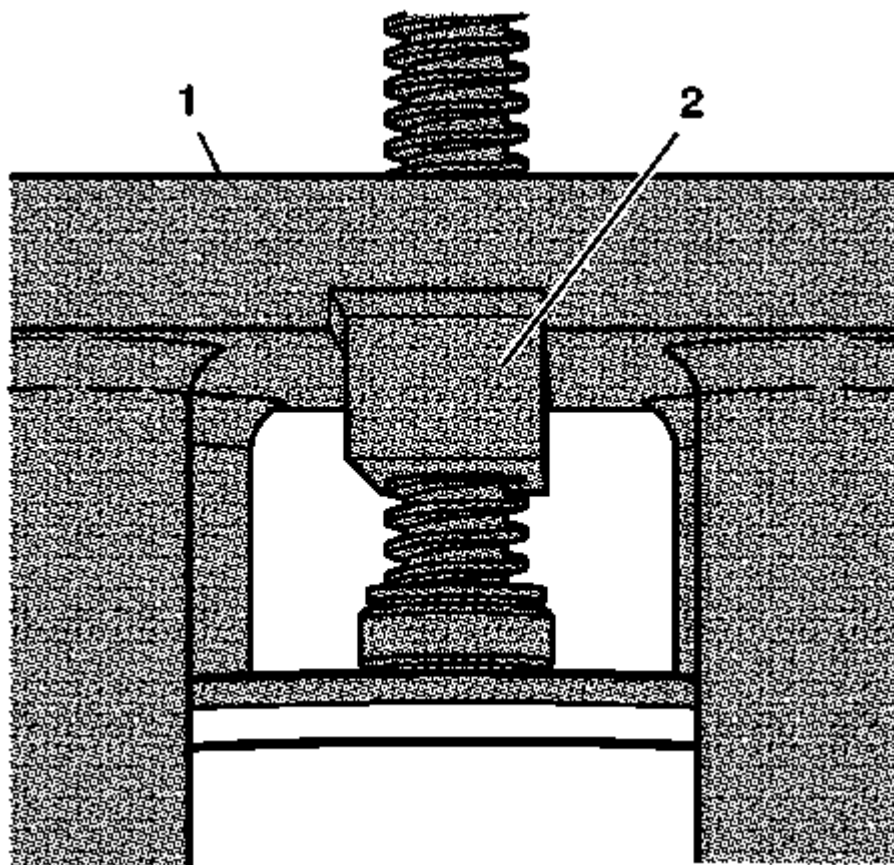


Fig. 199: View Of Pusher Block
Courtesy of GENERAL MOTORS CORP.

6. Align the pusher block (2) of cylinder bore sleeve installer EN 45680-853 into the groove of fixture EN 45680-851 (1).

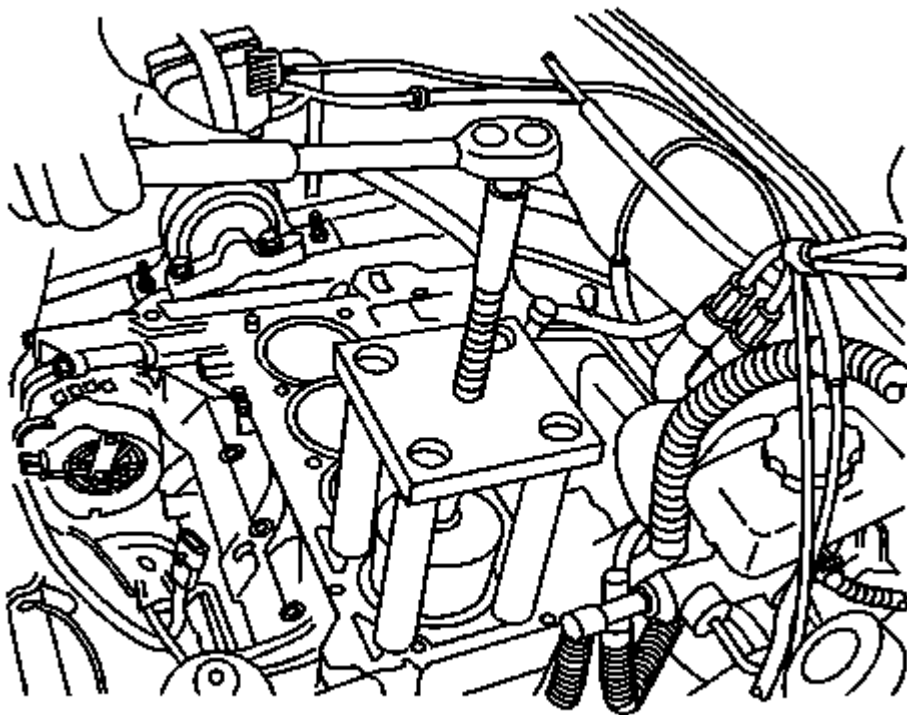


Fig. 200: View Of Cylinder Bore Sleeve Installer Assembly
Courtesy of GENERAL MOTORS CORP.

NOTE: Do not use any air powered or electric tools to rotate the threaded shaft of the fixture EN 45680-851/cylinder bore liner installer EN 45680-853 assembly or damage to the cylinder bore liner will occur.

7. Using a ratchet, rotate the threaded shaft of fixture EN 45680-851/cylinder bore sleeve installer EN 45680-853 assembly in order to install the cylinder bore sleeve into the engine block.
8. Do not completely seat the cylinder bore sleeve in the block. Leave approximately 1/16 inch of the cylinder bore sleeve above the surface of the cylinder block.

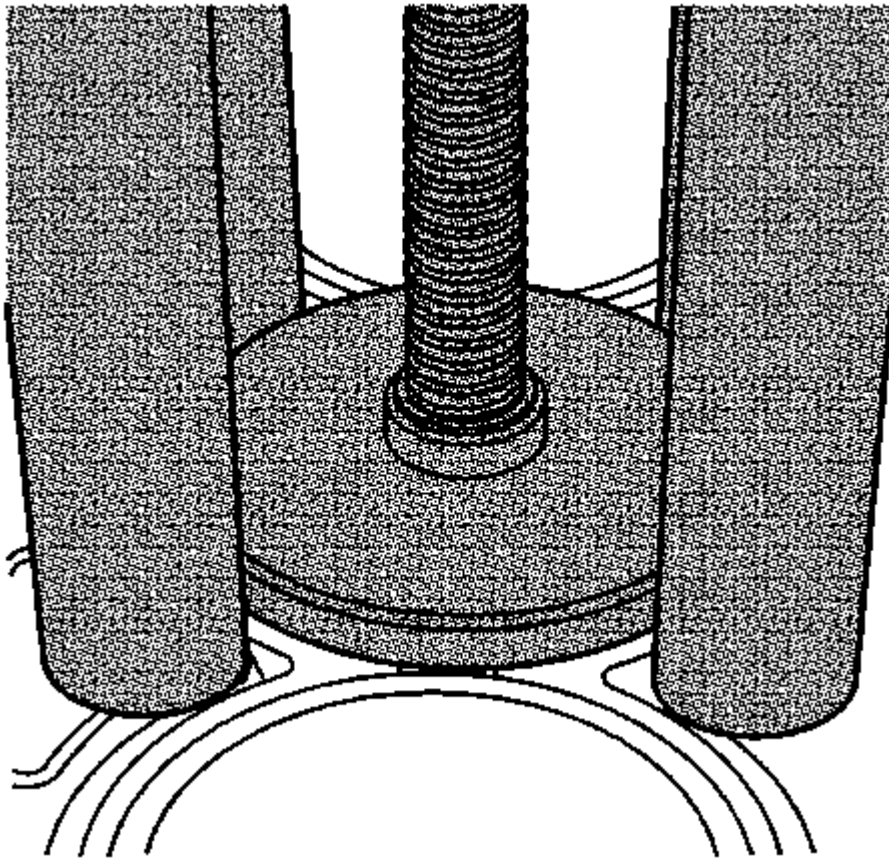


Fig. 201: Seating Cylinder Bore Sleeve Completely Using Tool
Courtesy of GENERAL MOTORS CORP.

9. Using a torque wrench, torque the threaded shaft of the fixture EN 45680-851/cylinder bore sleeve installer EN 45680-853 assembly to 102 N.m (75 lb ft) in order to completely seat the cylinder bore sleeve in the cylinder block. With the cylinder bore sleeve properly installed, a minimal portion of the cylinder bore sleeve flange will protrude above the block deck surface.

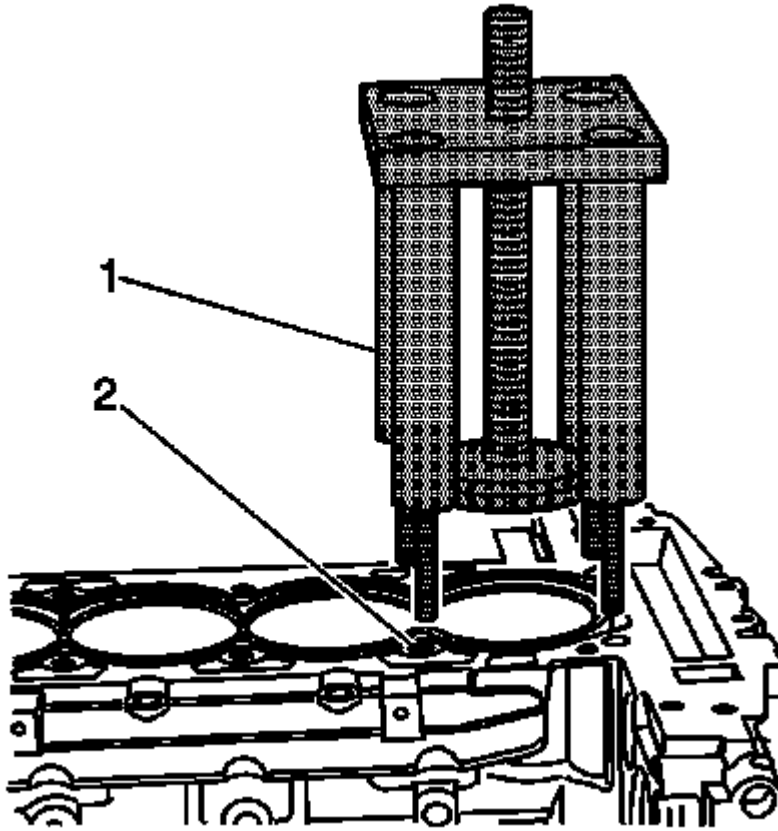


Fig. 202: Identifying Cylinder Bore Sleeve Installer Assembly
Courtesy of GENERAL MOTORS CORP.

10. Remove the fixture EN 45680-851/cylinder bore sleeve installer EN 45680-853 assembly (1) from the cylinder block (2).

Cylinder Liner Trimming

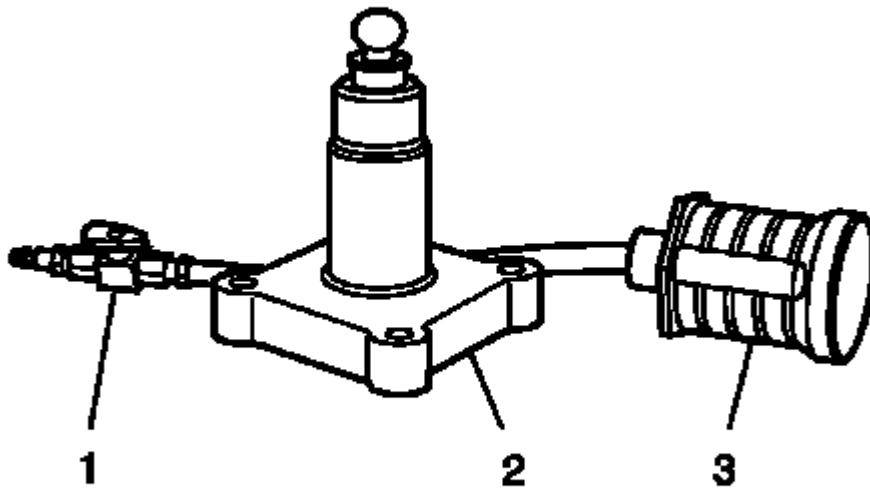


Fig. 203: View Of Cylinder Liner Trimming Tools (1 Of 2)
Courtesy of GENERAL MOTORS CORP.

- EN 45680-865 Debris Collector (3)
- EN 45680-861 Trim Tool Assembly (2)
- Air Control Valve (1)
- Drill Motor with 1/2 inch chuck, 1 1/8 hp, 7 amps, triple gear reduction, and a 450-600 RPM rotational speed in a clockwise direction

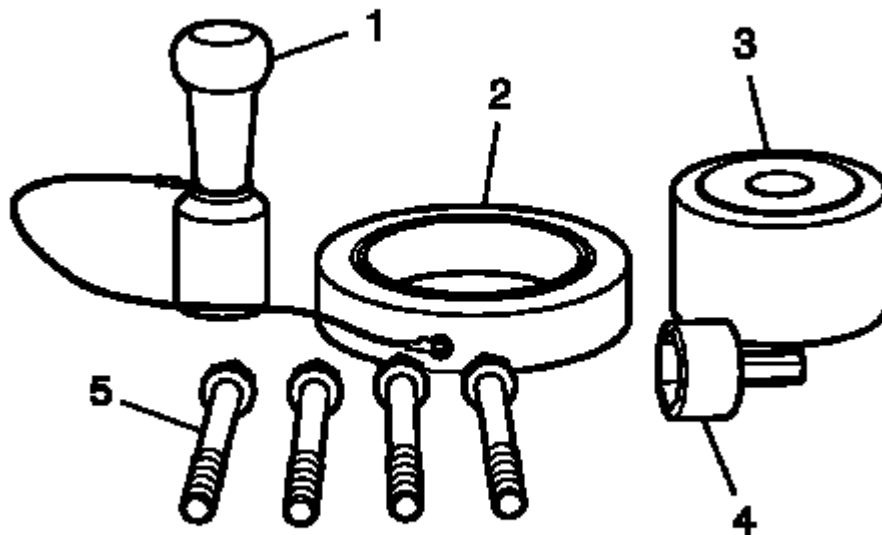


Fig. 204: View Of Cylinder Liner Trimming Tools (2 Of 2)
Courtesy of GENERAL MOTORS CORP.

- Trim Tool Preloader (1)
- EN 45680-862 Set Gage Ring (2)
- EN 45680-863 Metal Shavings Catch Plug (3)
- EN 45680-866 Drive Adapter (4)
- EN 45680-864 Bolts (5)

NOTE: Do not bore or hone the cylinder bore sleeve. The cylinder bore sleeve inside diameter (I.D) is fully machined and honed to size and is optimally finished as shipped. Any attempt to modify this factory-produced sizing and finish with additional boring and honing will lead to engine damage, excessive noise or abnormal oil consumption.

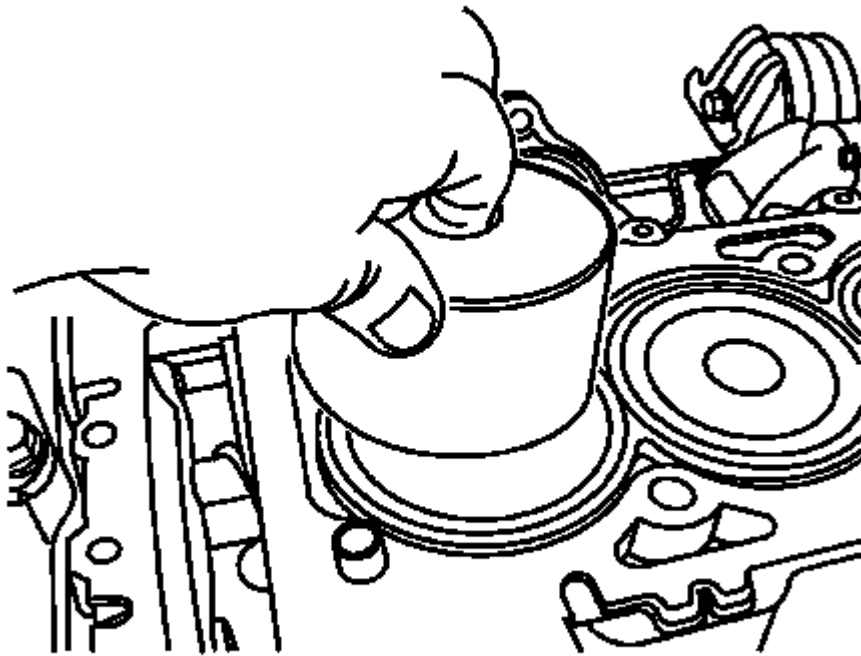


Fig. 205: Placing Metal Shaving Catch Plug EN 45680-863 Into Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

1. After installing the NEW cylinder bore sleeve(s) into the engine block, trim the excess material from the cylinder bore sleeve flange.

NOTE: **Ensure that all the metal particles are collected in order to prevent internal damage to the engine or bearings.**

2. Place metal shaving catch plug EN 45680-863 into the cylinder bore sleeve to be trimmed. Position the top of the EN 45680-863 approximately 3.0 mm (0.12 in) below the top surface of the cylinder bore sleeve.
3. Place additional metal shaving catch plugs EN 45680-863 into all remaining cylinder bore sleeves.

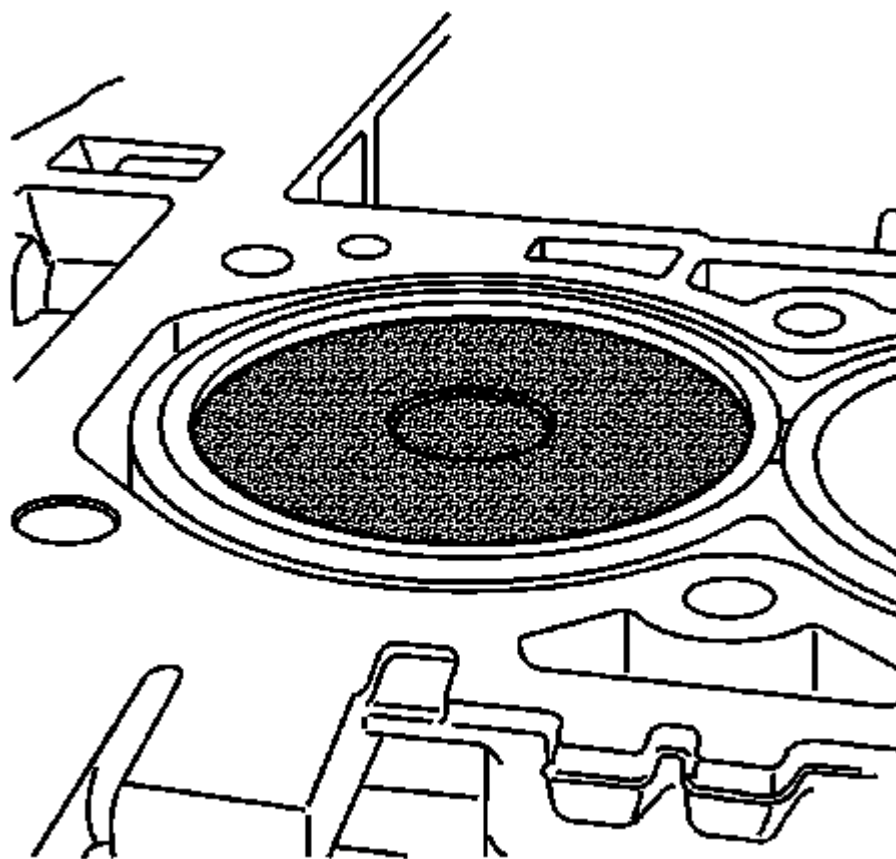


Fig. 206: Identifying Catch Plug Positioning
Courtesy of GENERAL MOTORS CORP.

NOTE: Installing the metal shaving catch plug EN 45680-863 deeper than the recommended depth will create a decrease in vacuum system performance. A decrease in vacuum system performance will cause metal shavings to enter the engine and cause engine failure.

NOTE: Installing the metal shaving catch plug EN 45680-863 above the recommended depth will cause damage to the metal shaving catch plug EN 45680-863.

4. Ensure that the metal shaving catch plug EN 45680-863 is 3.0 mm (0.12 in) below the top surface of the cylinder bore sleeve.

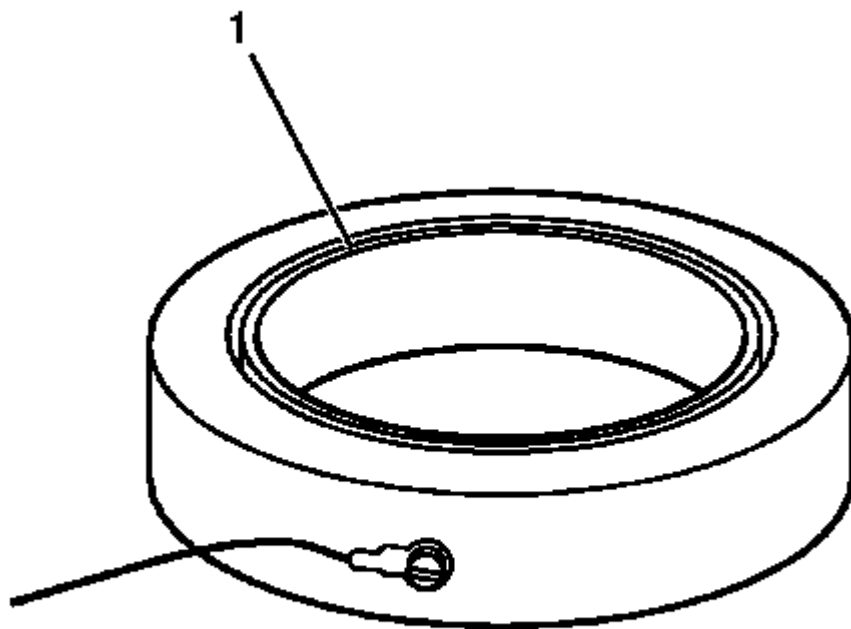


Fig. 207: Identifying Set Gauge Ring Groove
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Before using trim tool assembly EN 45680-861, the height of the cutting blades must be set to the proper specification. The proper specification is that the cylinder bore liner flange must be flush to $+0.02$ mm (0.0008 in) above the block deck surface.

5. The groove side of the set gage ring EN 45680-862 (1) should be positioned upward on a flat surface.

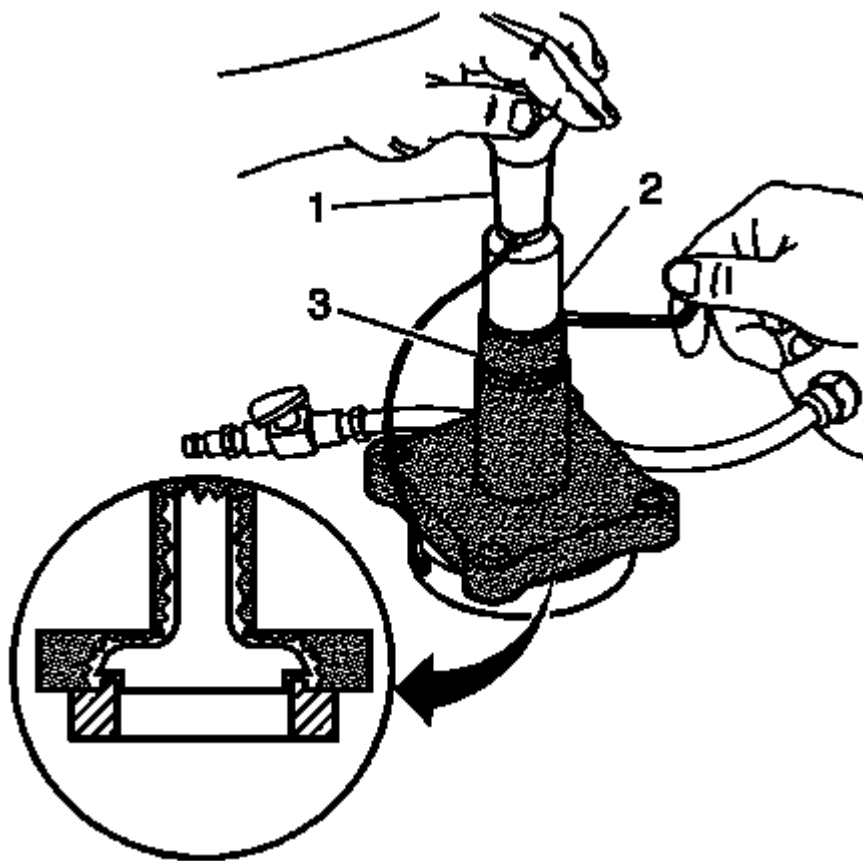


Fig. 208: View Of Trim Tool Assembly Components And Positioning
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Ensure that the set gage ring EN 45680-862 surfaces are clean.

6. Carefully position trim tool assembly EN 45680-861 onto the set gage ring EN 45680-862.
7. Loosen the shaft collar screw (2).
8. Push the shaft collar (2) downward using the trim tool preloader (1) until the shaft collar is positioned against the top of the flange bearing (3).

IMPORTANT: Once this procedure is done, it is not necessary to reset the trim tool assembly EN 45680-861 height until the blades are worn or damaged.

9. Apply downward pressure on the collar and inner drive shaft using the trim tool preloader (1), then tighten the shaft collar screw.

Tighten: Tighten the shaft collar screw to 19 N.m (14 lb ft).

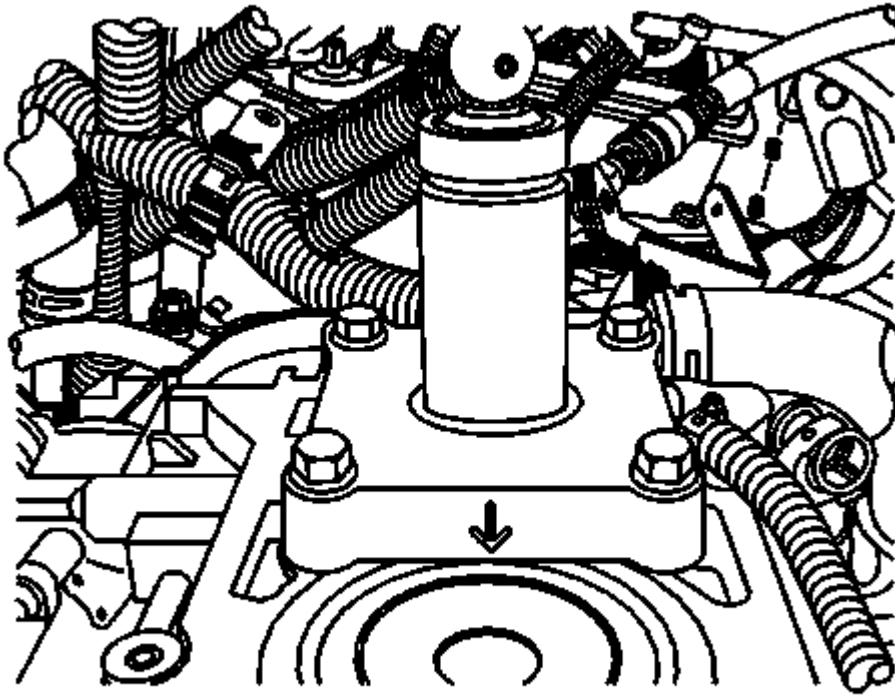


Fig. 209: Aligning Trim Tool Assembly
Courtesy of GENERAL MOTORS CORP.

10. Place trim tool assembly EN 45680-861 onto the cylinder to be trimmed with the directional arrow pointing in line with the crankshaft centerline and the front of the block.
11. Install the 4 bolts EN 45680-864 into the cylinder head bolt holes in the block.

Tighten: Tighten the bolts to 20 N.m (15 lb ft).

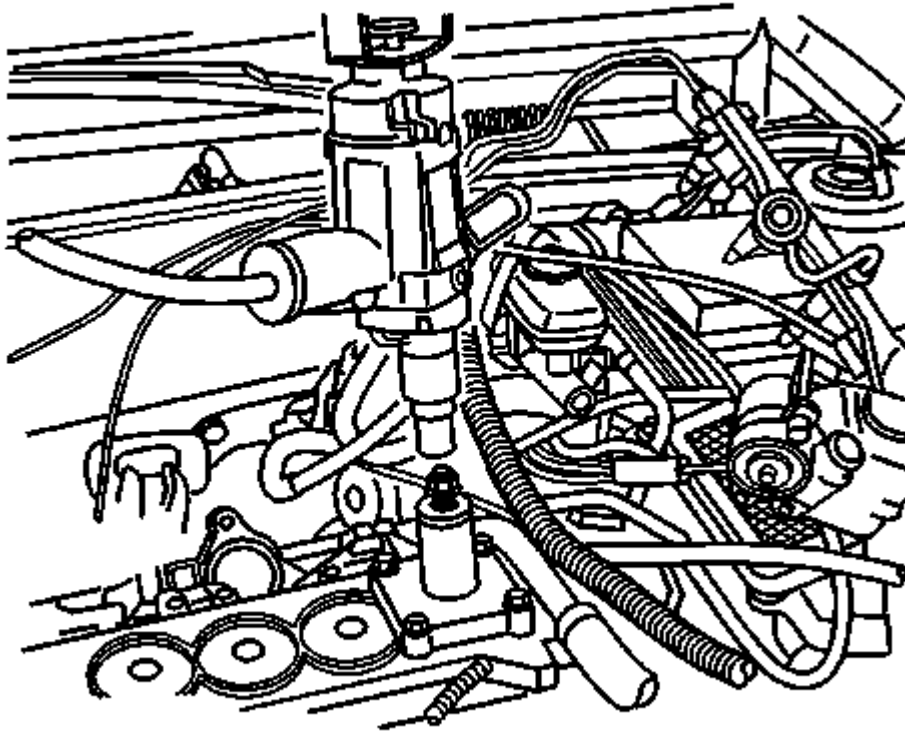


Fig. 210: Identifying EN 45680-866

Courtesy of GENERAL MOTORS CORP.

NOTE: For proper tool operation, a drill motor with a 1/2 inch chuck, 1 1/8 hp, 7 amps, triple gear reduction, and a 450-600 RPM rotational speed in a clockwise direction must be used. If the proper drill motor is not used, damage to the cylinder bore sleeve will occur.

12. Fasten drive adapter EN 45680-866 into the drill chuck.

NOTE: Ensure that there are no crimps in the air feed hose or the vacuum hose. Crimps in the hose may cause metal shavings to exit the cutting tool in any direction, causing engine damage.

13. Connect a compressed air supply (75-125 psi) to the male quick connect located on trim tool assembly EN 45680-861. Turn the compressed air valve to the open position. This starts the venturi vacuum system that will catch the metal shavings.
14. Place drive adapter EN 45680-866 and drill assembly vertically onto the drive adapter end of trim tool assembly EN 45680-861. Do not apply downward force on the drill until full rotational speed has been reached. After reaching full rotational speed, gradually apply downward force until the cutting action is complete in approximately 5 seconds.

15. Remove drive adapter EN 45680-866 (1) and drill assembly from the trim tool assembly EN 45680-861.
16. Turn OFF the compressed air valve.
17. Remove trim tool assembly EN 45680-861 from the engine block.
18. Wipe the cylinder bore sleeve and surrounding areas free of any powder residue and then remove the metal shaving catch plug EN 45680-863.

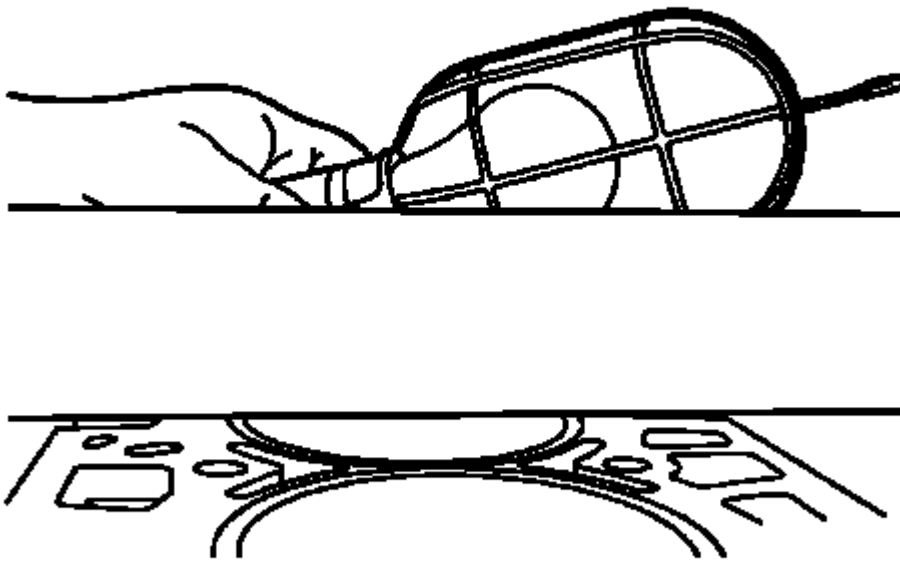


Fig. 211: Checking Cylinder Block Deck Surface With Straight Edge
Courtesy of GENERAL MOTORS CORP.

19. Install a straight edge on the cylinder block perpendicular to the crankshaft center line.
20. Using a light, illuminate the backside of the straight edge.

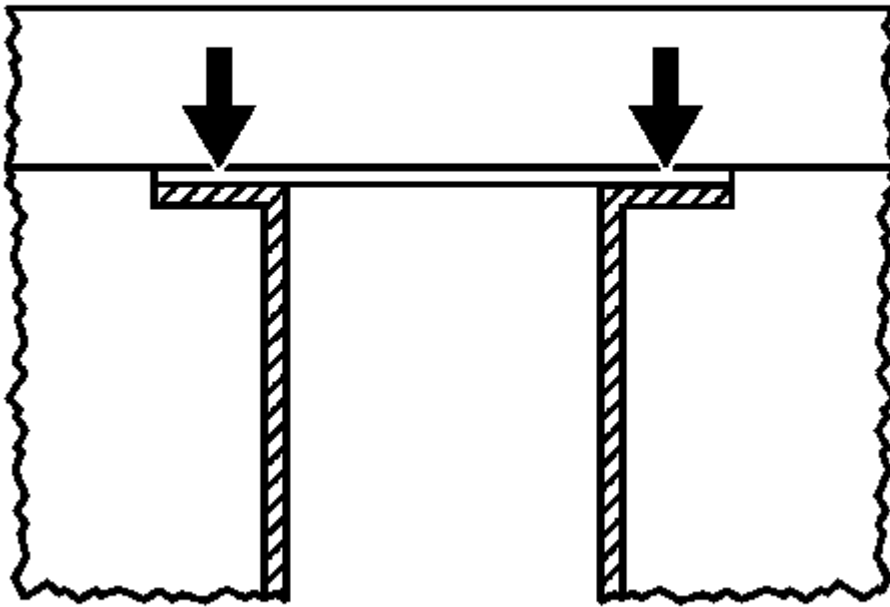


Fig. 212: View Of Improperly Cut Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

21. Looking at the front of the straight edge, check to see if light is protruding through the bottom of the straight edge and the top of the cylinder bore sleeve flange. If light is present on either side or both sides of the cylinder bore sleeve, the cylinder bore sleeve is cut incorrectly and a new cylinder bore sleeve needs to be installed.

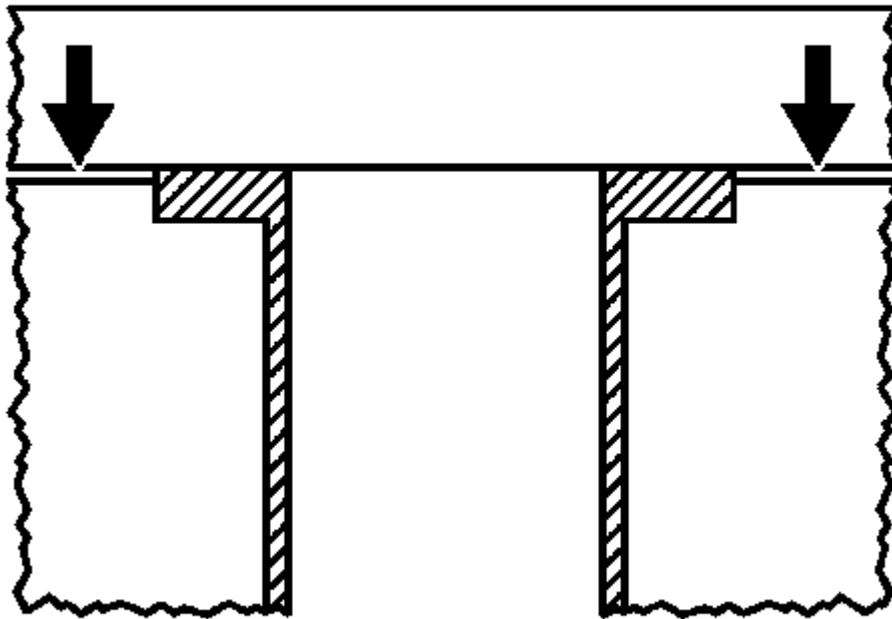


Fig. 213: View Of For Properly Cut Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

22. Looking at the front of the straight edge, check to see if light is protruding through the bottom of the straight edge and the top of the cylinder block deck surface. If light is present on both sides of the cylinder block, the cylinder bore sleeve is cut correctly.
23. Proceed to the next bore sleeve to be trimmed repeating steps 10-19 if necessary.
24. Install the piston and connecting rod. Refer to **Piston, Connecting Rod, and Bearing Replacement**.

ENGINE FLYWHEEL REPLACEMENT

Removal Procedure

1. Remove the transmission. Refer to **Transmission Replacement** for the manual transmission or **Transmission Replacement** for the automatic transmission.

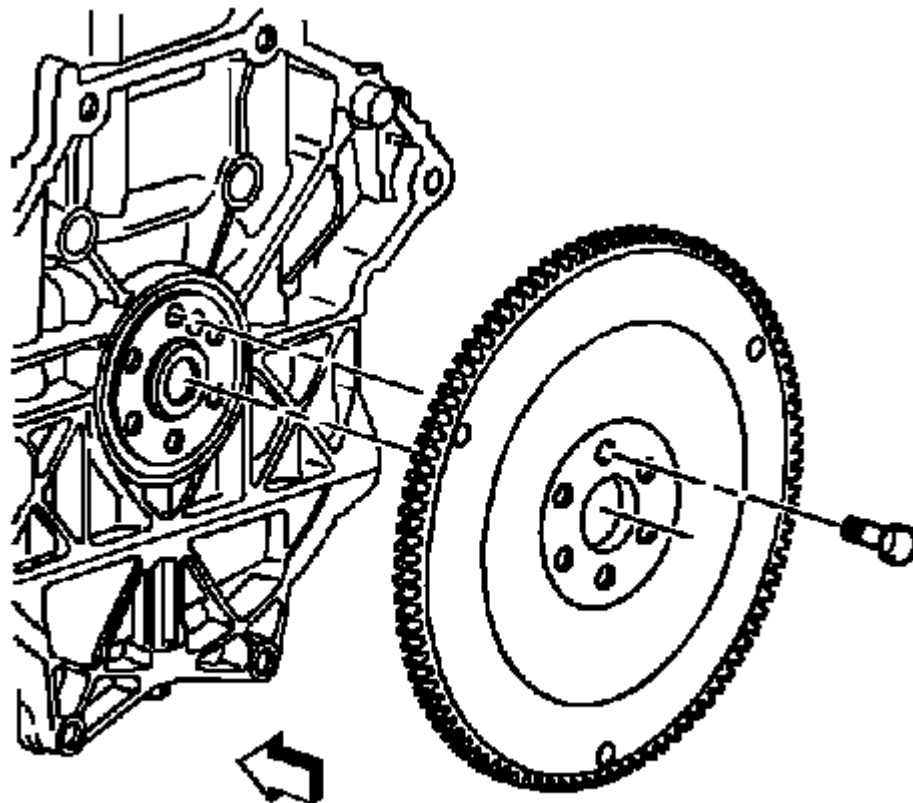


Fig. 214: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

2. Remove the flywheel.

Installation Procedure

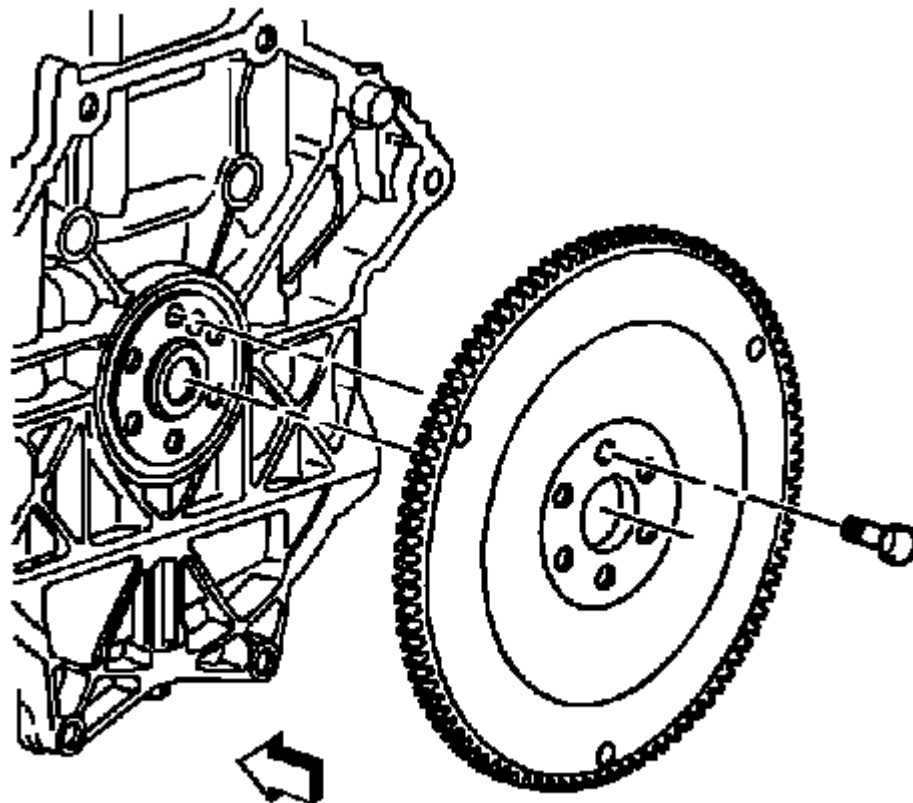


Fig. 215: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

1. Install the flywheel.

Tighten: Tighten the flywheel bolts to 53 N.m (39 lb ft) plus 25 degrees.

2. Install the transmission. Refer to **Transmission Replacement** for the manual transmission or to **Transmission Replacement** for the automatic transmission.

CRANKSHAFT REAR OIL SEAL REPLACEMENT

Tools Required

J 42067 Rear Main Seal Installer

Removal Procedure

1. Remove the transmission. Refer to **Transmission Replacement** for the M86/N94 Getrag transmission or **Transmission Replacement** for the 4T40-E/4T45-E transmission.

2. Remove the flywheel.

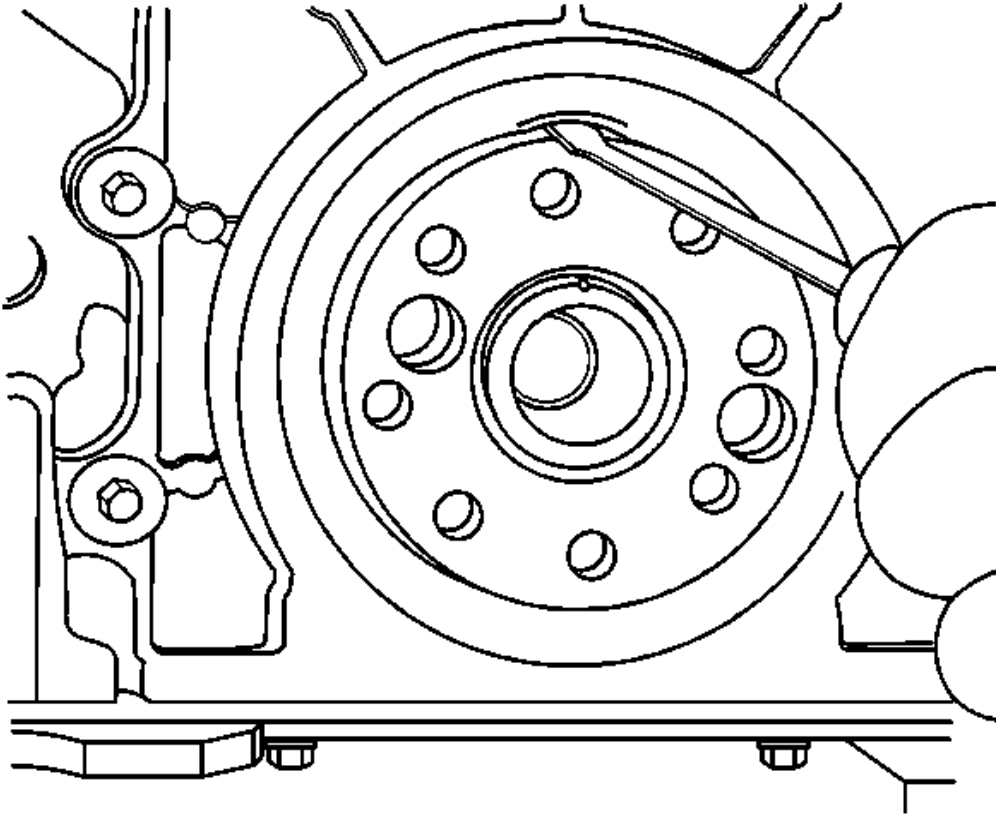


Fig. 216: View Of Crankshaft Rear Oil Seal
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Make sure not to damage the outside diameter of the crankshaft or chamber with any tool.

3. Pry the crankshaft rear oil seal with a flat-bladed tool.

Installation Procedure

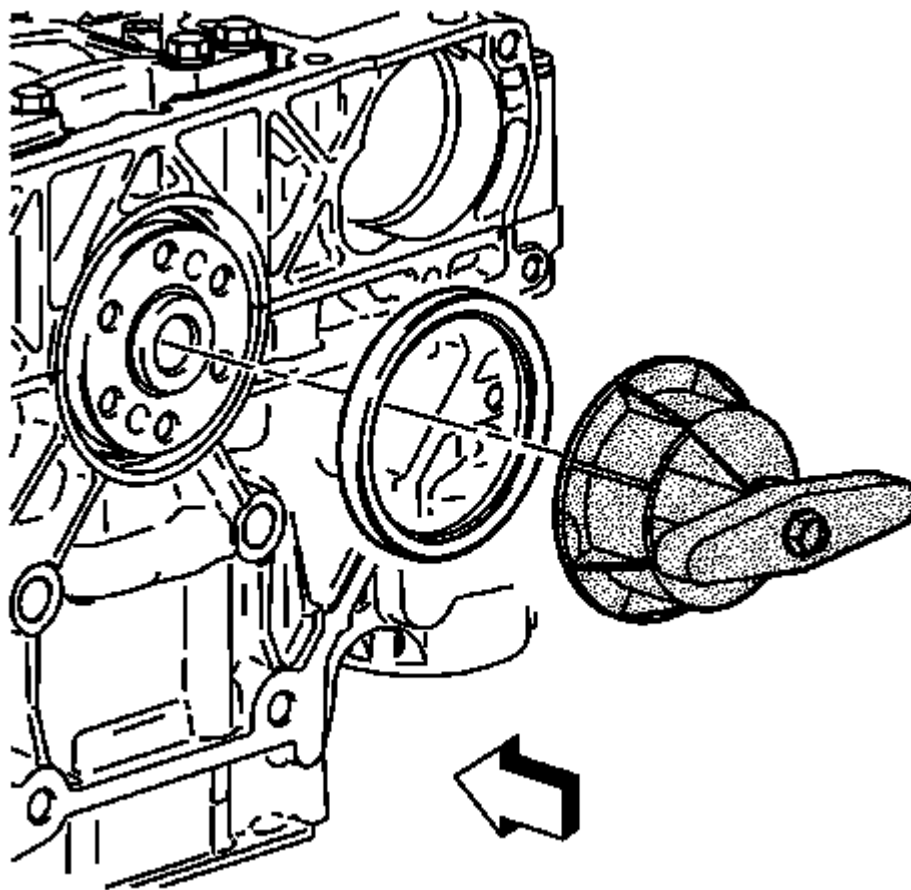


Fig. 217: Installing Crankshaft Rear Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Use the **J 42067** and install the seal.

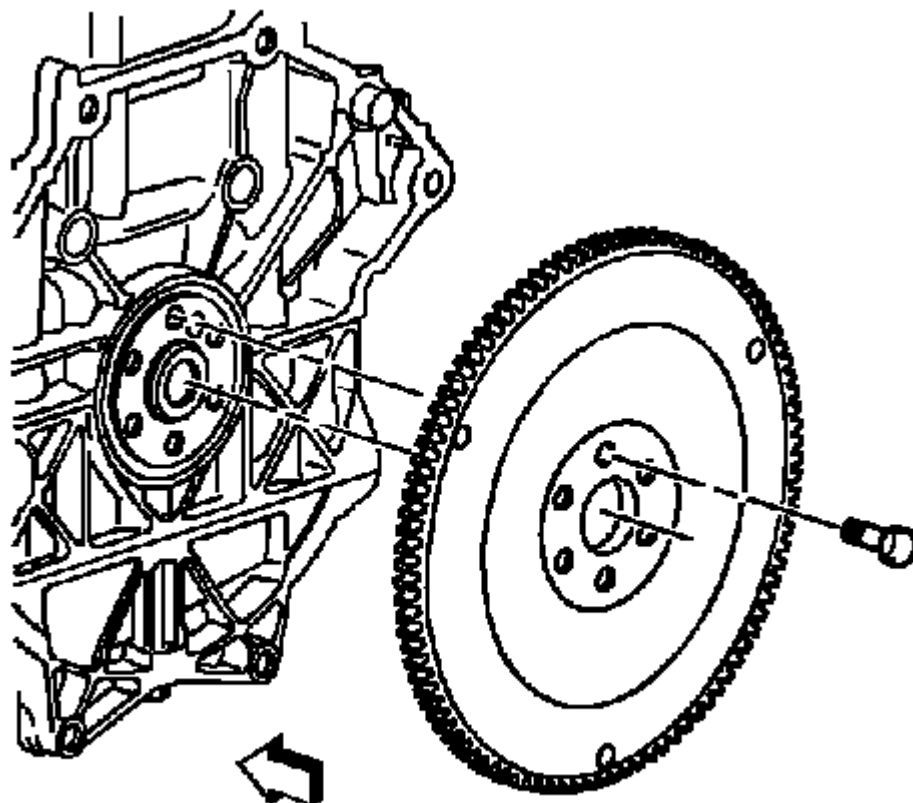


Fig. 218: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

2. Install the flywheel.

Tighten: Tighten the flywheel bolts to 53 N.m (39 lb ft) plus 25 degrees.

3. Install the transmission. Refer to **Transmission Replacement** for the M86/N94 Getrag transmission or **Transmission Replacement** for the 4T40-E/4T45-E transmission.

ENGINE REPLACEMENT

Removal Procedure

1. With the tires in the straight forward position, remove the key from the ignition.
2. Disconnect the negative battery cable. Refer to **Battery Negative Cable Disconnection and Connection** .
3. Remove the air inlet duct and resonator. Refer to **Air Cleaner Outlet Resonator Replacement** .

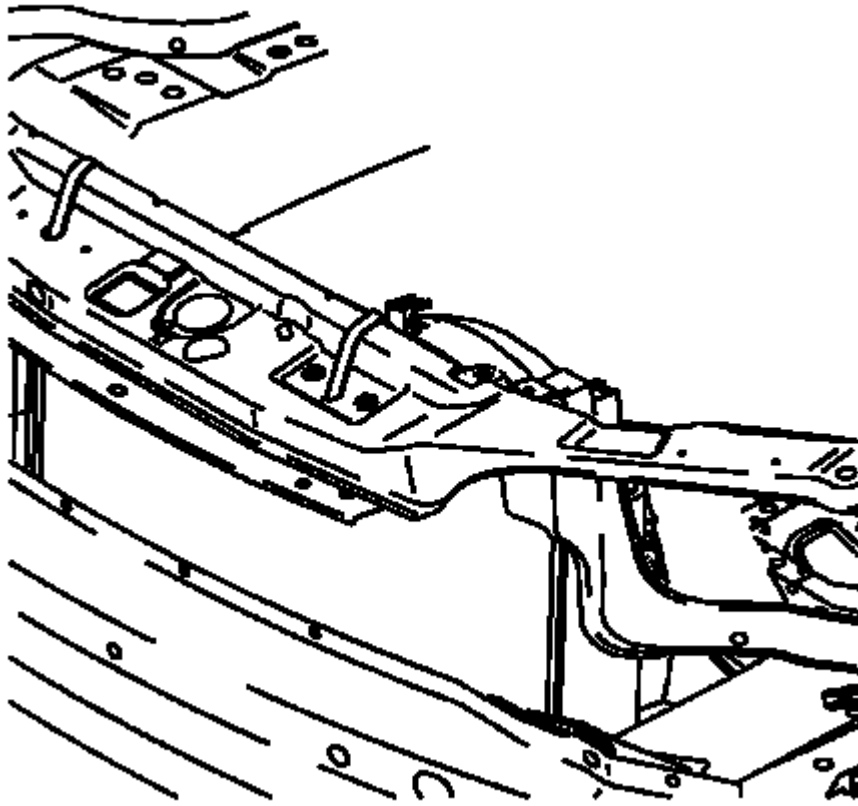


Fig. 219: Cooling Module Secured To Upper Body Structure
Courtesy of GENERAL MOTORS CORP.

4. Secure the cooling module to the upper body structure.
5. Relieve the fuel system pressure. Refer to **Fuel Pressure Relief (Without CH 48027)** or **Fuel Pressure Relief (With CH 48027)** .
6. Disconnect the fuel line from the fuel rail. Refer to **Metal Collar Quick Connect Fitting Service** .
7. Drain the cooling system. Refer to **Cooling System Draining and Filling (GE 47716 Fill)** or **Cooling System Draining and Filling (Static Fill LE5, L61)** .
8. Remove the radiator inlet hose. Refer to **Radiator Inlet Hose Replacement (LE5, L61)** .
9. Remove the surge tank to cylinder head hose. Refer to **Radiator Surge Tank Inlet Hose/Pipe Replacement (LE5, L61)** and **Radiator Surge Tank Outlet Hose/Pipe Replacement (LE5, L61)** .
10. Remove the radiator outlet hose. Refer to **Radiator Outlet Hose Replacement (LE5, L61)** .

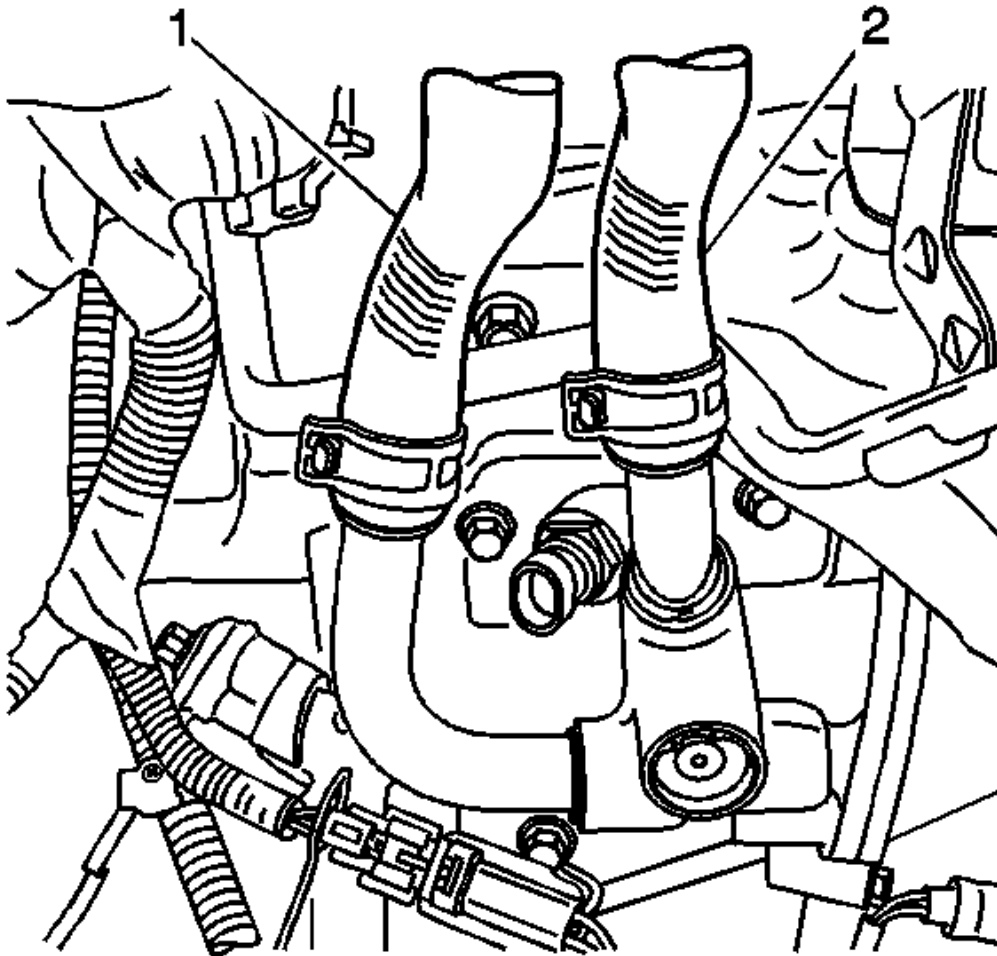


Fig. 220: View Of Inlet & Outlet Heater Hose
Courtesy of GENERAL MOTORS CORP.

11. Remove the inlet (1) and outlet (2) heater hoses. Refer to **Heater Inlet Hose Replacement (L61, LE5)** and **HEATER OUTLET HOSE REPLACEMENT (L61, LE5)** .

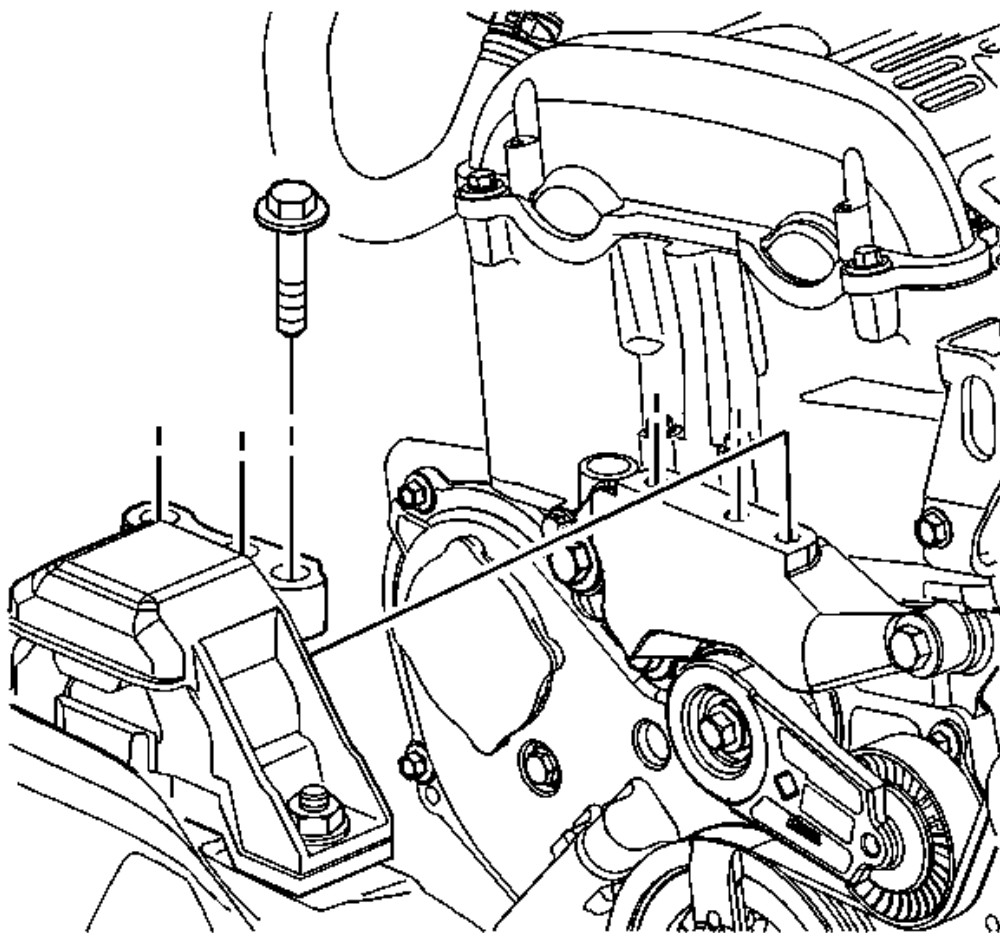


Fig. 221: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

12. Disconnect the following harness connectors:

- Idle air control (IAC) motor
- Temperature position sensor (TPS)
- Manifold absolute pressure (MAP) sensor
- Crankshaft sensor
- Oil pressure sensor
- Purge solenoid
- Ignition coil and module assembly
- Oxygen (O2) sensor

- Vehicle speed sensor
 - Engine temperature sensor
 - Backup lamp switch
13. Raise and suitably support the vehicle. Refer to **Lifting and Jacking the Vehicle**.
 14. Remove the engine drive belt. Refer to **Drive Belt Replacement**.
 15. Remove the A/C compressor bolts and set the compressor aside.

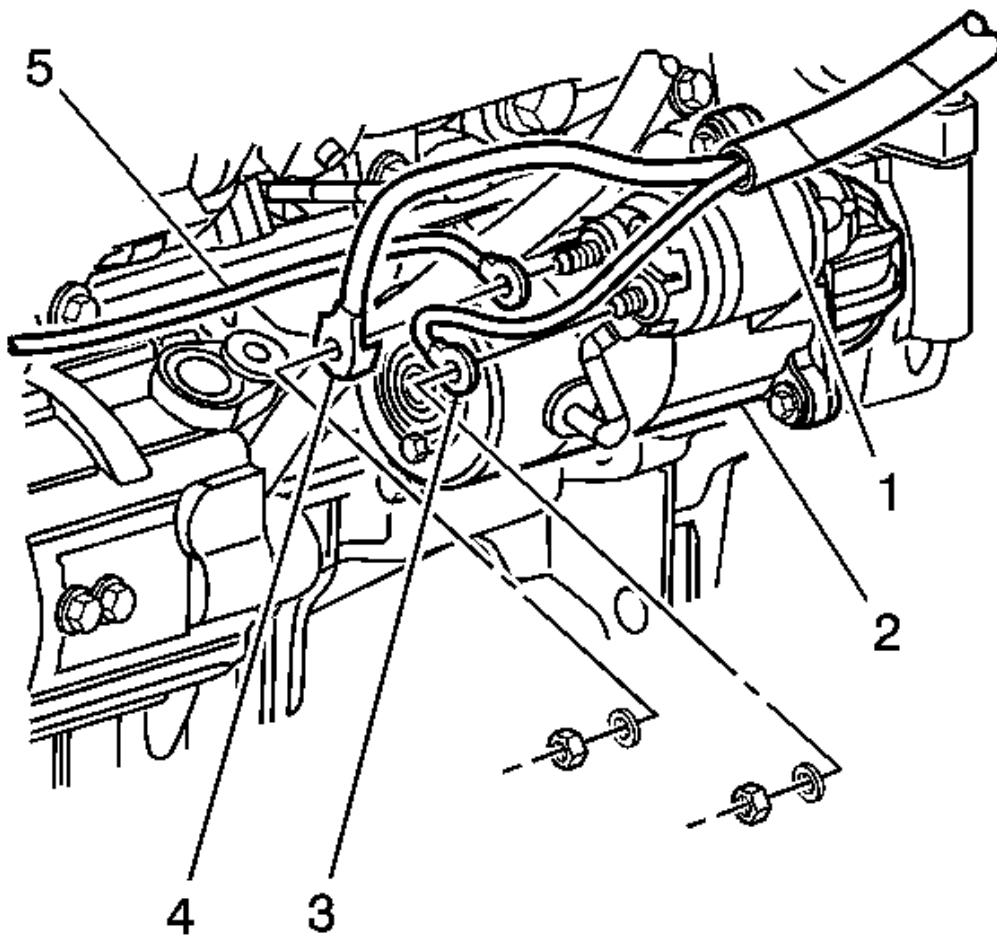


Fig. 222: Identifying Starter Electrical Connectors
Courtesy of GENERAL MOTORS CORP.

16. Disconnect the starter harness connectors (3, 4, 5).
17. Disconnect the generator harness connectors.

18. Drain the engine oil.
19. Disconnect the front exhaust pipe from the exhaust manifold. Refer to **EXHAUST MANIFOLD REPLACEMENT (L61)**.
20. Disconnect the transmission harness connectors.
21. Disconnect the transmission shift cable from the transmission.
22. Use blocks of wood to support the powertrain assembly between the frame and the powertrain.
23. Remove the engine mount. Refer to **Engine Mount Replacement**.

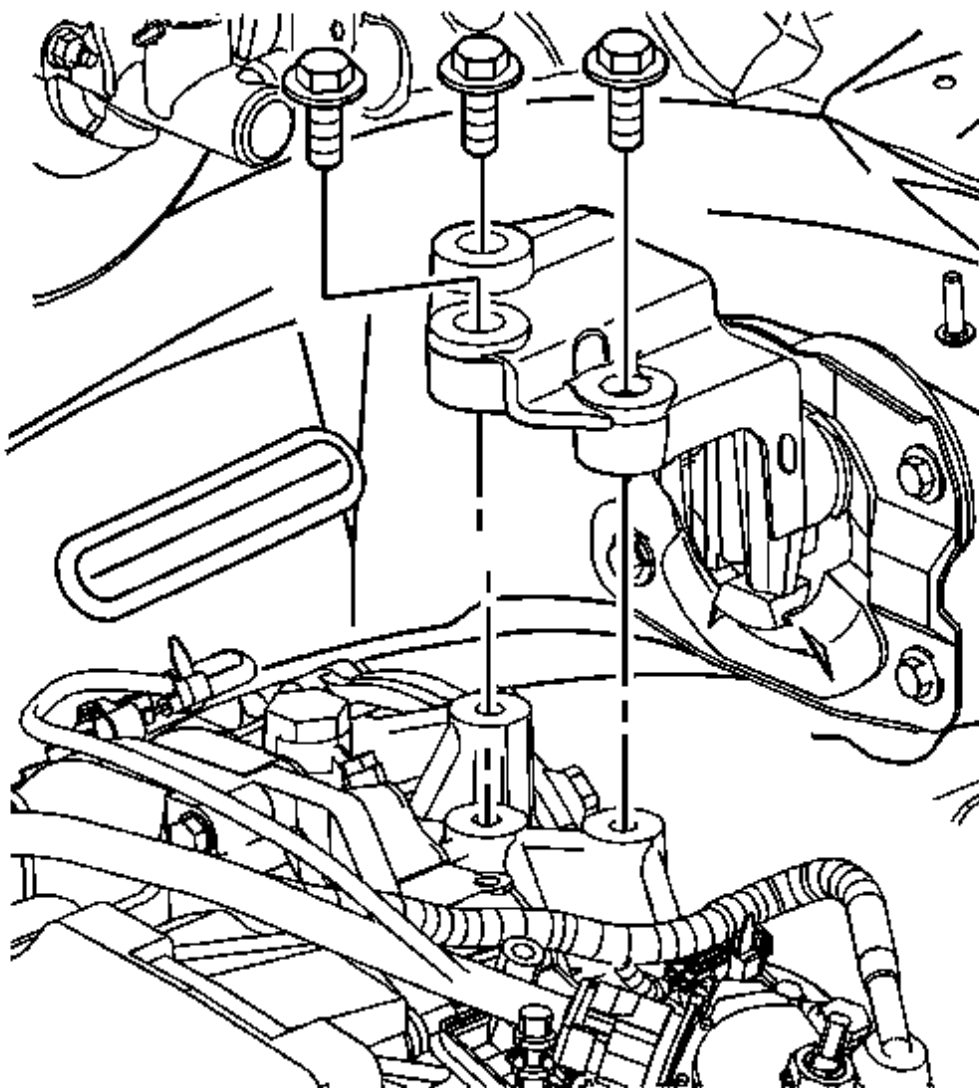


Fig. 223: View Of Side Transmission Mount
Courtesy of GENERAL MOTORS CORP.

24. Remove the side transmission mount. Refer to the appropriate procedure:
- **Transmission Mount Replacement - Left Side** for the 4T45-E transaxle
 - **Transmission Mount Replacement - Left Side** for the MU3 transaxle
 - **Transmission Mount Replacement - Left Side** for the Getrag 5-speed transmission

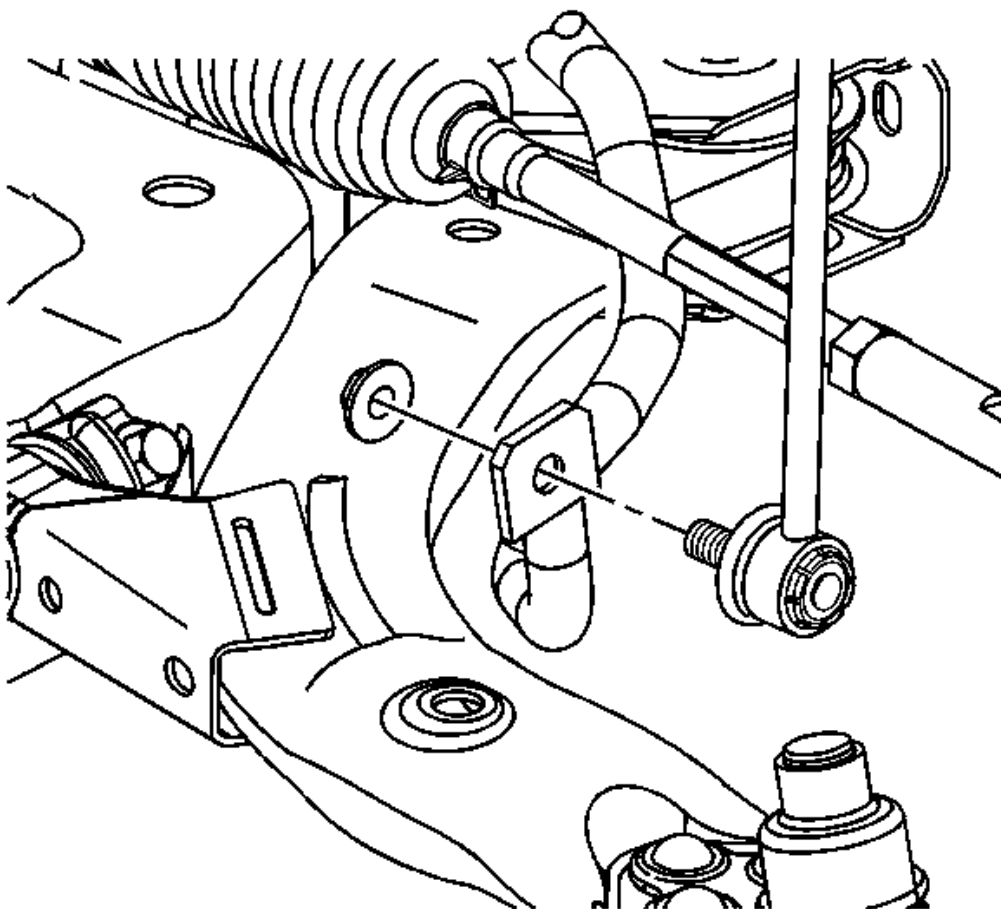


Fig. 224: View Of Stabilizer Link At Stabilizer Shaft
Courtesy of GENERAL MOTORS CORP.

25. Disconnect the stabilizer links from the stabilizer bar. Refer to **Stabilizer Shaft Link Replacement** .

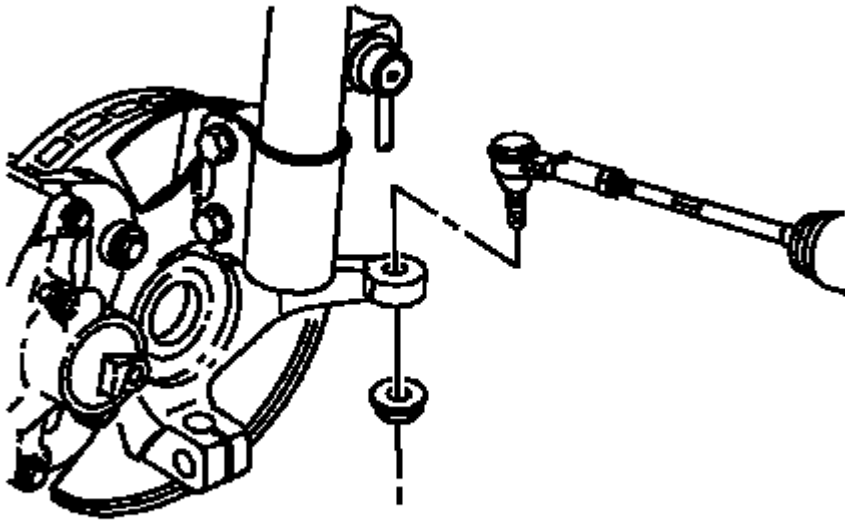


Fig. 225: View Of Tie Rod End & Steering Knuckle
Courtesy of GENERAL MOTORS CORP.

26. Disconnect the outer tie rod ends from the steering knuckles. Refer to **Rack and Pinion Outer Tie Rod End Replacement** .

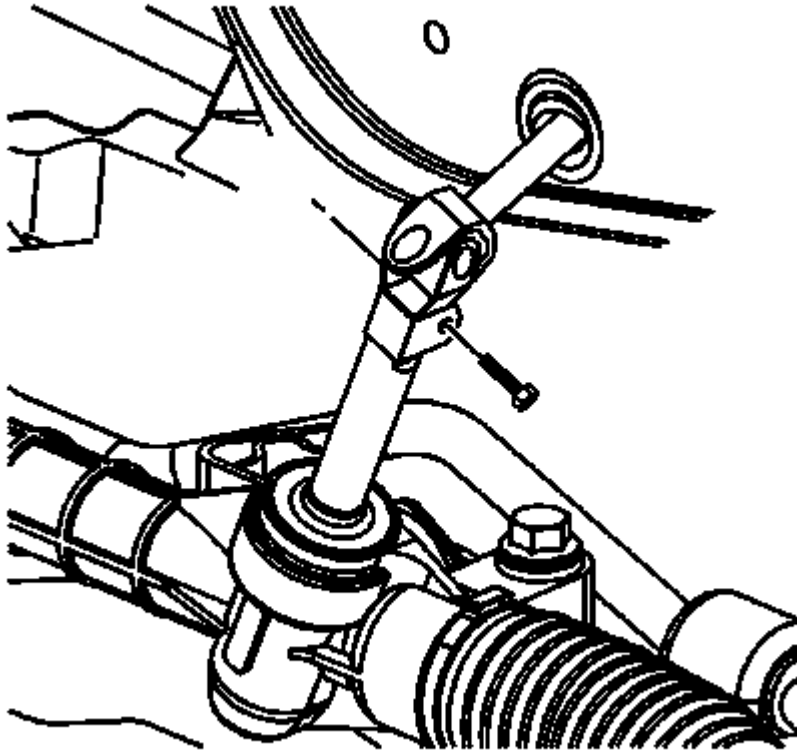


Fig. 226: View Of Intermediate Shaft-To-Steering Gear Pinch Bolt
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: In order to prevent possible SIR system deployment, do not attempt to rotate the steering shaft.

27. Disconnect the intermediate shaft from the steering gear. Refer to **Intermediate Steering Shaft Replacement** .

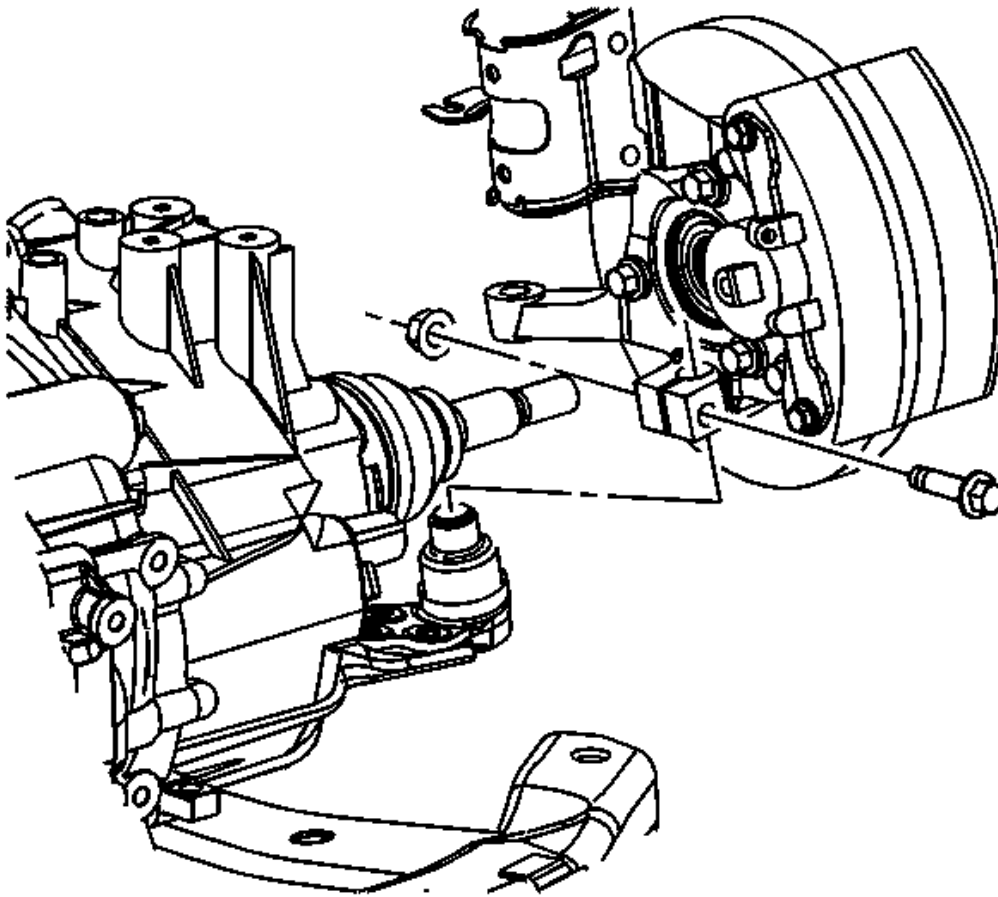


Fig. 227: Identifying Lower Control Arm Ball Stud-To-Steering Knuckle Pinch Bolt
Courtesy of GENERAL MOTORS CORP.

28. Disconnect the lower control arms from the steering knuckles. Refer to **Lower Control Arm Replacement** .

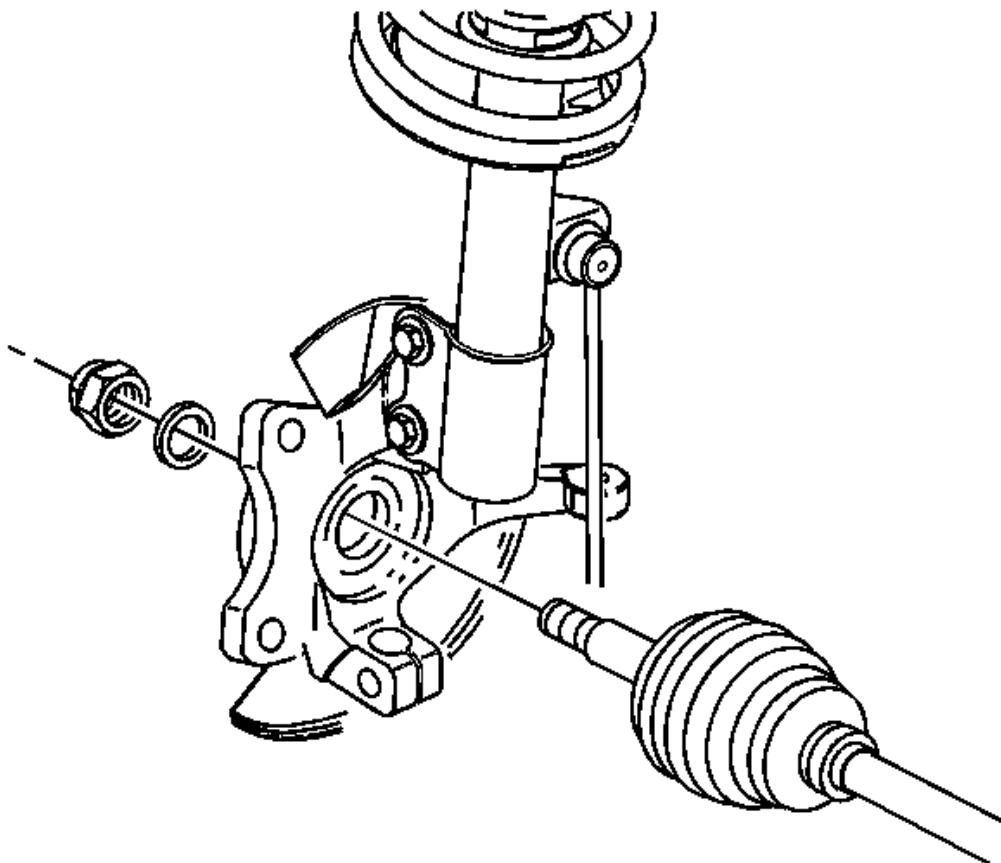


Fig. 228: View Of Drive Axle & Steering Knuckle
Courtesy of GENERAL MOTORS CORP.

29. Disconnect the drive axles from the steering knuckle. Refer to **Wheel Drive Shaft Replacement** .
30. Use a paint pen or magic marker in order to mark the frame to body position.
31. Lower the vehicle to about 1 m (3 ft) off the ground in order to position the lift table under the frame.
32. Use wood blocks as necessary between the lift table and the frame to support the assembly.
33. Slowly remove the frame bolts using the following sequence:
 1. Remove the front frame bolts.
 2. Partially unscrew the rear frame bolts until 4 cm (1.5 in) of bolt shank is exposed.
34. Slowly lower the table to the floor with the cradle and powertrain assembly.
35. Attach the engine lift hoist to the engine lift hooks.

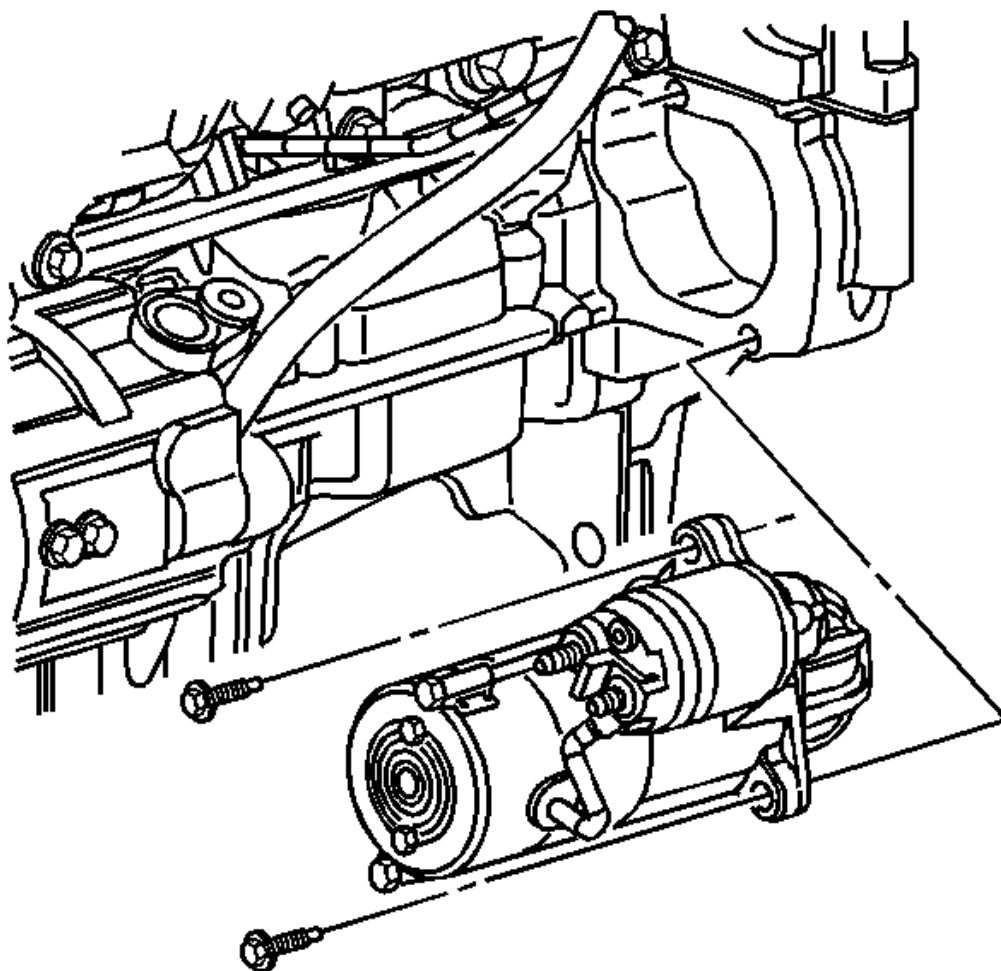


Fig. 229: View Of Starter
Courtesy of GENERAL MOTORS CORP.

36. Remove the starter.
37. If applicable, remove the torque converter to flywheel bolts.
38. Remove the transmission to engine bolts.
39. Separate the engine from the transmission.
40. If applicable, remove the clutch pressure plate and disk.
41. Remove the following components:
 - Exhaust manifold
 - Exhaust manifold studs

- Engine mount bracket
- Engine block heater
- Thermostat housing and feed pipe
- Generator

42. Remove the engine from the engine lift.

Installation Procedure

1. Attach the engine lift hoist to the engine lift hooks.
2. Install the following components:
 - Exhaust manifold-Refer to **EXHAUST MANIFOLD REPLACEMENT (L61)** .
 - Engine mount bracket-Refer to **Engine Mount Bracket Replacement - Right Side**.
 - Fuel rail-Refer to **Fuel Injection Fuel Rail Assembly Replacement** .
 - Engine block heater, if equipped-Refer to **Coolant Heater Replacement** .
 - Drive belt tensioner-Refer to **Drive Belt Tensioner Replacement**.
 - Thermostat housing and feed pipe-Refer to **ENGINE COOLANT THERMOSTAT REPLACEMENT (L61)** .
 - Generator-Refer to **Generator Replacement** .
 - Flywheel-Refer to **Engine Flywheel Replacement**.
3. If applicable, install the clutch pressure plate and disk.
4. Align the engine to the transmission.

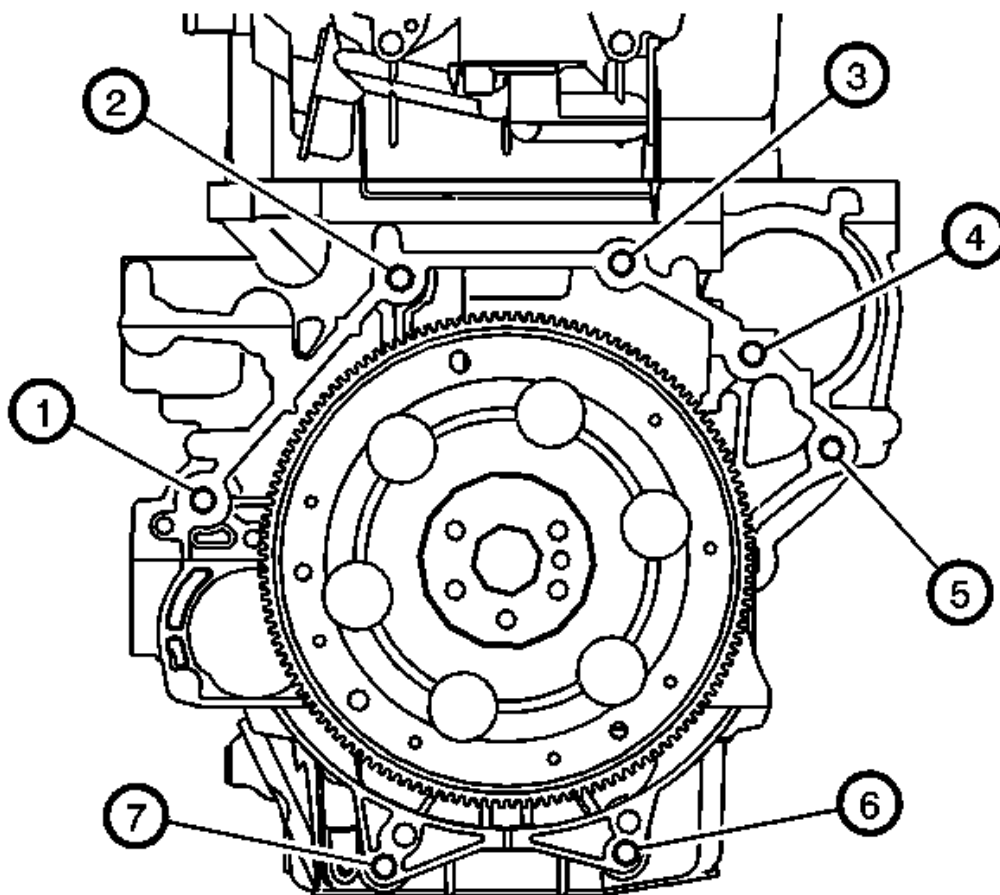


Fig. 230: Identifying Engine-To-Transmission Bolt Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

IMPORTANT: The number 3 bolt location is not used.

5. Secure the engine to the transmission.

Tighten: Tighten the transmission to engine bolts to 75 N.m (55 lb ft).

6. If applicable, install the torque converter bolts.

Tighten: Tighten the bolts to 60 N.m (44 lb ft).

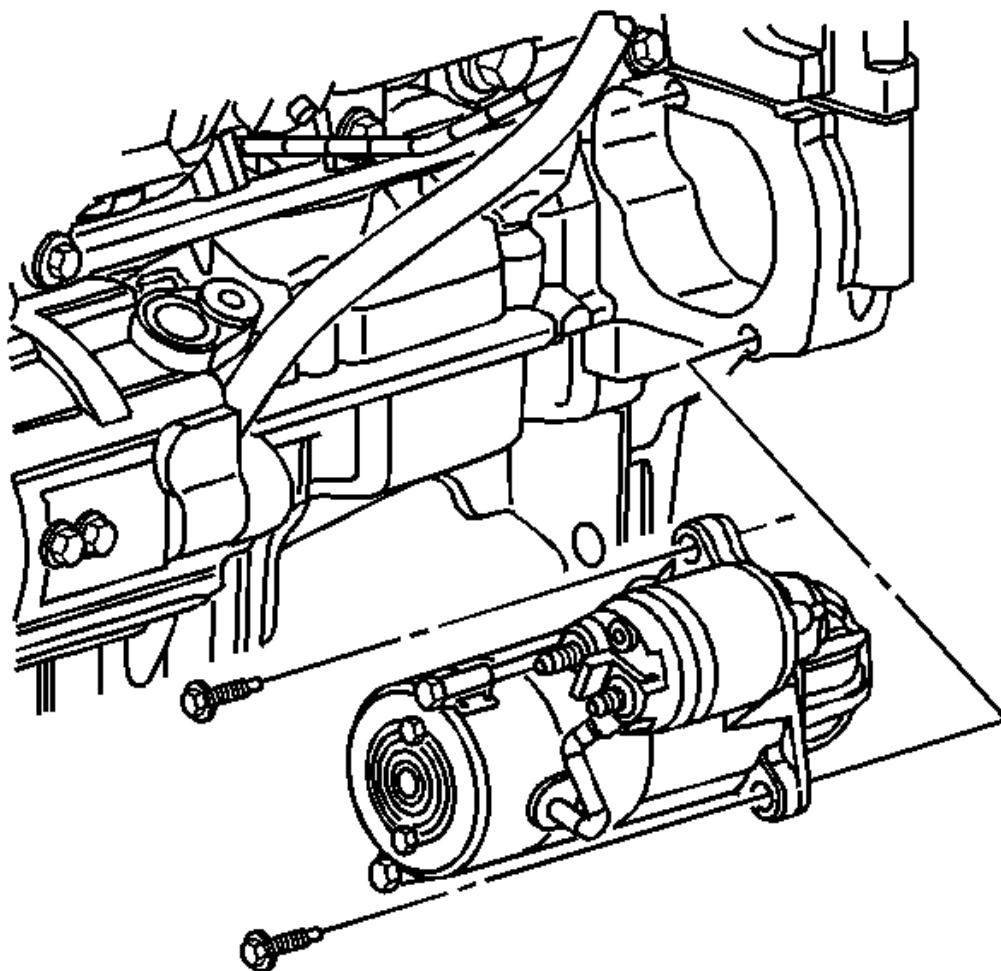


Fig. 231: View Of Starter
Courtesy of GENERAL MOTORS CORP.

7. Install the starter. Refer to **Starter Motor Replacement** .
8. Remove the engine lift from the engine.
9. Raise and position the frame and powertrain assembly to the vehicle.
10. Hand start all the frame bolts while aligning the frame to the paint marks.
11. Tighten the frame bolts.

Tighten: Tighten the frame bolts to 100 N.m (74 lb ft plus 180 degrees).

12. Remove the lift table.

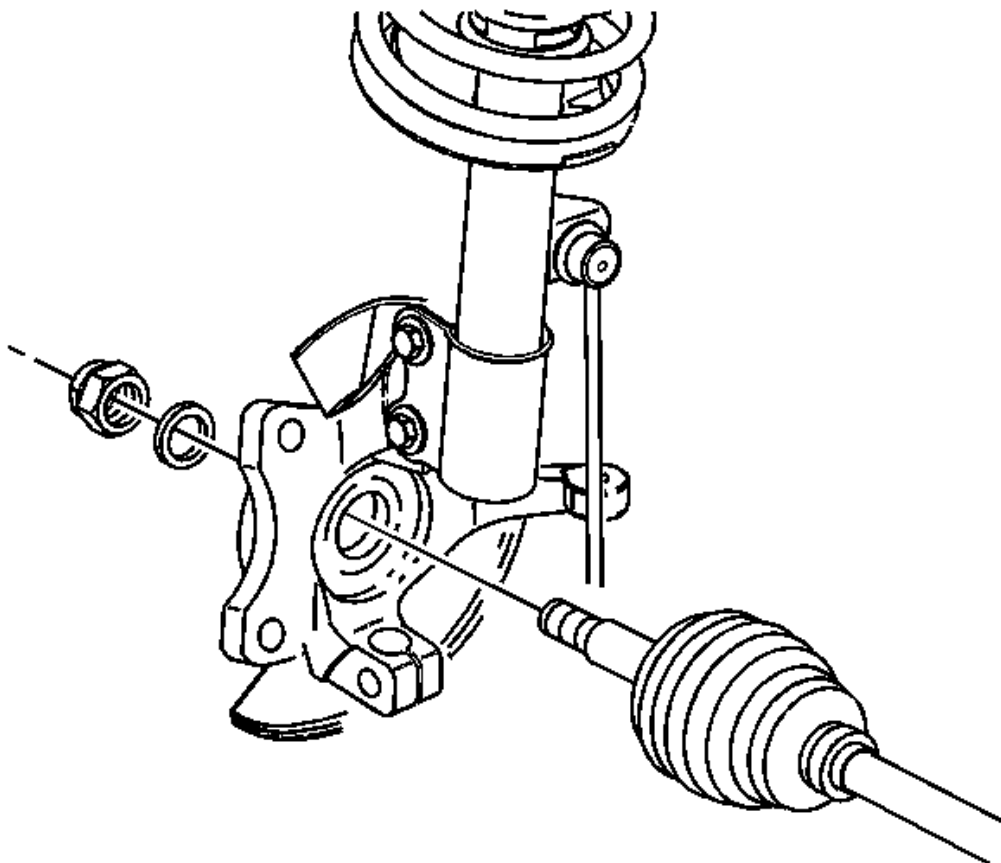


Fig. 232: View Of Drive Axle & Steering Knuckle
Courtesy of GENERAL MOTORS CORP.

13. Connect the drive axles to the steering knuckles. Refer to **Wheel Drive Shaft Replacement** .

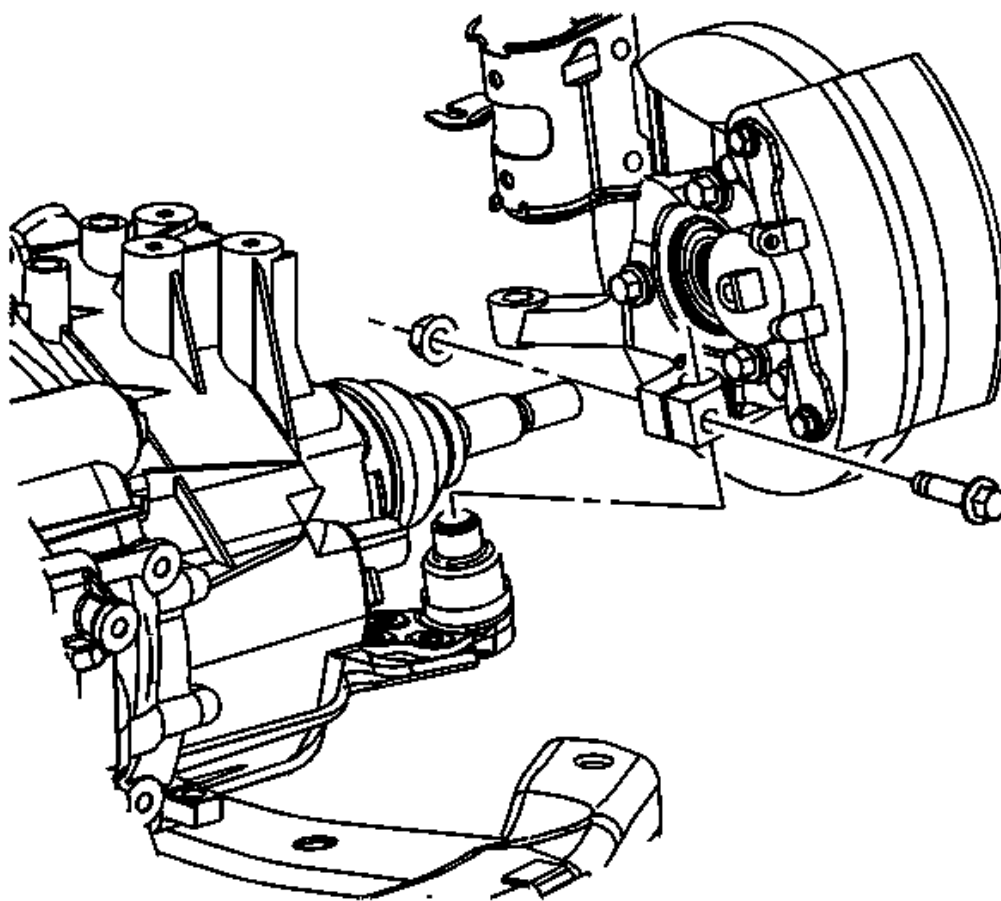


Fig. 233: Identifying Lower Control Arm Ball Stud-To-Steering Knuckle Pinch Bolt
Courtesy of GENERAL MOTORS CORP.

14. Connect the lower control arm to the steering knuckle. Refer to **Lower Control Arm Replacement** .

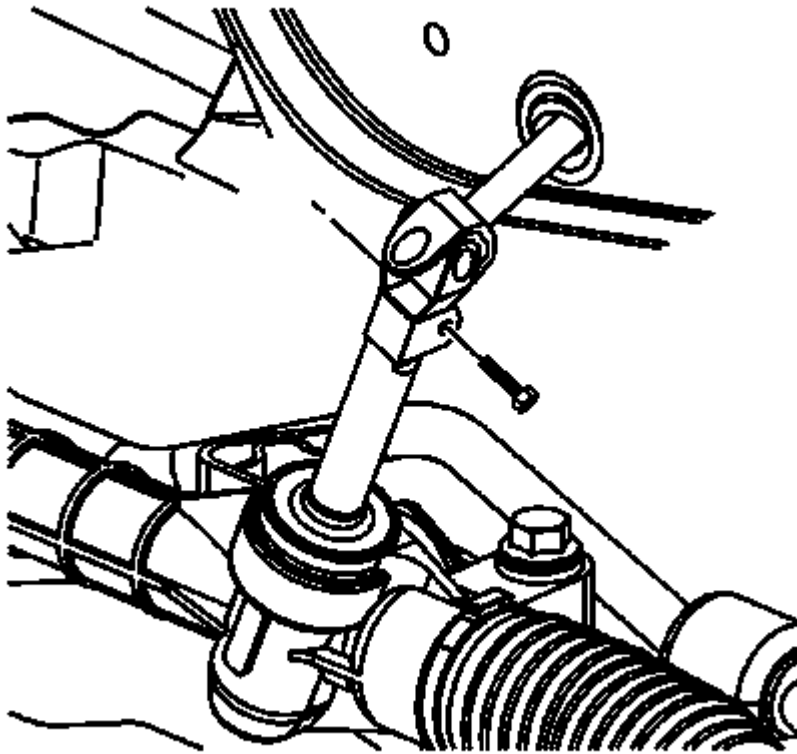


Fig. 234: View Of Intermediate Shaft-To-Steering Gear Pinch Bolt
Courtesy of GENERAL MOTORS CORP.

15. Connect the intermediate steering shaft to the steering gear. Refer to **Steering Gear Replacement** .

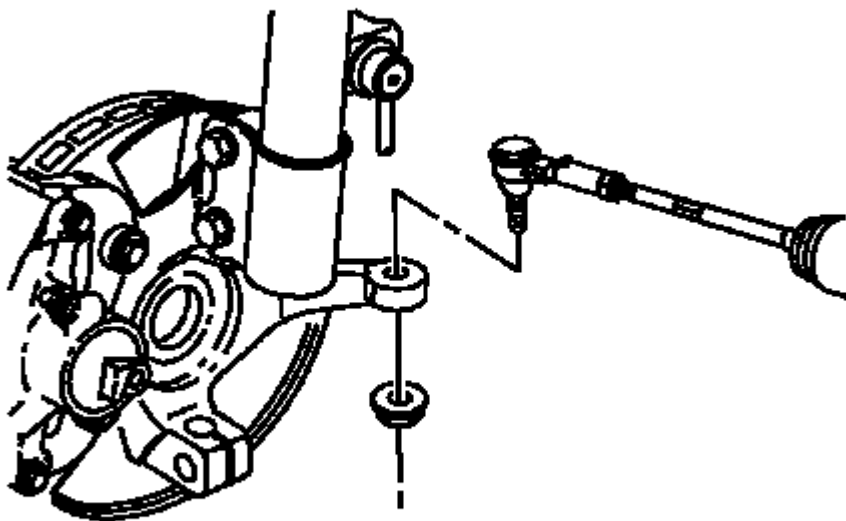


Fig. 235: View Of Tie Rod End & Steering Knuckle
Courtesy of GENERAL MOTORS CORP.

16. Connect the outer tie rod ends to the steering knuckles. Refer to **Rack and Pinion Outer Tie Rod End Replacement** .

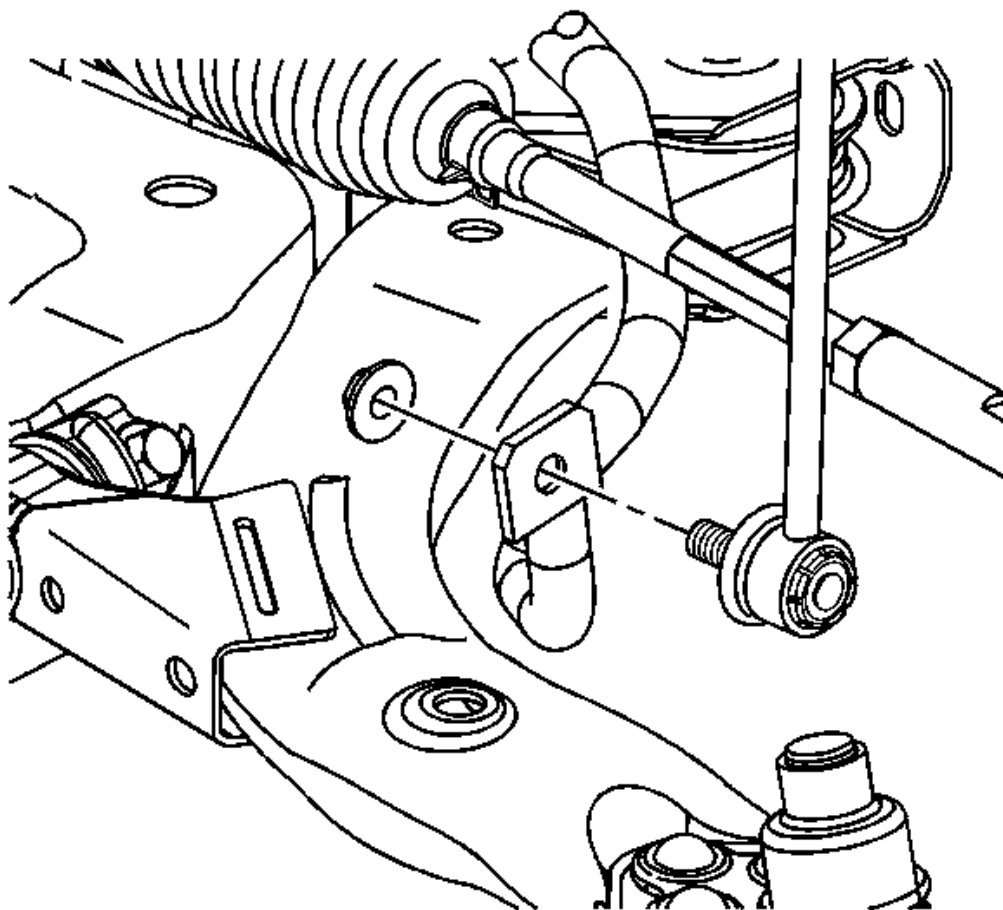


Fig. 236: View Of Stabilizer Link At Stabilizer Shaft
Courtesy of GENERAL MOTORS CORP.

17. Connect the stabilizer links to the stabilizer bar. Refer to **Stabilizer Shaft Link Replacement** .

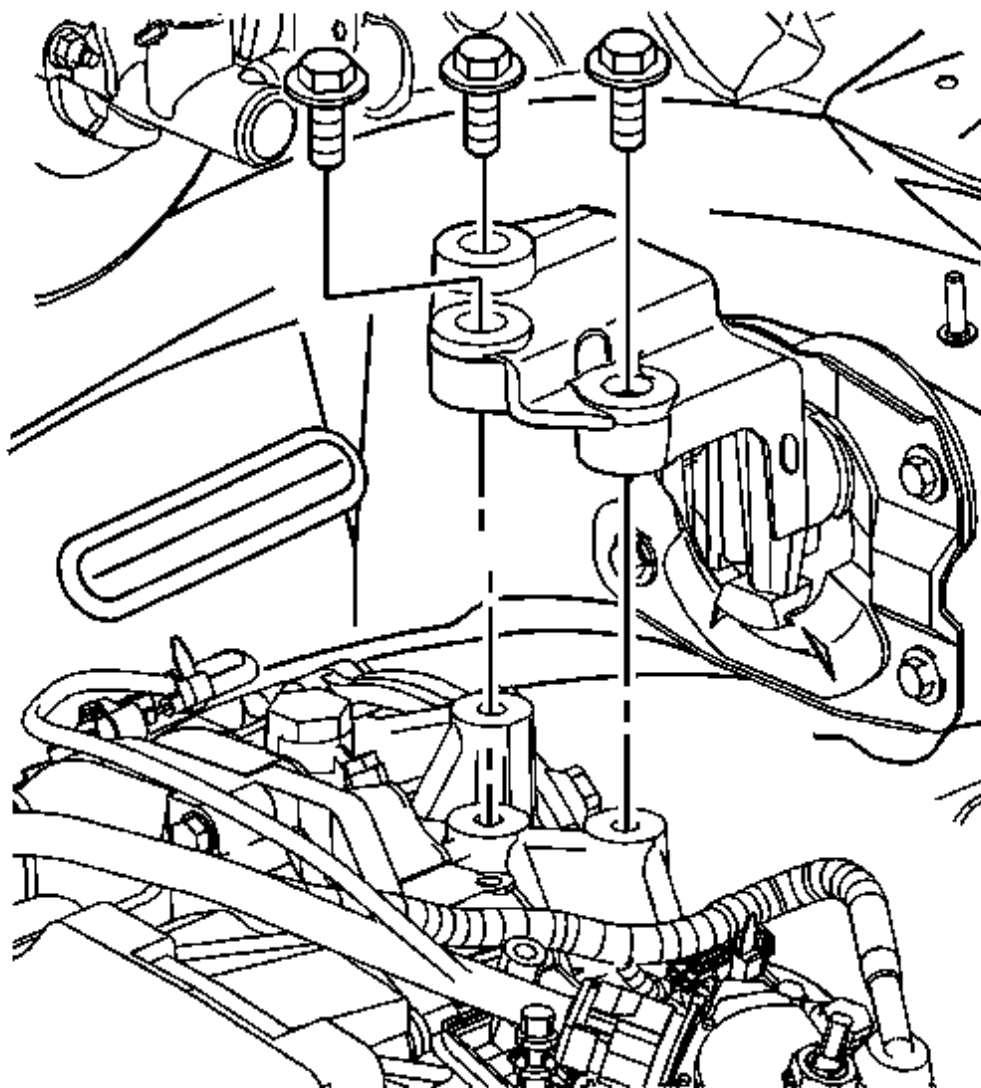


Fig. 237: View Of Side Transmission Mount
Courtesy of GENERAL MOTORS CORP.

18. Install the side transmission mount. Refer to the following:

- **Transmission Mount Replacement - Left Side** for the 4T45-E transaxle
- **Transmission Mount Replacement - Left Side** for the MU3 transaxle
- **Transmission Mount Replacement - Left Side** for the Getrag 5-speed transmission

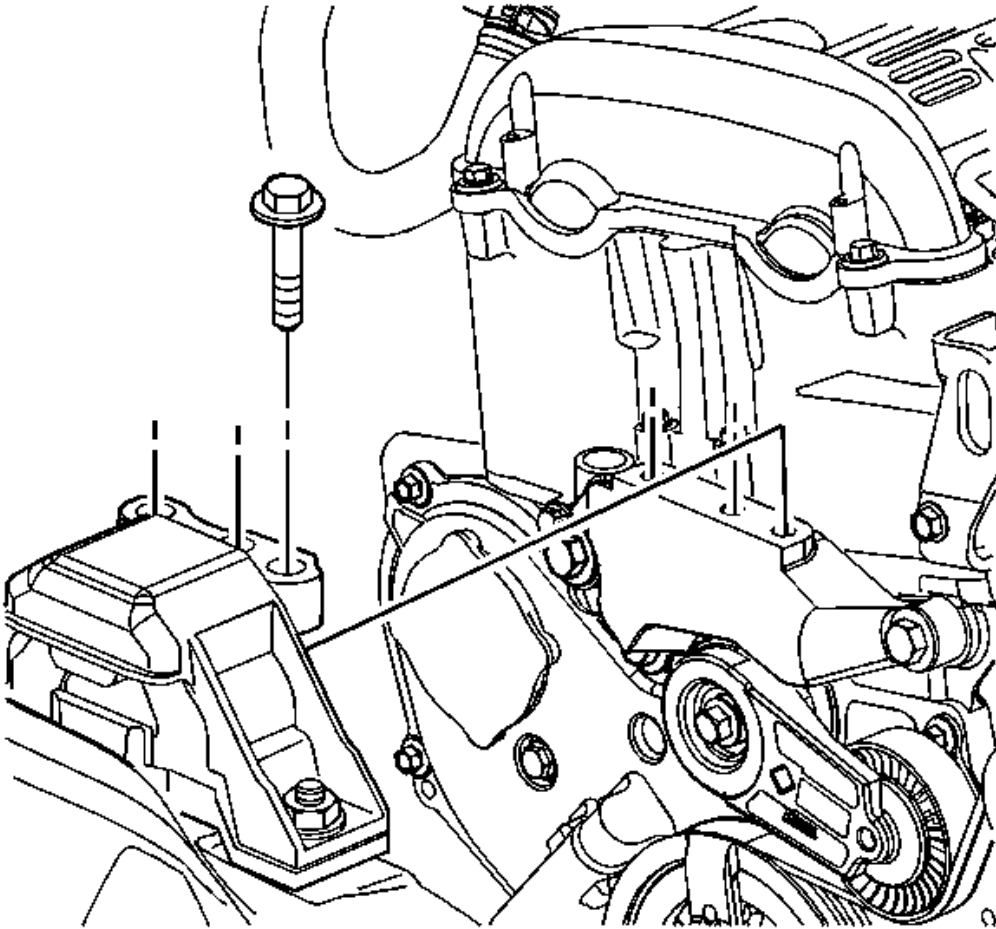


Fig. 238: View Of Engine Mount To Intermediate Bracket Bolts
Courtesy of GENERAL MOTORS CORP.

19. Install the engine mount. Refer to **Engine Mount Replacement**.
20. Remove the wood blocks between the powertrain and frame.
21. Connect the transmission shift cable to the transmission.
22. Connect the transmission harness connector.

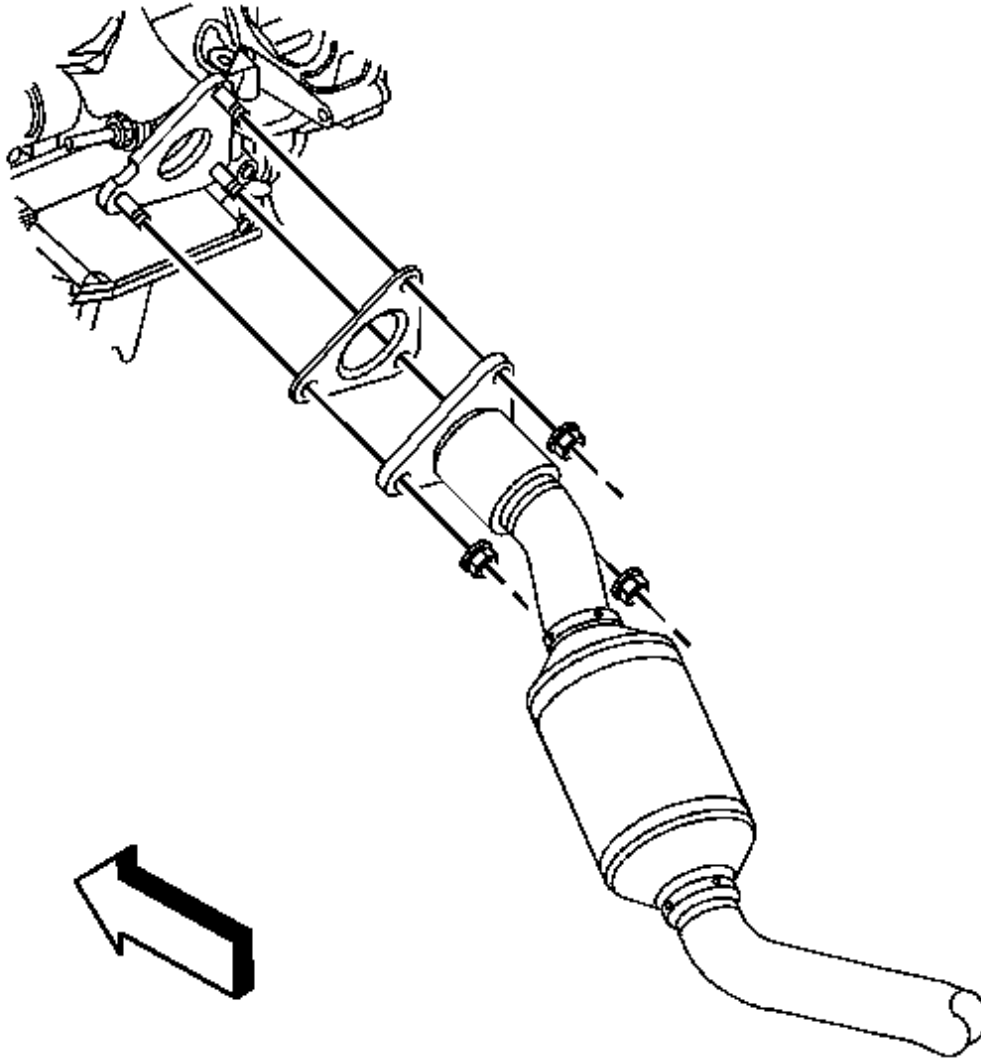


Fig. 239: View Of Exhaust Takedown Pipe
Courtesy of GENERAL MOTORS CORP.

23. Connect the exhaust takedown pipe to the exhaust manifold.

Tighten: Tighten the nuts to 30 N.m (22 lb ft).

24. Connect the generator harness connectors.

Tighten: Tighten the generator terminal nut to 20 N.m (15 lb ft).

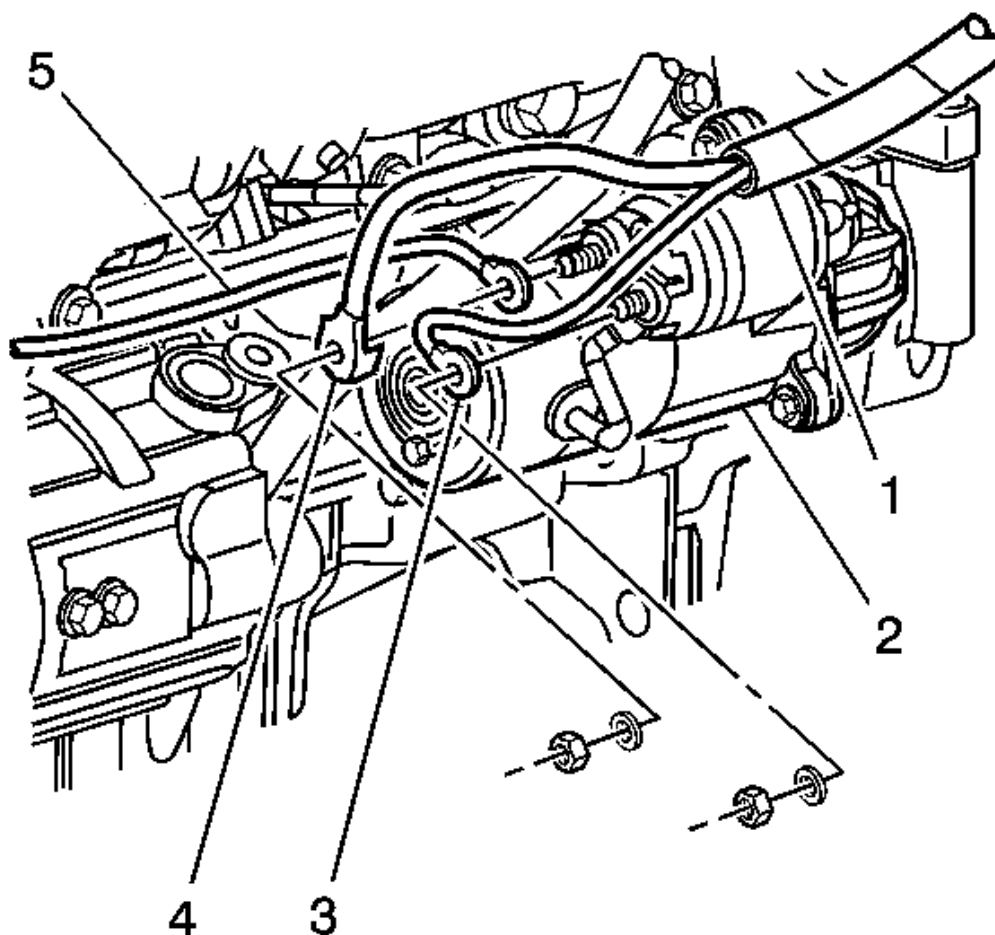


Fig. 240: Identifying Starter Electrical Connectors
Courtesy of GENERAL MOTORS CORP.

25. Connect the starter harness connectors (3, 4, 5).

Tighten:

- Tighten the battery terminal nut to 17 N.m (13 lb ft).
- Tighten the S-terminal nut to 3 N.m (27 lb in).

26. Install the AC compressor to the engine. Refer to **Air Conditioning Compressor Replacement (L61, LE5)**.
27. Install the engine drive belt. Refer to **Drive Belt Replacement**.
28. Connect the following harness connectors:

- IAC motor
- TPS
- MAP sensor
- Crankshaft sensor
- Oil pressure sensor
- Purge solenoid
- Ignition coil and module assembly
- O2 sensor
- Vehicle speed sensor
- Engine temperature sensor

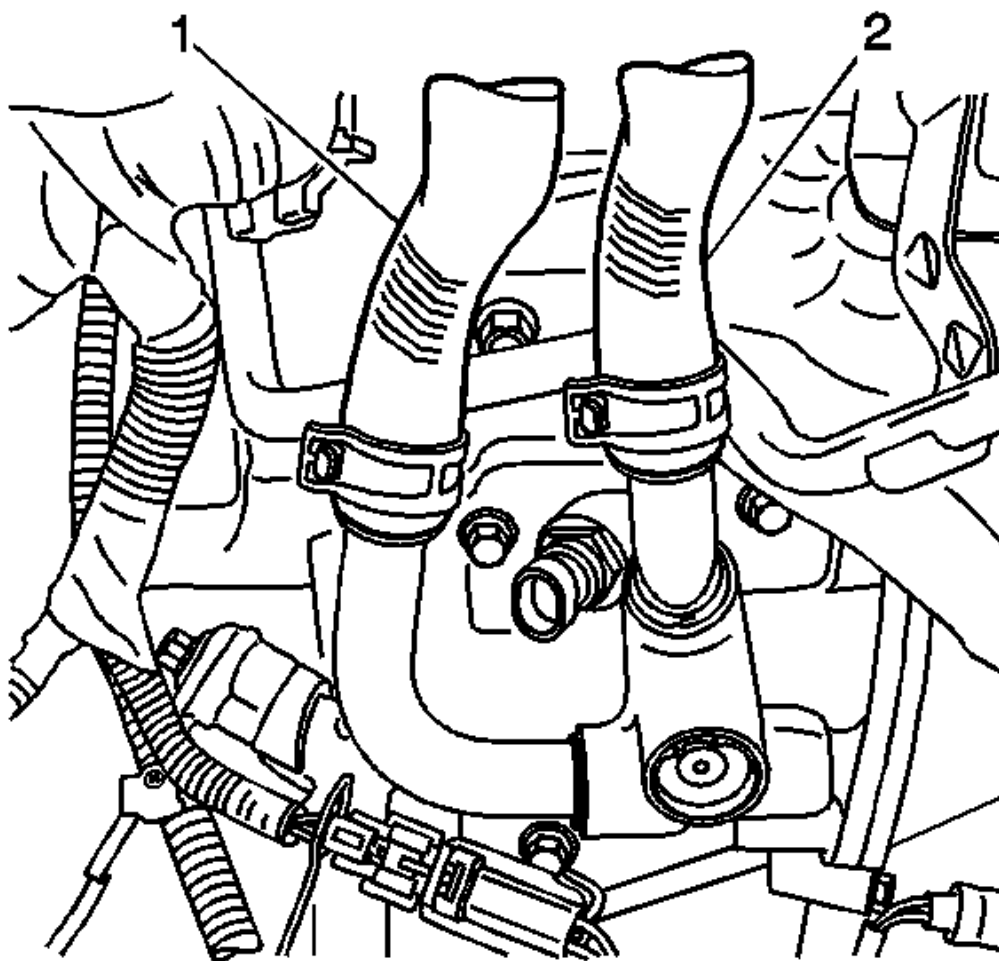


Fig. 241: View Of Inlet & Outlet Heater Hose
Courtesy of GENERAL MOTORS CORP.

29. Install the inlet heater hose (1) and outlet heater hose (2). Refer to **Heater Inlet Hose Replacement (L61, LE5)** and **Heater Outlet Hose Replacement (L61, LE5)** .
30. Install the radiator outlet hose. Refer to **Radiator Inlet Hose Replacement (LE5, L61)** .
31. Connect the fuel line to the fuel rail. Refer to **Metal Collar Quick Connect Fitting Service** .
32. Connect the brake booster hose at the brake booster.

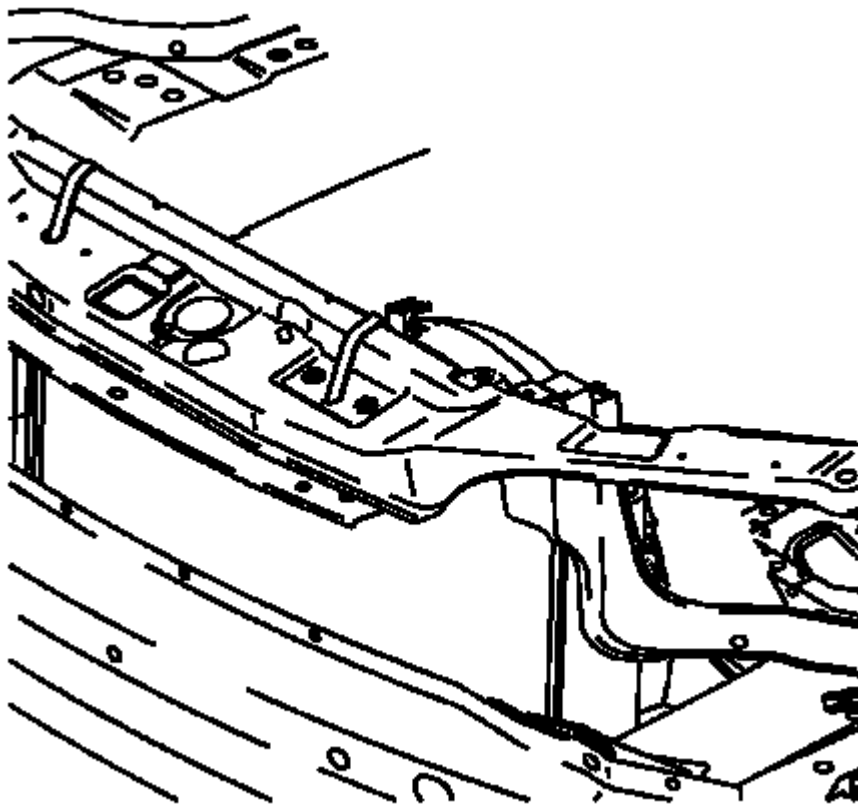


Fig. 242: Cooling Module Secured To Upper Body Structure
Courtesy of GENERAL MOTORS CORP.

33. Release the cooling module from the upper body structure.
34. Install the air inlet duct and resonator. Refer to **Air Cleaner Outlet Resonator Replacement** .
35. Connect the negative battery cable. Refer to **Battery Negative Cable Disconnection and Connection** .
36. Fill the engine with engine oil to the proper level. Refer to **Fluid and Lubricant Recommendations** .
37. Fill the cooling system. Refer to **Cooling System Draining and Filling (GE 47716 Fill)** or **Cooling System Draining and Filling (Static Fill LE5, L61)** .
38. Road test the vehicle.

ENGINE OIL AND OIL FILTER REPLACEMENT**Tools Required****J 44887** Oil Filter Wrench**Removal Procedure**

1. Raise and support the vehicle. Refer to **Lifting and Jacking the Vehicle** .
2. Place a drain pan under the oil drain plug.

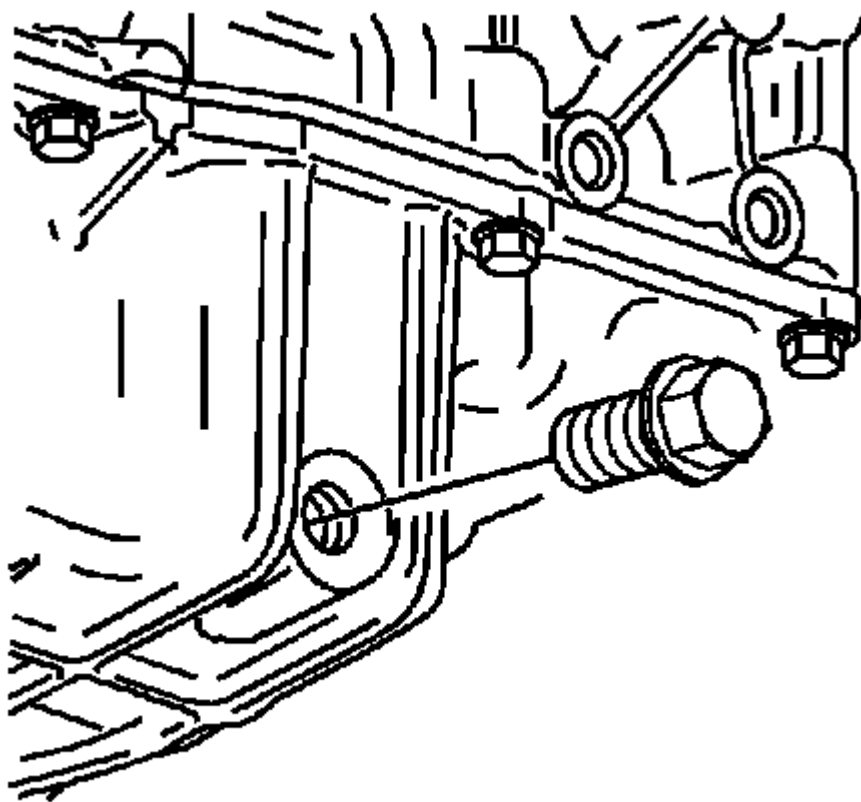


Fig. 243: View Of Oil Pan Drain Bolt
Courtesy of GENERAL MOTORS CORP.

3. Remove the oil pan drain plug.

IMPORTANT: DO NOT use an open end wrench on the hex on top of the oil filter cap.

4. Use **J 44887** to remove the oil filter cap.

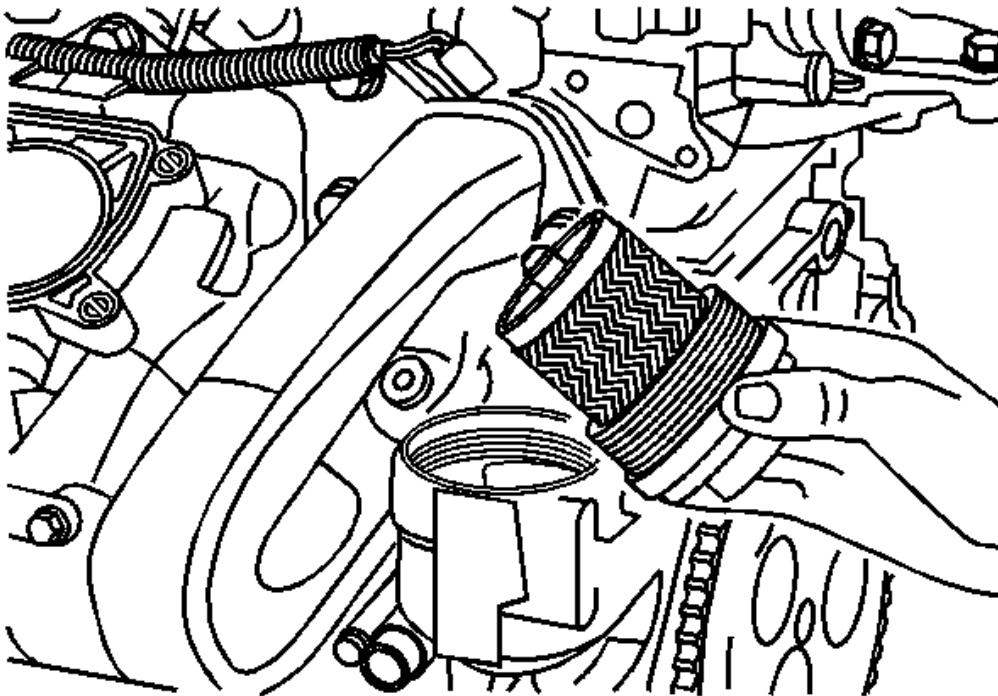


Fig. 244: View Of Oil Filter

Courtesy of GENERAL MOTORS CORP.

5. Remove the oil filter cap with filter.
6. Remove the filter from the cap.

Installation Procedure

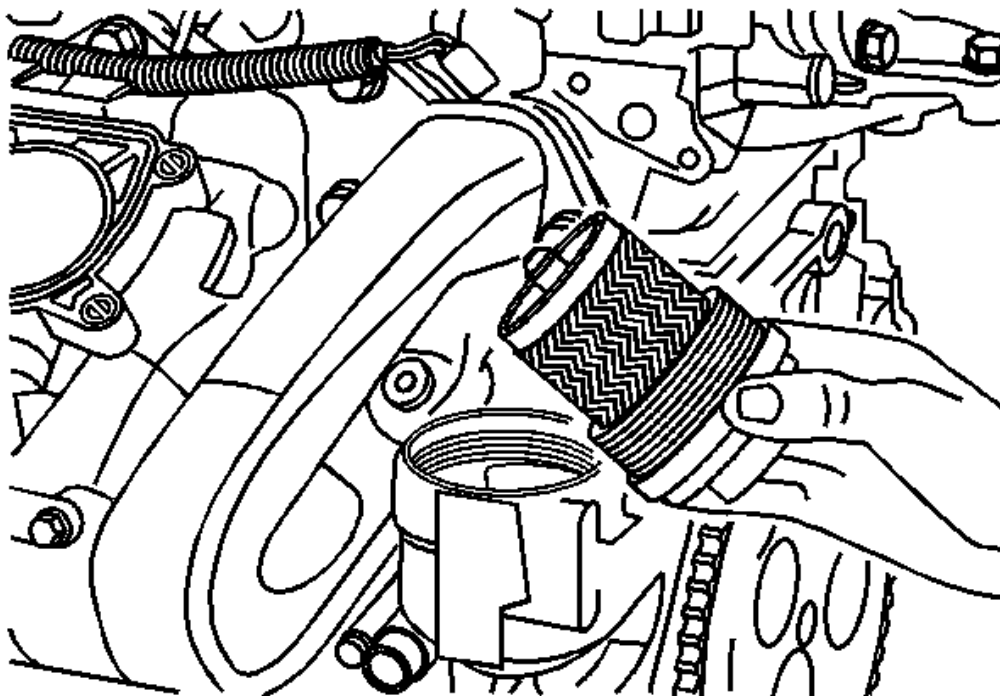


Fig. 245: View Of Oil Filter

Courtesy of GENERAL MOTORS CORP.

1. Install the filter to the cap.
2. Install the oil filter cap with filter.

NOTE: Over torquing the oil filter cap may cause damage to the oil filter cap resulting in an oil leak.

NOTE: Refer to FASTENER NOTICE .

IMPORTANT: DO NOT use an open end wrench on the hex on top of the oil filter cap.

3. Use **J 44887** on the oil filter cap.

Tighten: Tighten the oil filter cap until fully seated, DO NOT exceed 25 N.m (18 lb ft).

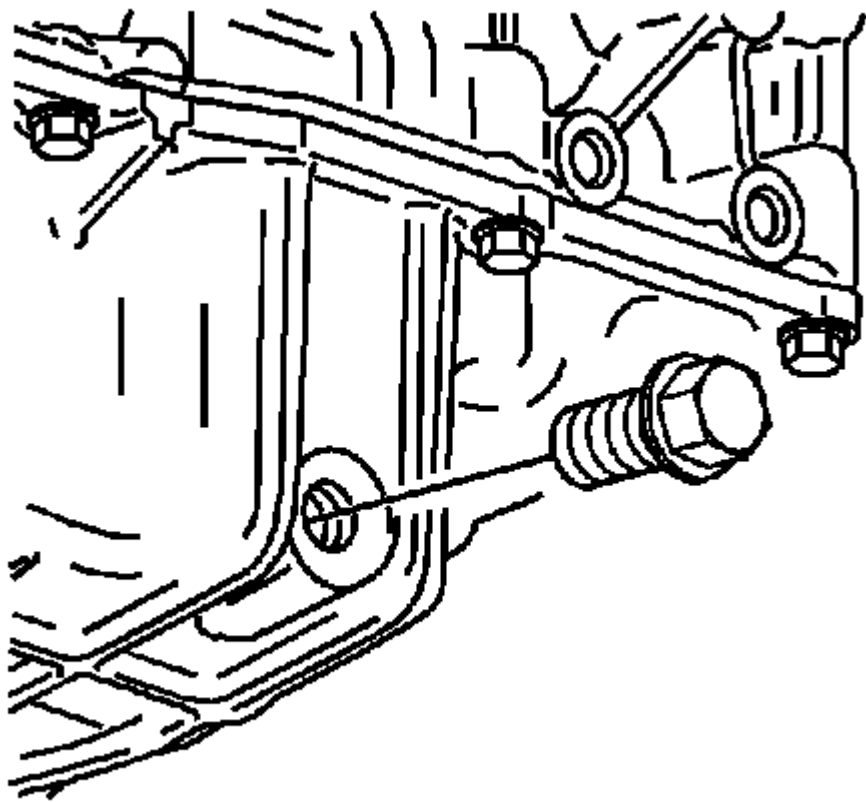


Fig. 246: View Of Oil Pan Drain Bolt
Courtesy of GENERAL MOTORS CORP.

4. Install the oil pan drain plug.

Tighten: Tighten the oil pan drain plug to 25 N.m (18 lb ft).

5. Lower the vehicle.
6. Fill the engine with oil. Refer to Fluid and Lubricant Recommendations .

REPAIR INSTRUCTIONS - OFF VEHICLE

DRAINING FLUIDS AND OIL FILTER REMOVAL

Tools Required

J 44887 Oil Filter Wrench

Removal Procedure

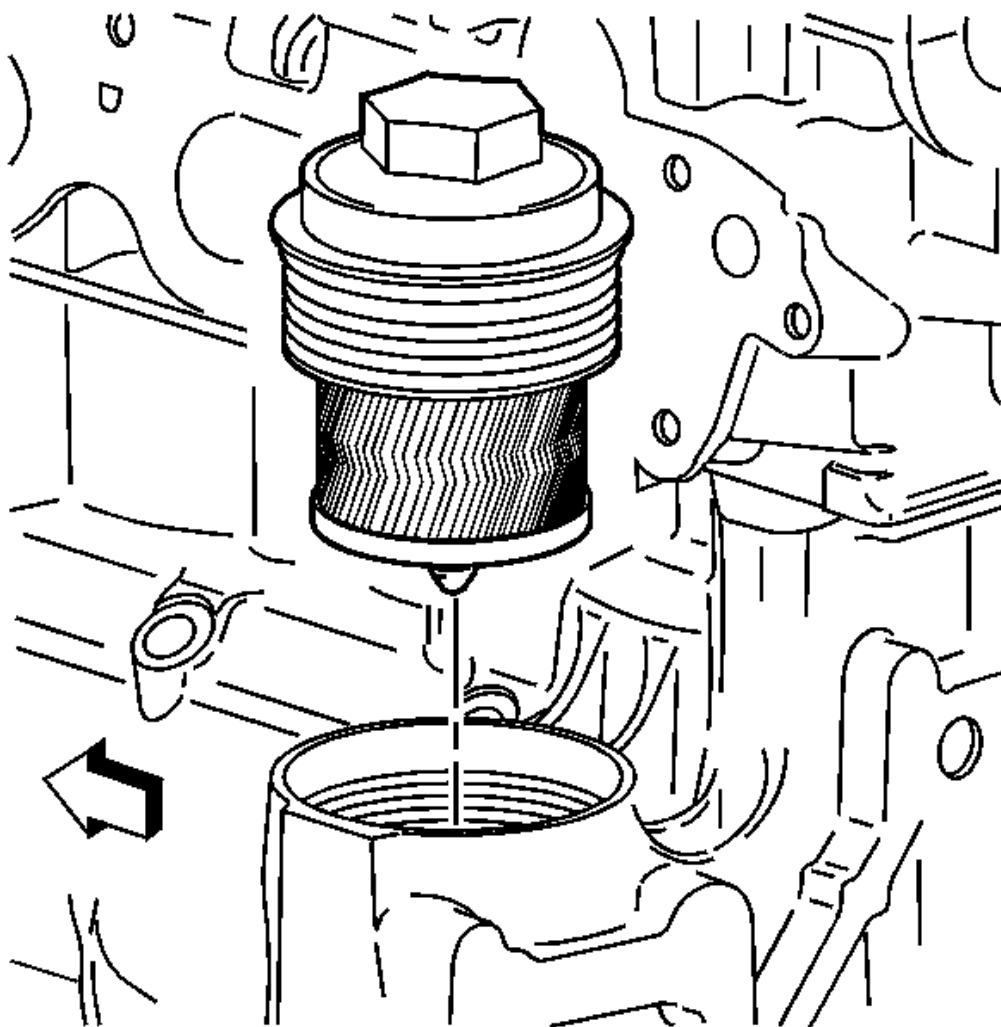


Fig. 247: Identifying Oil Filter Housing
Courtesy of GENERAL MOTORS CORP.

1. Use **J 44887** to remove the oil filter cap. Remove the oil pan drain plug and allow the oil to drain out.
2. Remove the oil filter from the cap and discard.
3. Clean the oil filter housing in the engine block.

NOTE: Refer to **FASTENER NOTICE** .

4. Install the oil pan drain plug.

Tighten: Tighten the oil pan drain plug to 25 N.m (18 lb ft).

5. Remove the water pump drain plug from the water pump and allow the coolant to drain from the water jacket.
6. Apply sealant GM P/N 12346004 (Canadian P/N 10953480) or equivalent to the water pump drain plug.
7. Install the water pump drain plug.

Tighten: Tighten the water pump drain plug to 20 N.m (15 lb ft).

8. If cleaning or repairing the engine block, it is not necessary to reinstall the plugs.

CRANKSHAFT BALANCER REMOVAL

Tools Required

J 38122-A Crankshaft Balancer Holder. See **Special Tools**.

Removal Procedure

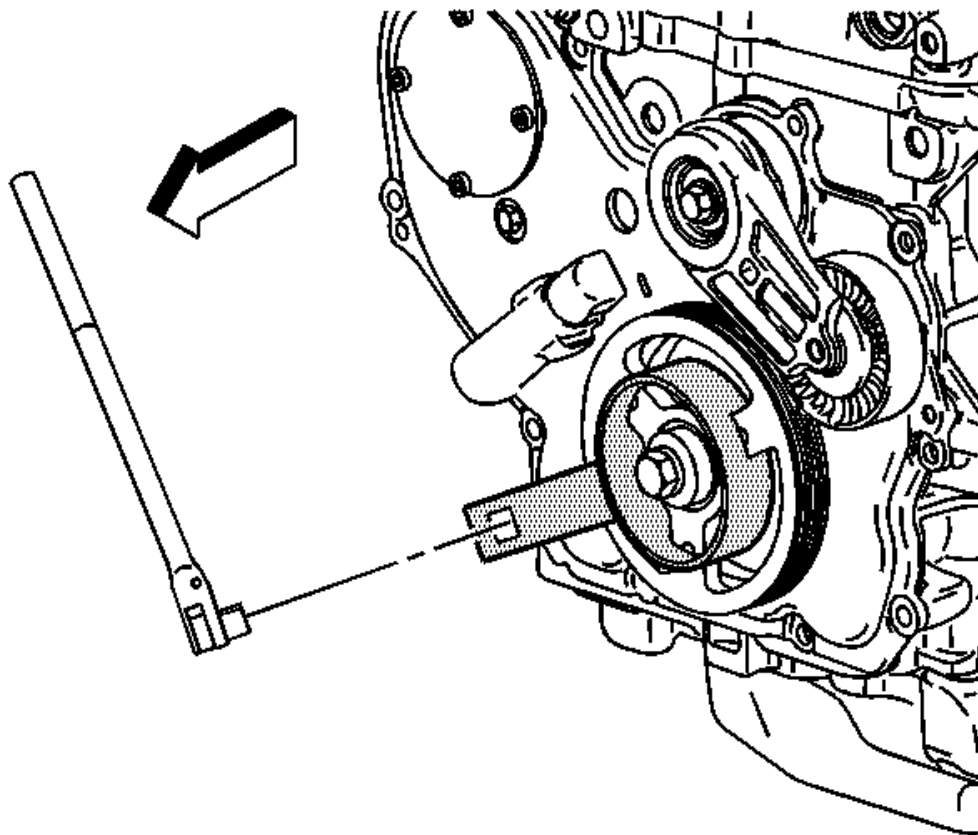


Fig. 248: View Of Harmonic Balancer Holder J38122-A
Courtesy of GENERAL MOTORS CORP.

1. Install the **J 38122-A** . See **Special Tools**.
2. Remove the balancer retaining bolt and washer. Use the **J 38122-A** and a breaker bar to prevent the crankshaft from rotating when loosening the bolt. See **Special Tools**.

Discard the bolt.

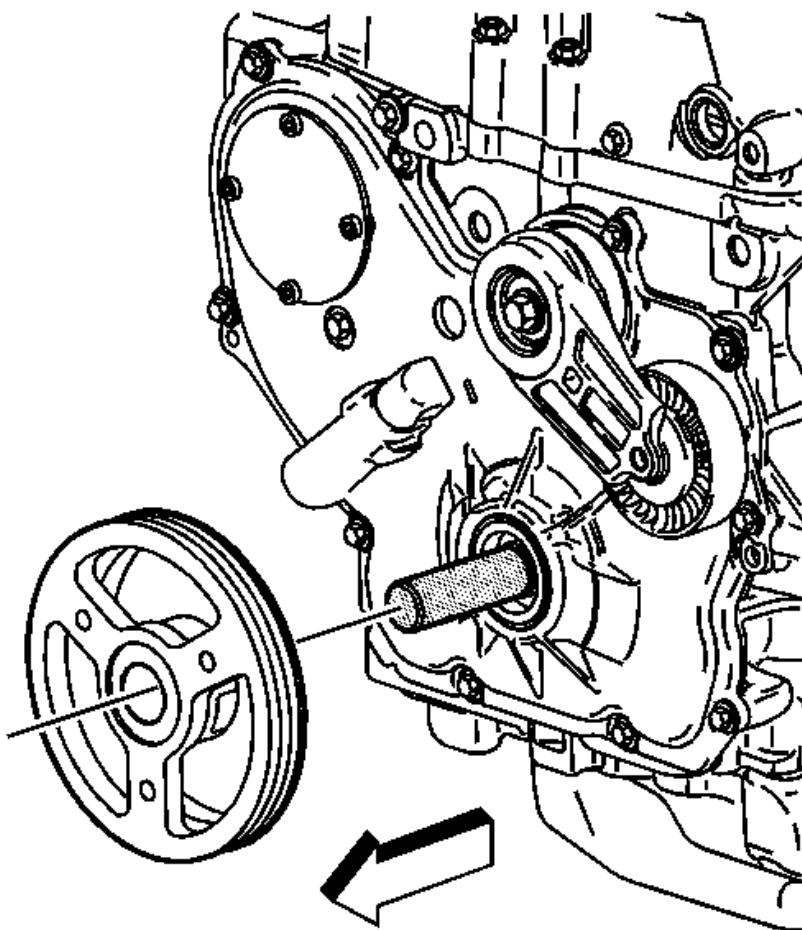


Fig. 249: View Of Crankshaft Balancer
Courtesy of GENERAL MOTORS CORP.

3. Remove the crankshaft balancer assembly.

ENGINE FLYWHEEL REMOVAL

Tools Required

J 38122-A Crankshaft Balancer Holder. See **Special Tools**.

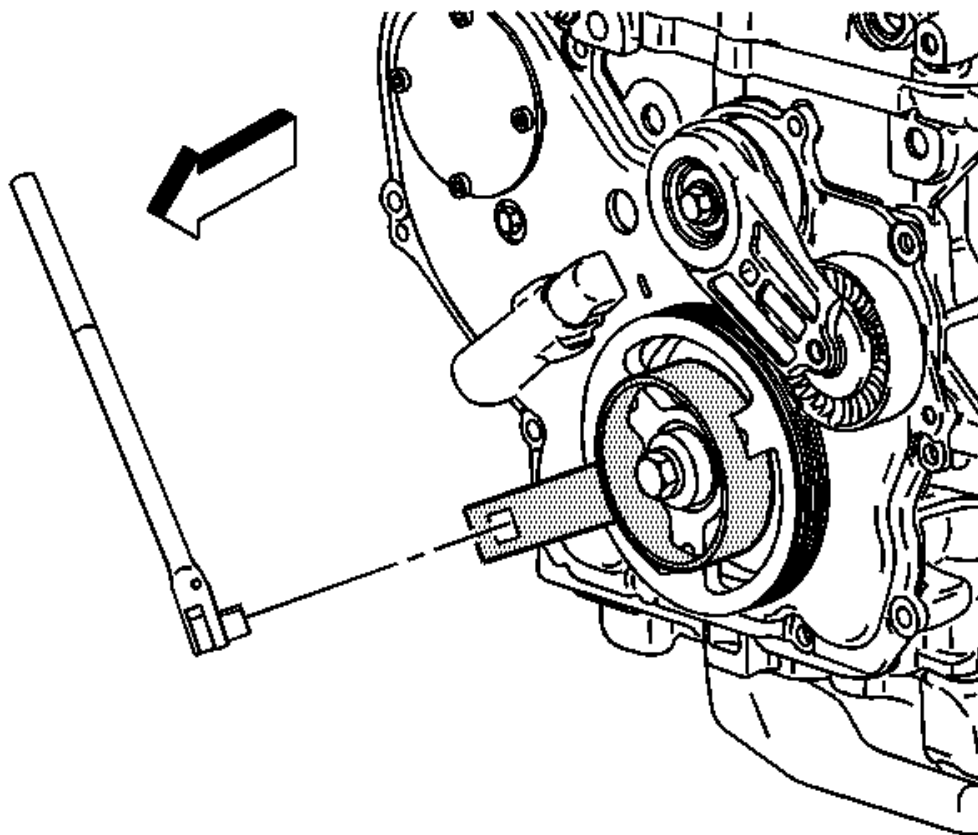
Removal Procedure

Fig. 250: View Of Harmonic Balancer Holder J38122-A
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: It may be necessary to remove the chamfer (bevel) from the edge of an 18 mm socket in order to get full socket engagement on the thin headed flywheel bolts.
Do not orientate the flywheel to the crankshaft. It is balanced separately from the engine.

1. Remove the flywheel attaching bolt. Use the **J 38122-A** to prevent crankshaft rotation. See **Special Tools**.

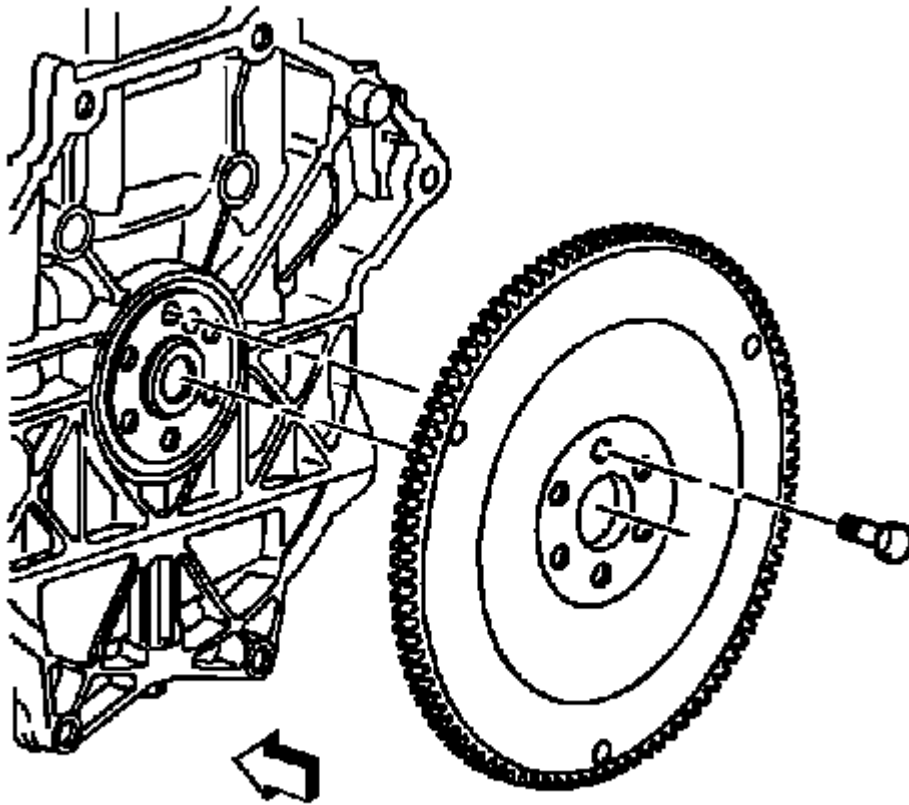


Fig. 251: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

2. Remove the flywheel retainer.
3. Remove the flywheel.
4. Clean the thread adhesive from the flywheel bolt holes. Use a nylon bristle brush to clean the holes in the crankshaft.

OIL LEVEL INDICATOR AND TUBE REMOVAL

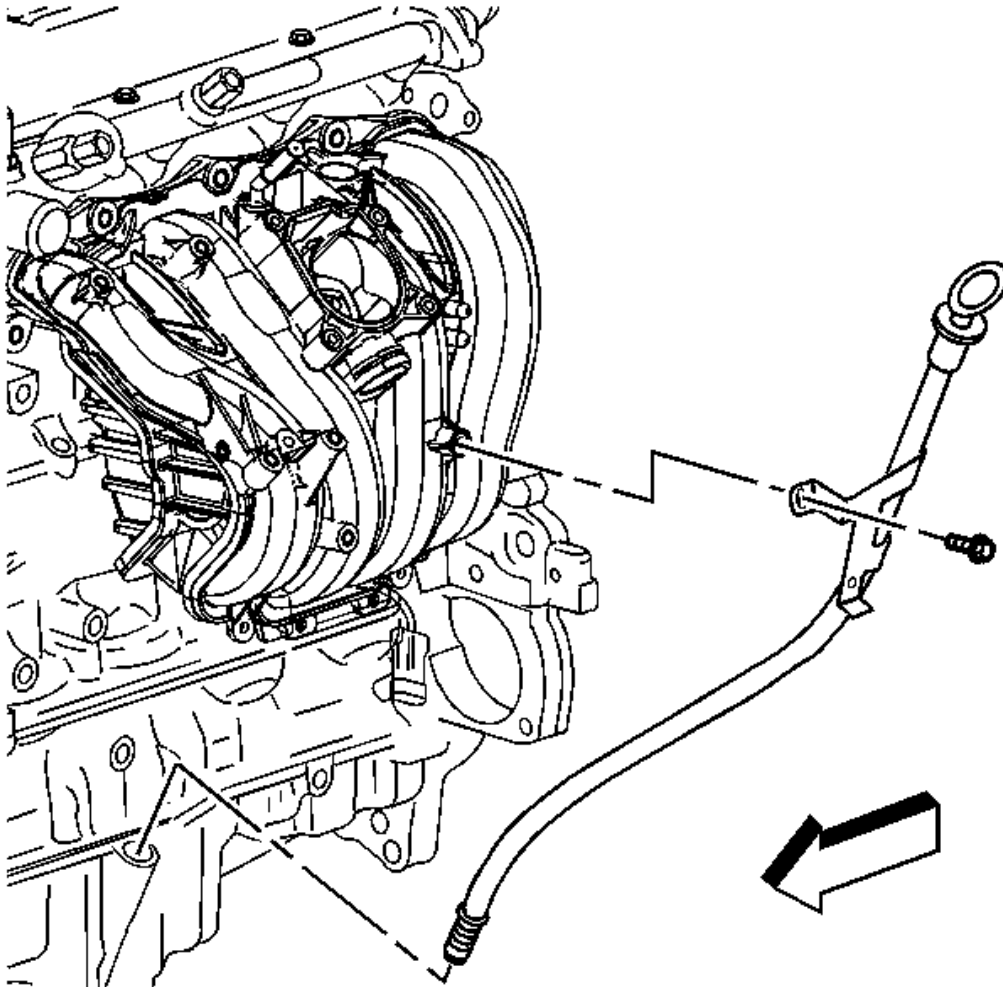


Fig. 252: View Of Oil Level Indicator
Courtesy of GENERAL MOTORS CORP.

1. Remove knock sensor connector from the oil level indicator tube.
2. Remove the oil level indicator tube bracket to the intake manifold bolt.
3. Remove the oil level indicator and the oil level indicator tube from the oil pan.

EXHAUST MANIFOLD REMOVAL

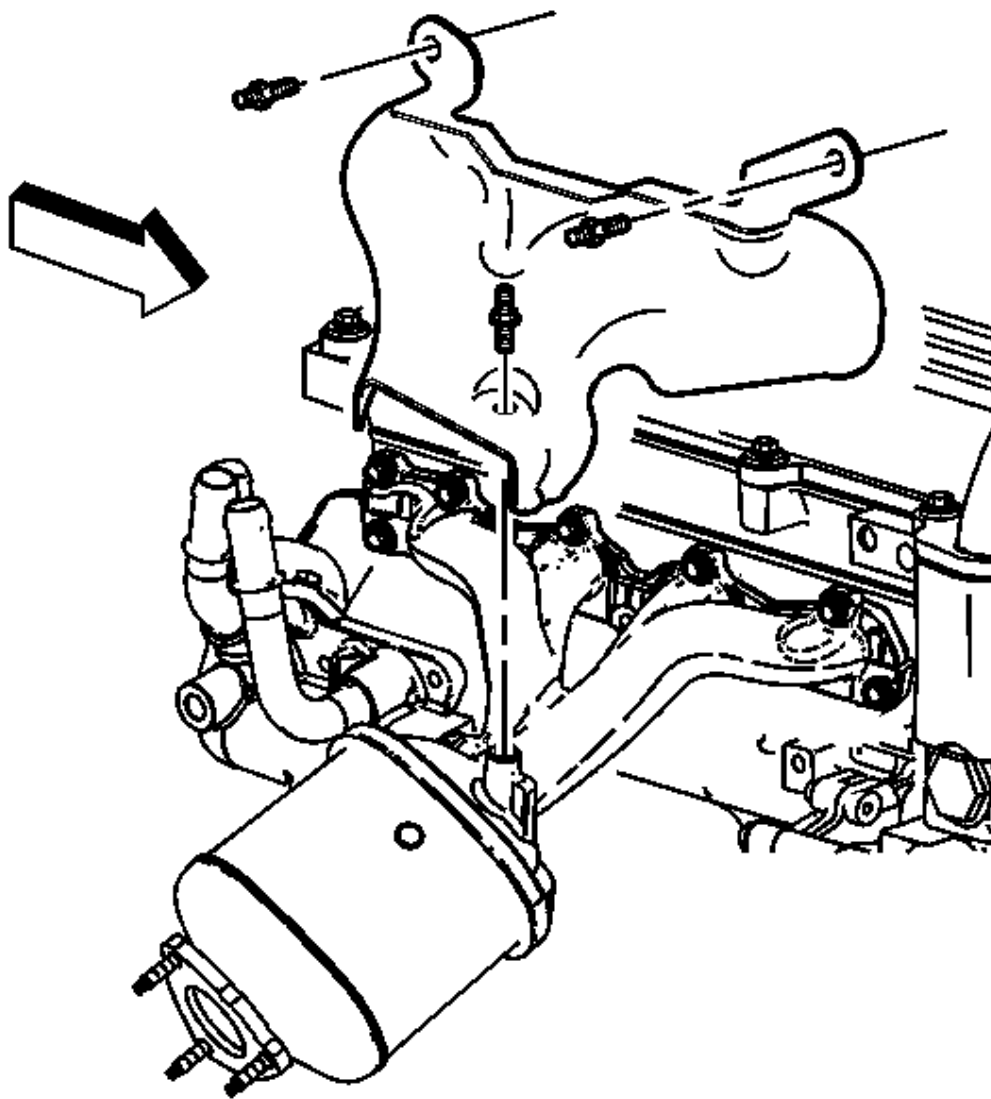


Fig. 253: View Of Exhaust Manifold Heat Shield
Courtesy of GENERAL MOTORS CORP.

1. Remove the exhaust manifold heat shield.

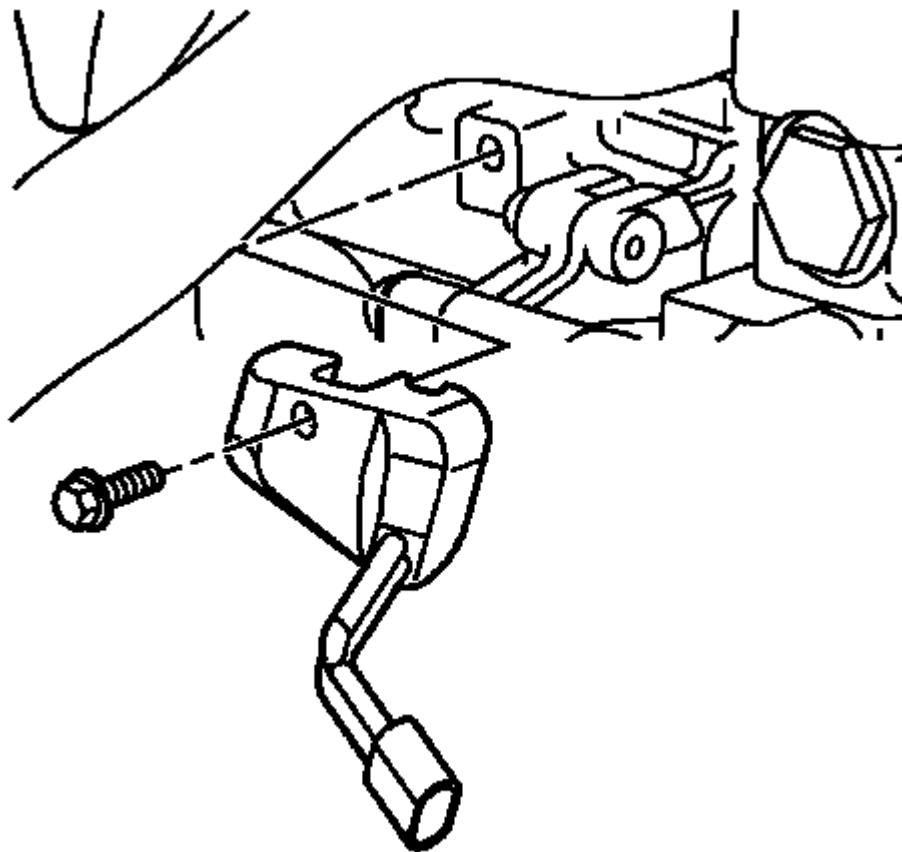


Fig. 254: View Of Block Heater
Courtesy of GENERAL MOTORS CORP.

2. Remove the block heater if equipped.

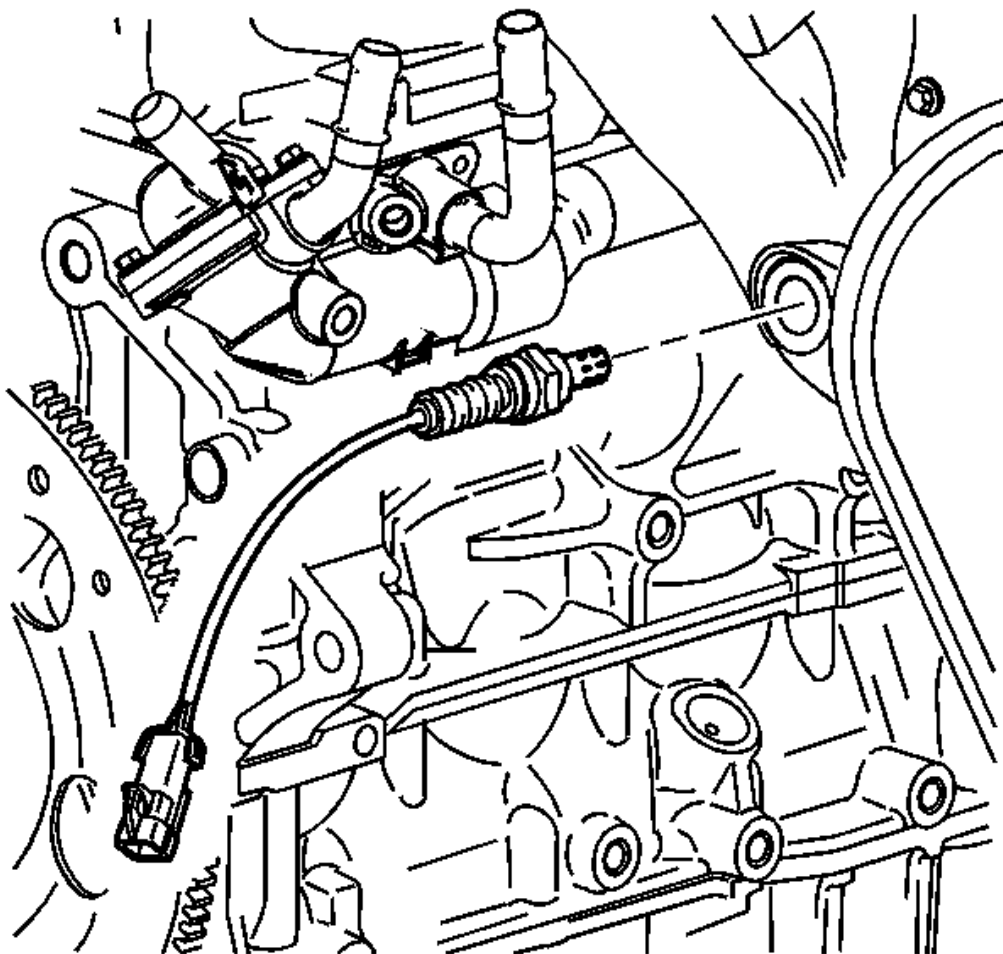


Fig. 255: View Of Oxygen Sensor
Courtesy of GENERAL MOTORS CORP.

3. Remove the oxygen sensor.

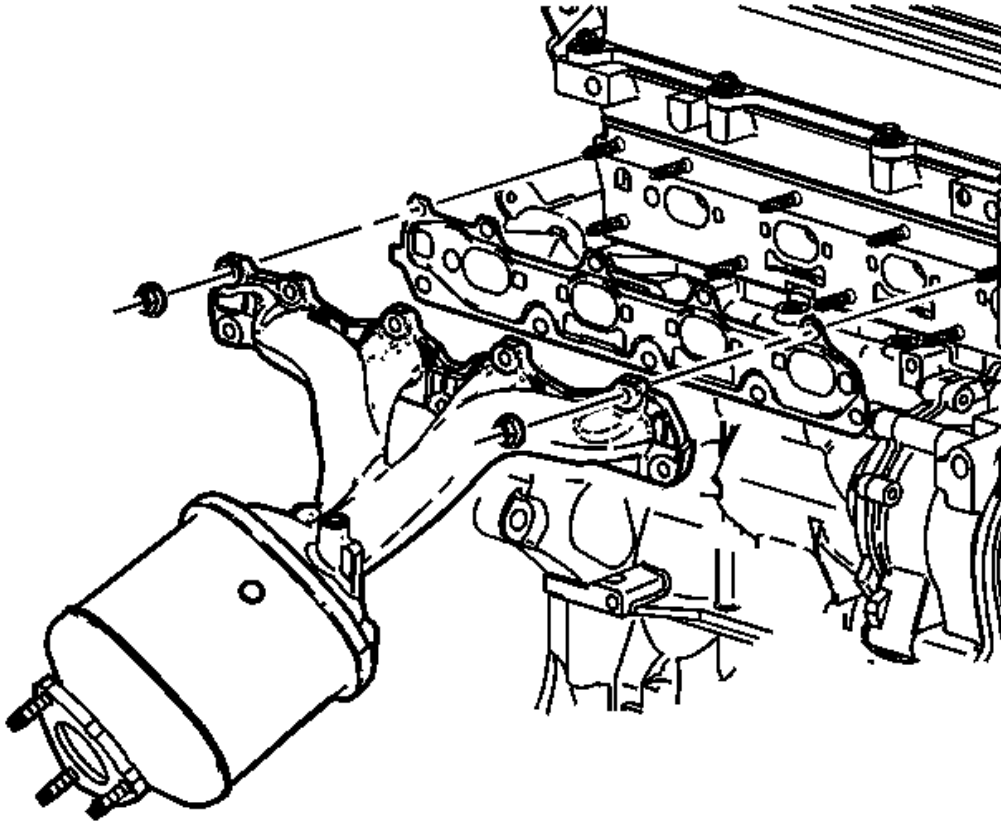


Fig. 256: View Of Exhaust Manifold And Catalytic Converter Assembly
Courtesy of GENERAL MOTORS CORP.

4. Remove and discard the exhaust manifold to cylinder head retaining nuts.
5. Remove the exhaust manifold and catalytic converter assembly.
6. Clean all of the sealing surfaces.
7. If the exhaust manifold and catalytic converter assembly is being replaced, transfer the following parts:
 - The exhaust manifold heat shield
 - The oxygen sensor

INTAKE MANIFOLD REMOVAL

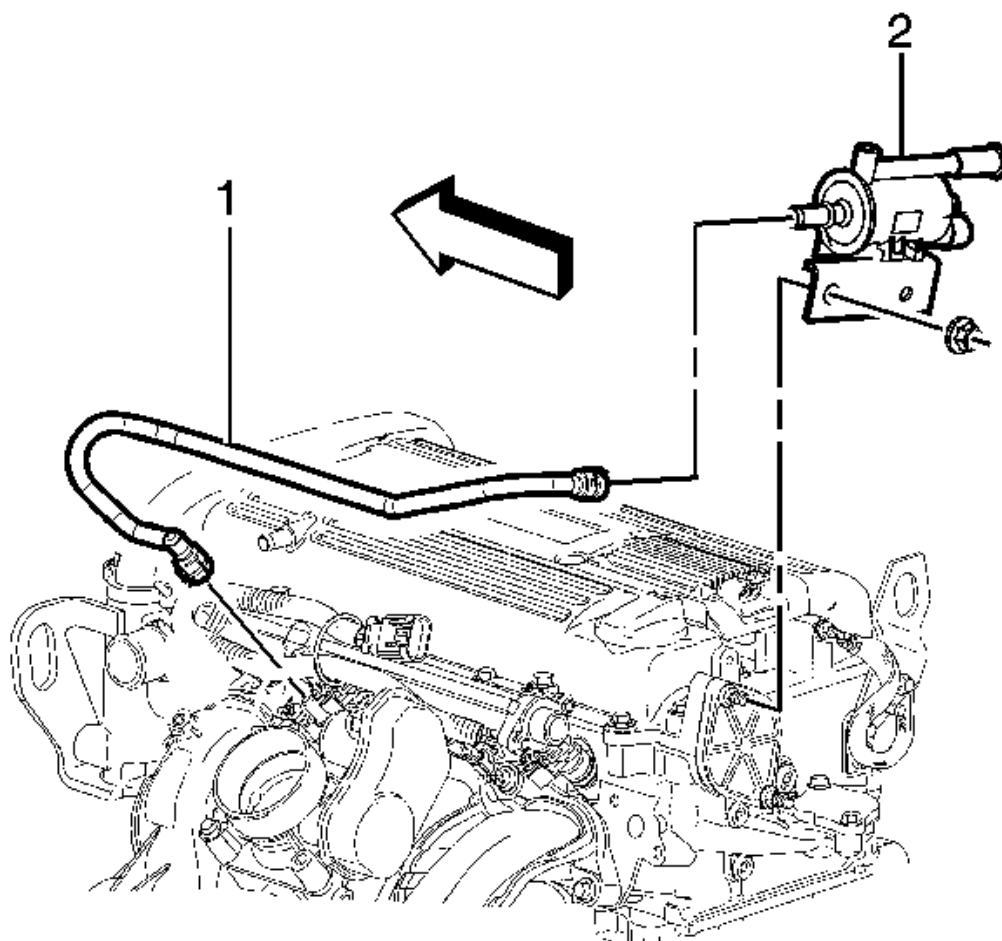


Fig. 257: View Of EVAP Emission Canister Valve & Tube
Courtesy of GENERAL MOTORS CORP.

NOTE: Never attempt to remove the intake manifold from a hot engine, allow the engine to cool to ambient temperature. The intake manifold is made of a composite plastic and can be damaged if it is removed when the engine is hot.

1. Remove the evaporative emission (EVAP) canister valve tube (1).
2. Remove the EVAP emission canister valve (2).

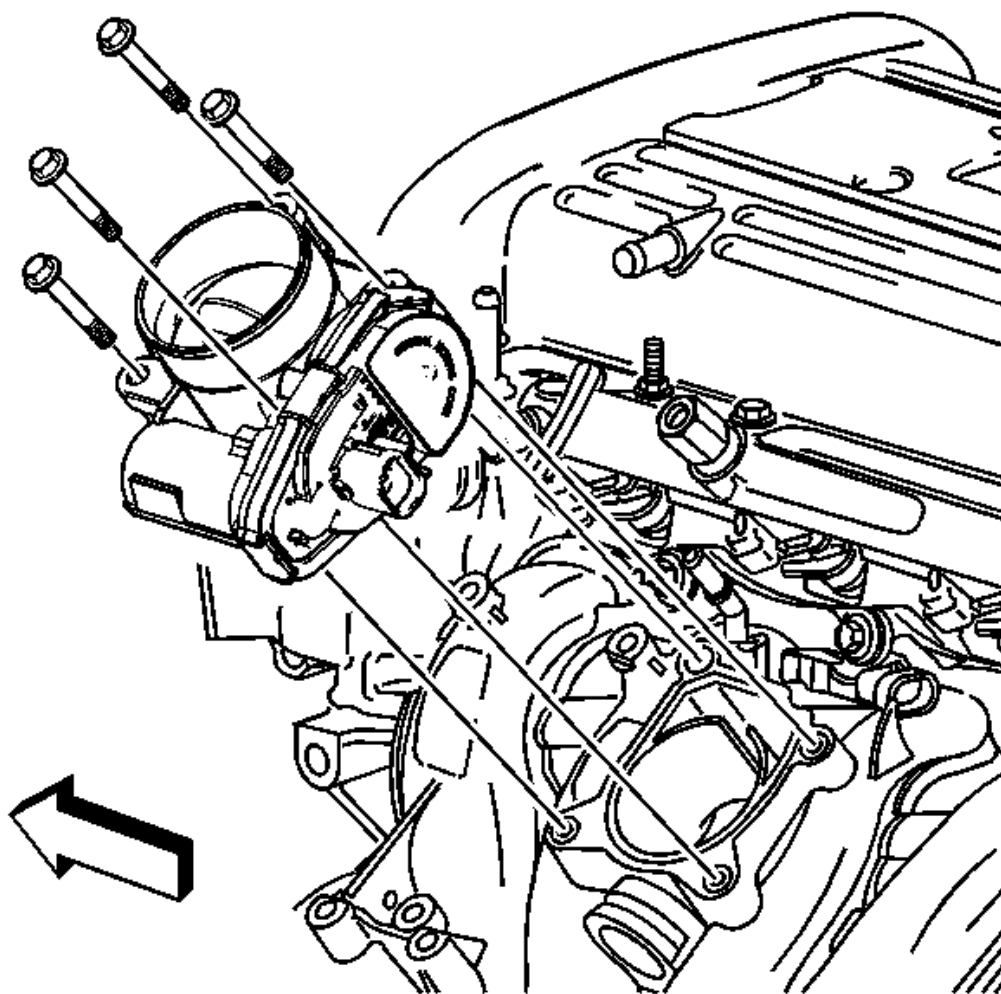


Fig. 258: View Of Throttle Body & Bolts
Courtesy of GENERAL MOTORS CORP.

3. Remove the throttle body.

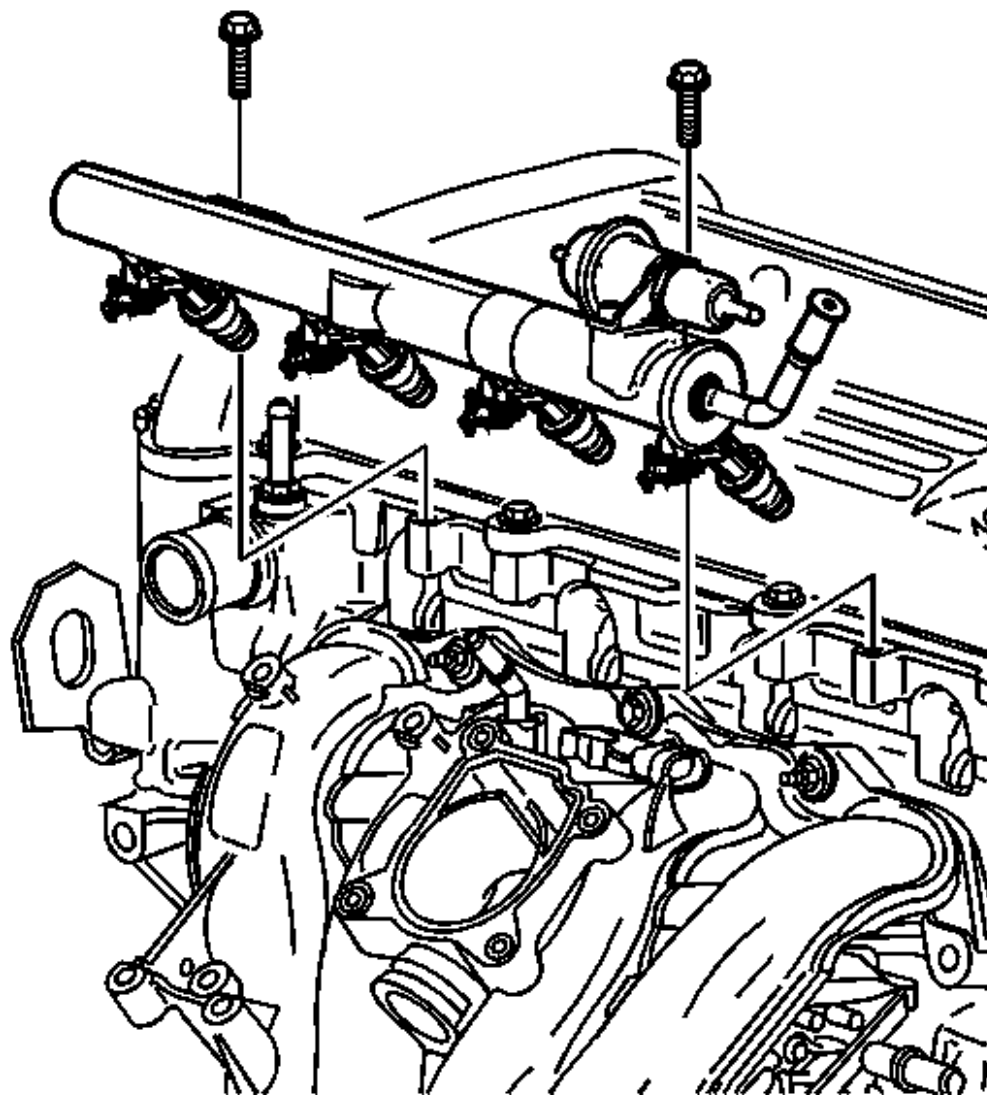


Fig. 259: Identifying Fuel Rail Assembly
Courtesy of GENERAL MOTORS CORP.

4. Remove fuel pipes and clip.
5. Remove the fuel rail bolts.
6. Remove the fuel rail assembly.

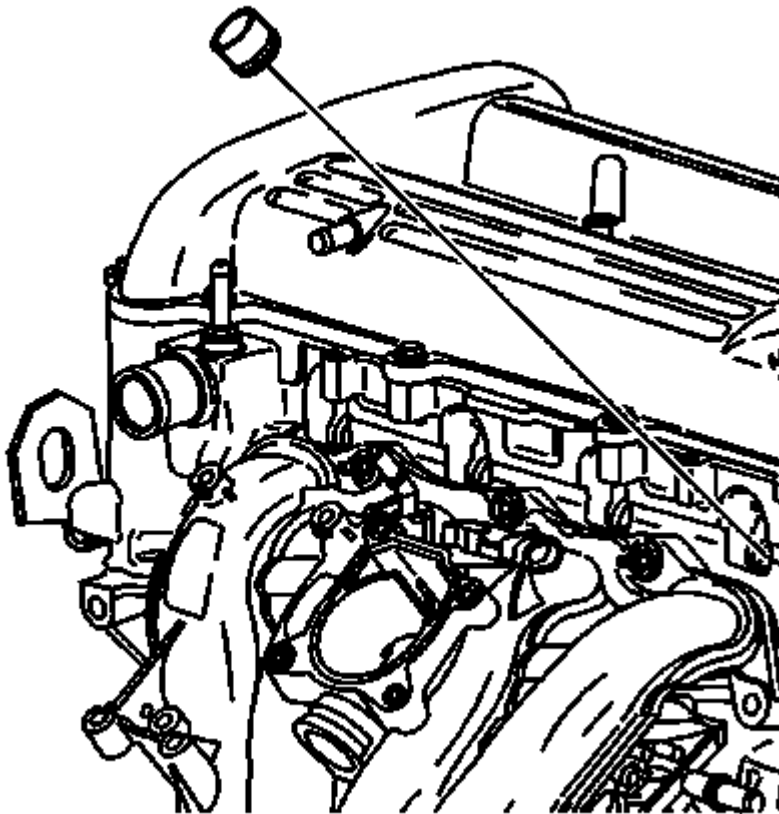


Fig. 260: View Of Fuel Injector Tip Insulators
Courtesy of GENERAL MOTORS CORP.

7. Remove the fuel injector tip insulators and discard.

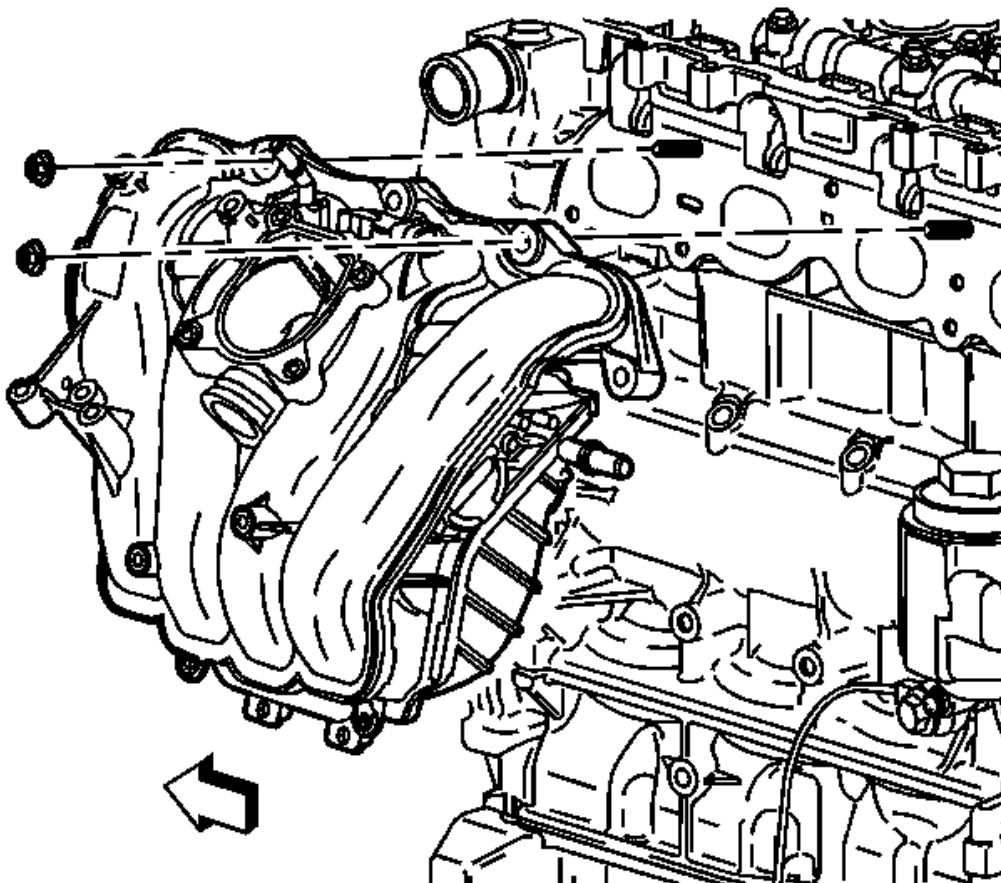


Fig. 261: Removing & Installing Intake Manifold
Courtesy of GENERAL MOTORS CORP.

8. Remove the intake manifold retaining nuts and bolts.
9. Remove the intake manifold.
10. Remove the intake manifold gasket, if necessary. The gasket is reusable if it is not damaged.
11. If the intake manifold needs to be replaced, transfer the following parts:
 - The throttle body
 - The throttle body gasket

The manifold-to-throttle body gasket is reusable if it is not damaged.

CAMSHAFT COVER REMOVAL

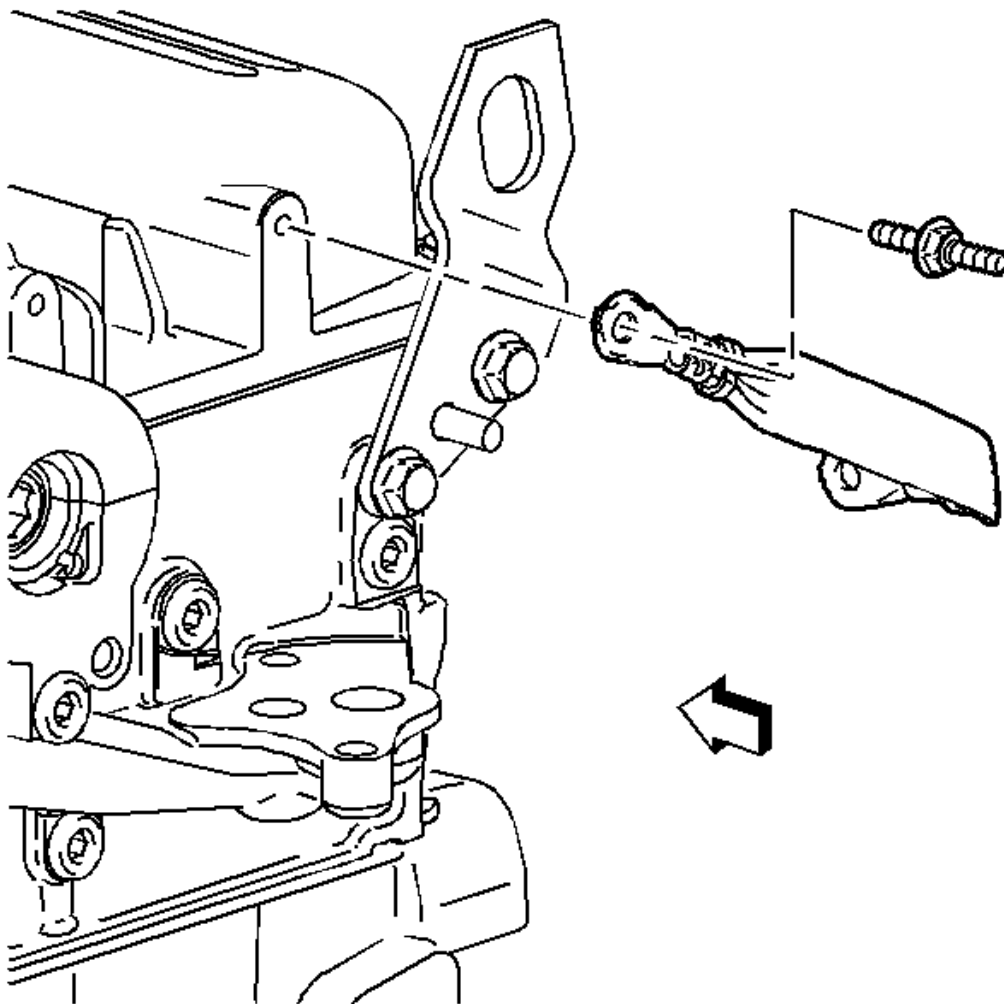


Fig. 262: View Of Camshaft Cover Ground Strap
Courtesy of GENERAL MOTORS CORP.

1. Remove the camshaft cover grounding strap.

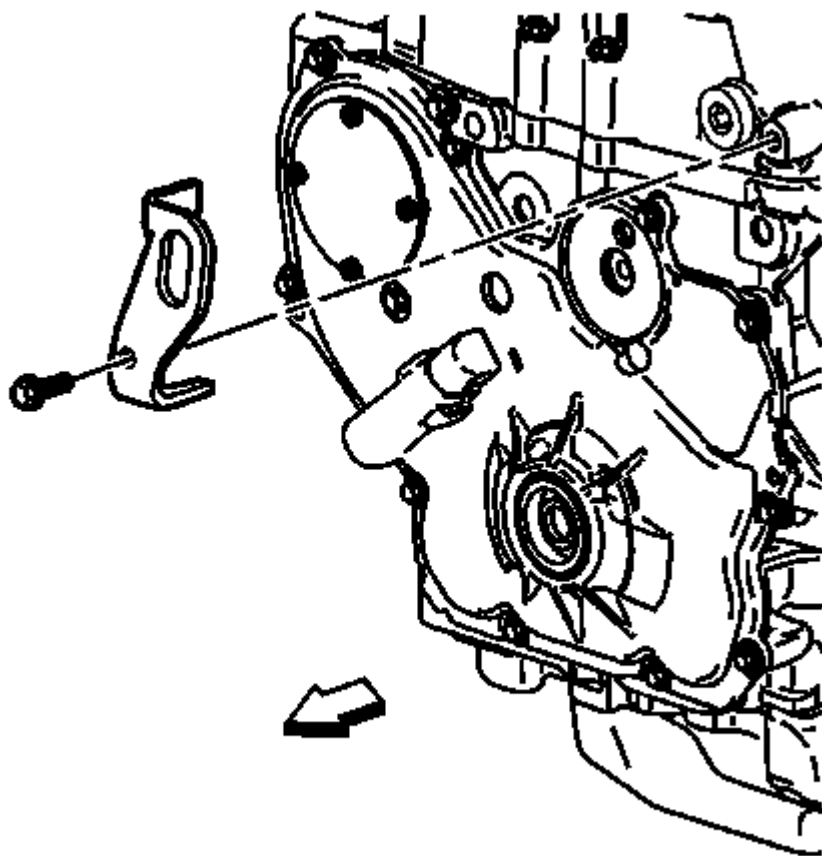


Fig. 263: View Of Front Lift Bracket
Courtesy of GENERAL MOTORS CORP.

2. Remove the front lift bracket.

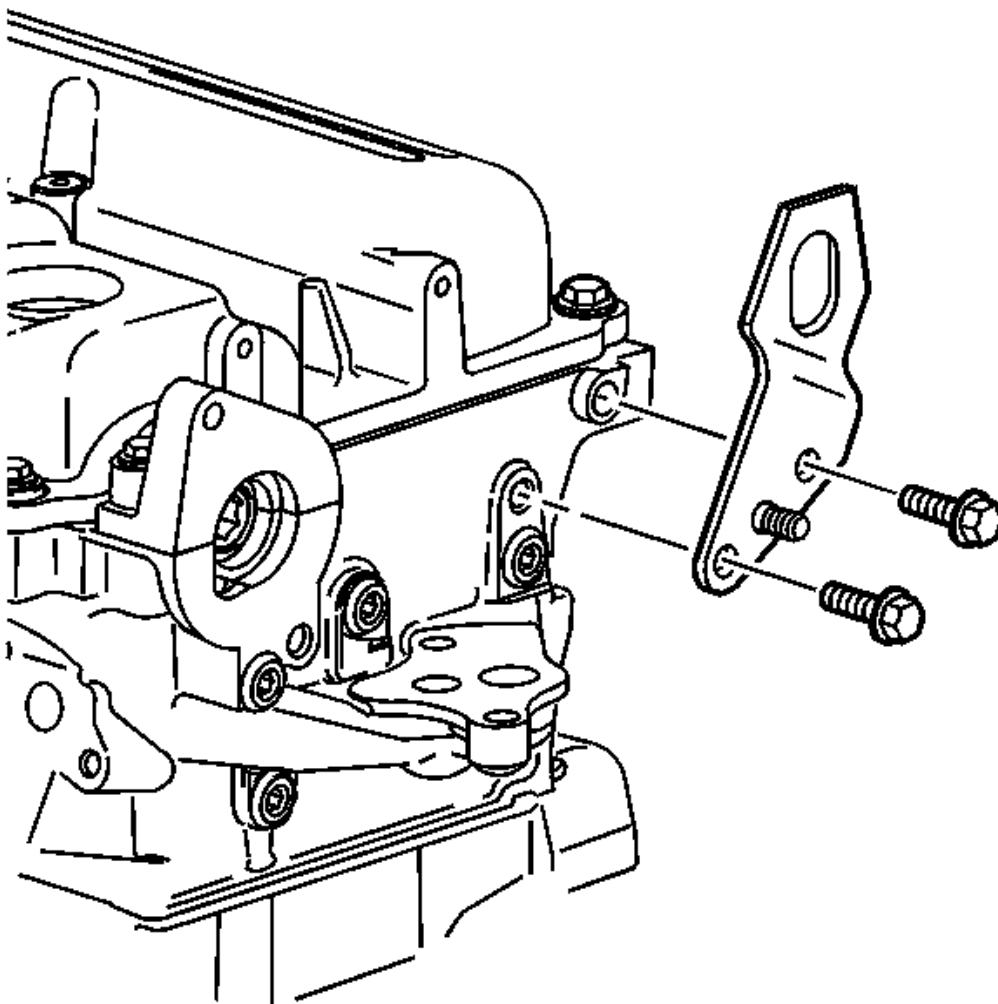


Fig. 264: View Of Rear Lift Bracket
Courtesy of GENERAL MOTORS CORP.

3. Remove the rear lift bracket.

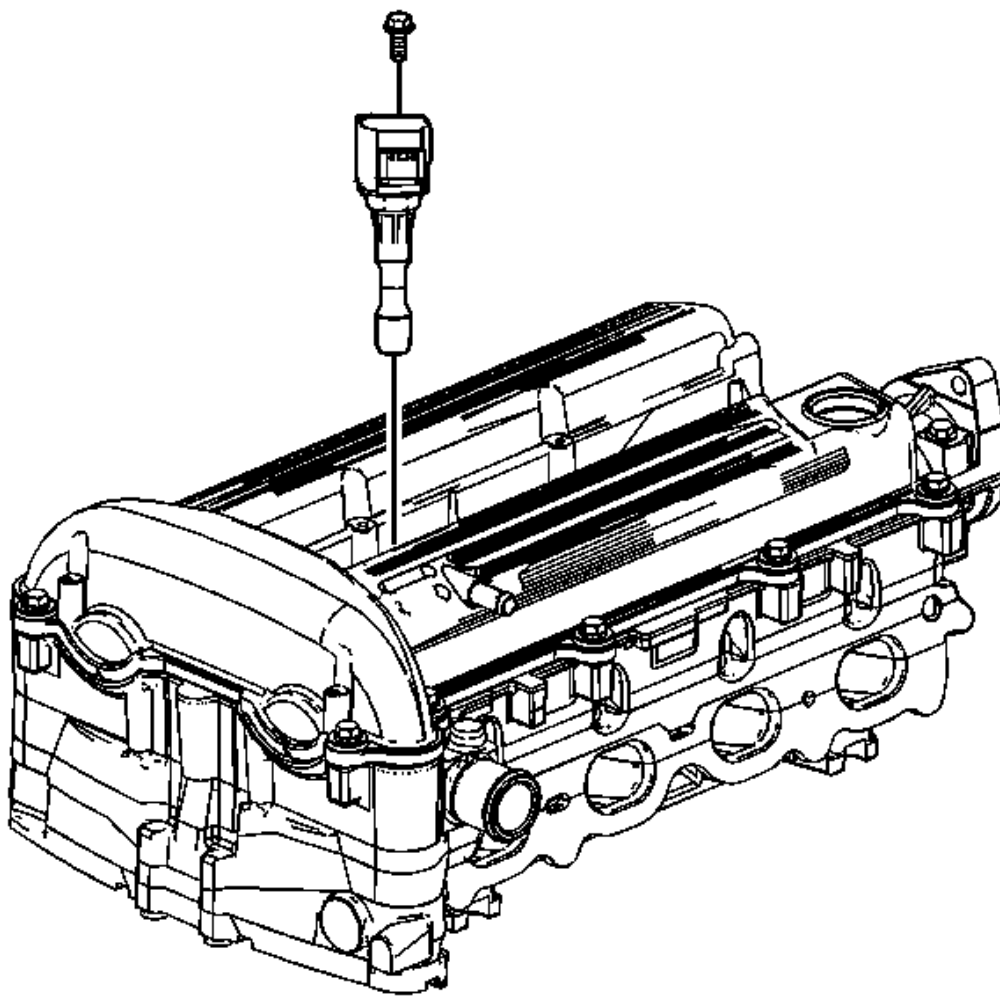


Fig. 265: View Of Ignition Coil And Mounting Bolt
Courtesy of GENERAL MOTORS CORP.

4. Remove the ignition coil bolts.
5. Remove the ignition coils.

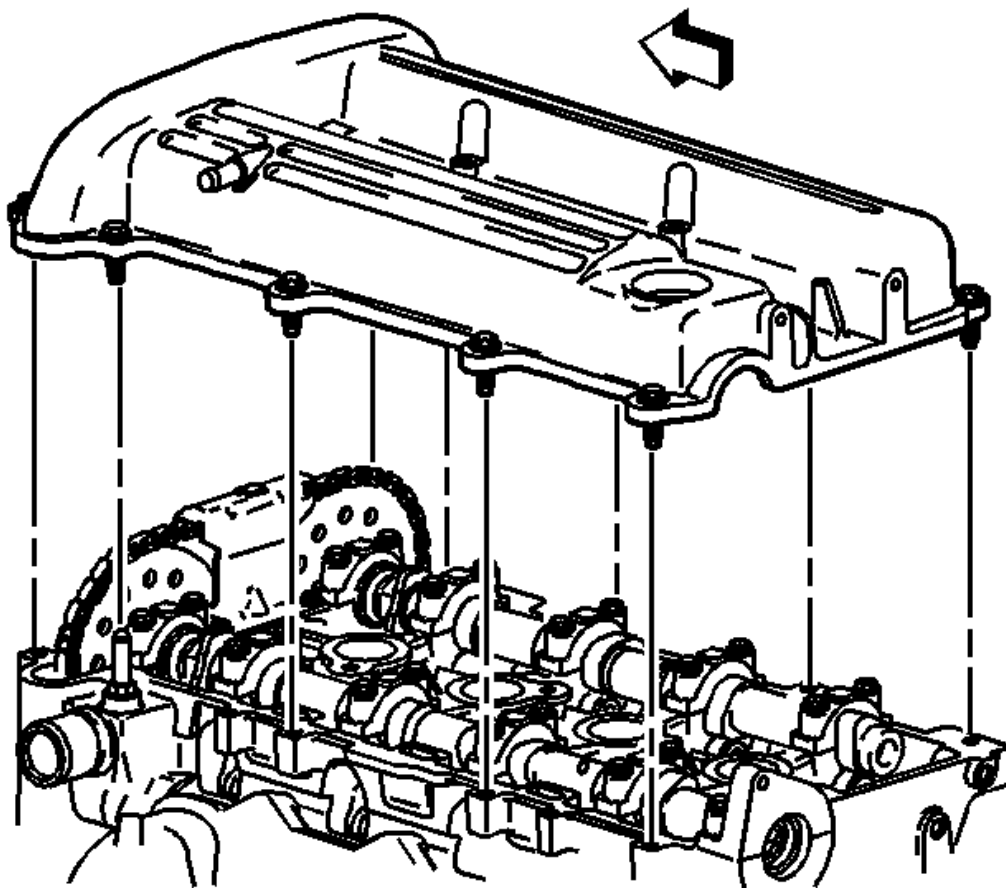


Fig. 266: View Of Camshaft Cover
Courtesy of GENERAL MOTORS CORP.

6. Remove the camshaft cover assembly.

ENGINE FRONT COVER AND OIL PUMP REMOVAL

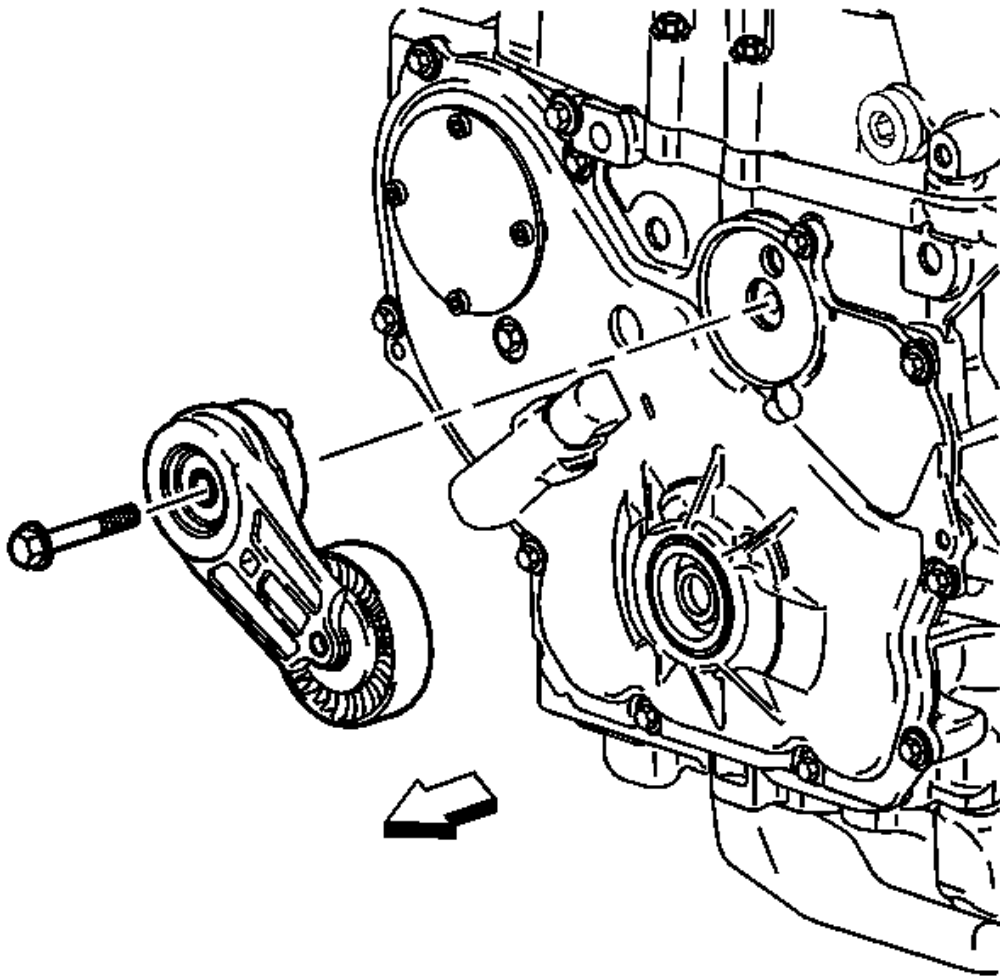


Fig. 267: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

1. Remove the accessory drive belt tensioner bolt.
2. Remove the accessory drive belt tensioner.

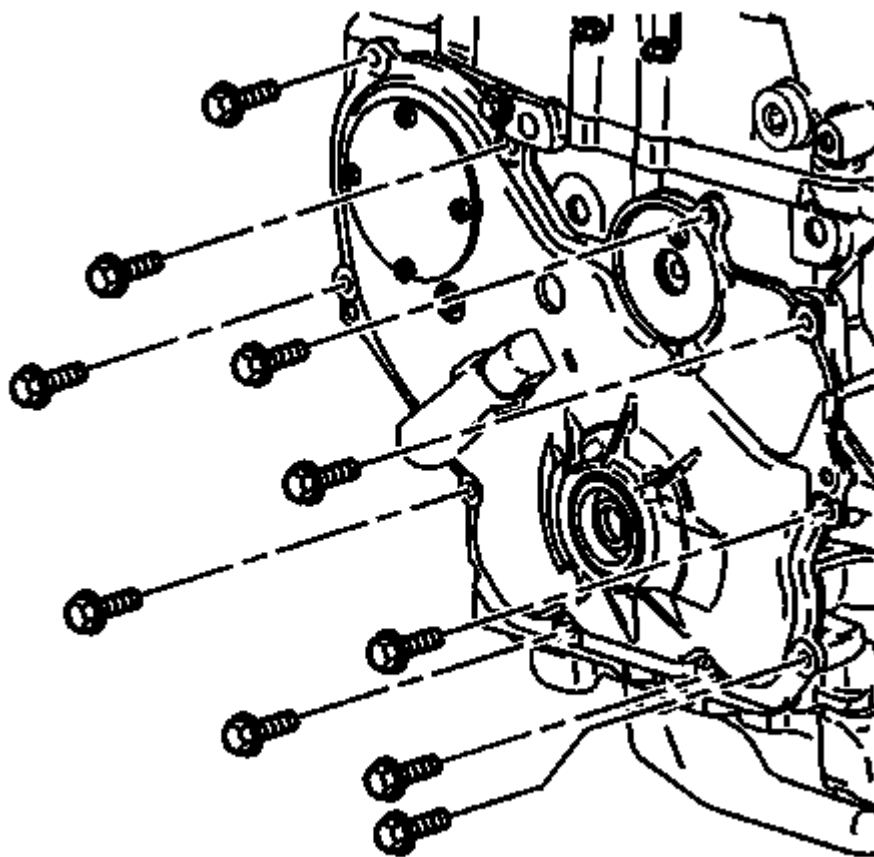


Fig. 268: View Of Engine Front Cover Bolts
Courtesy of GENERAL MOTORS CORP.

3. Remove the engine front cover bolts.

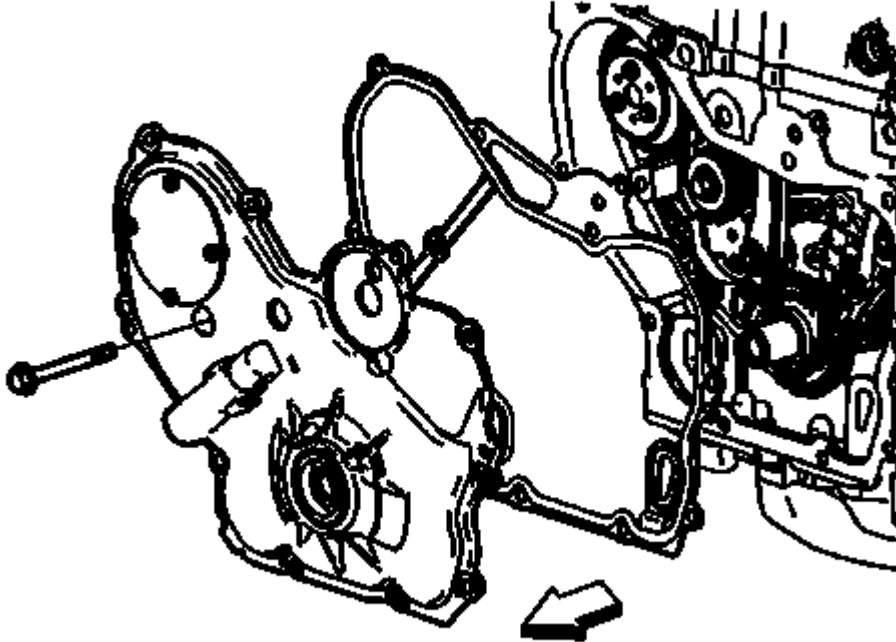


Fig. 269: View Of Engine Front Cover
Courtesy of GENERAL MOTORS CORP.

4. Remove the long water pump bolt.
5. Remove the engine front cover and gaskets.
6. Remove the crankshaft front cover oil seal with an appropriate tool.

TIMING CHAIN AND TENSIONER REMOVAL

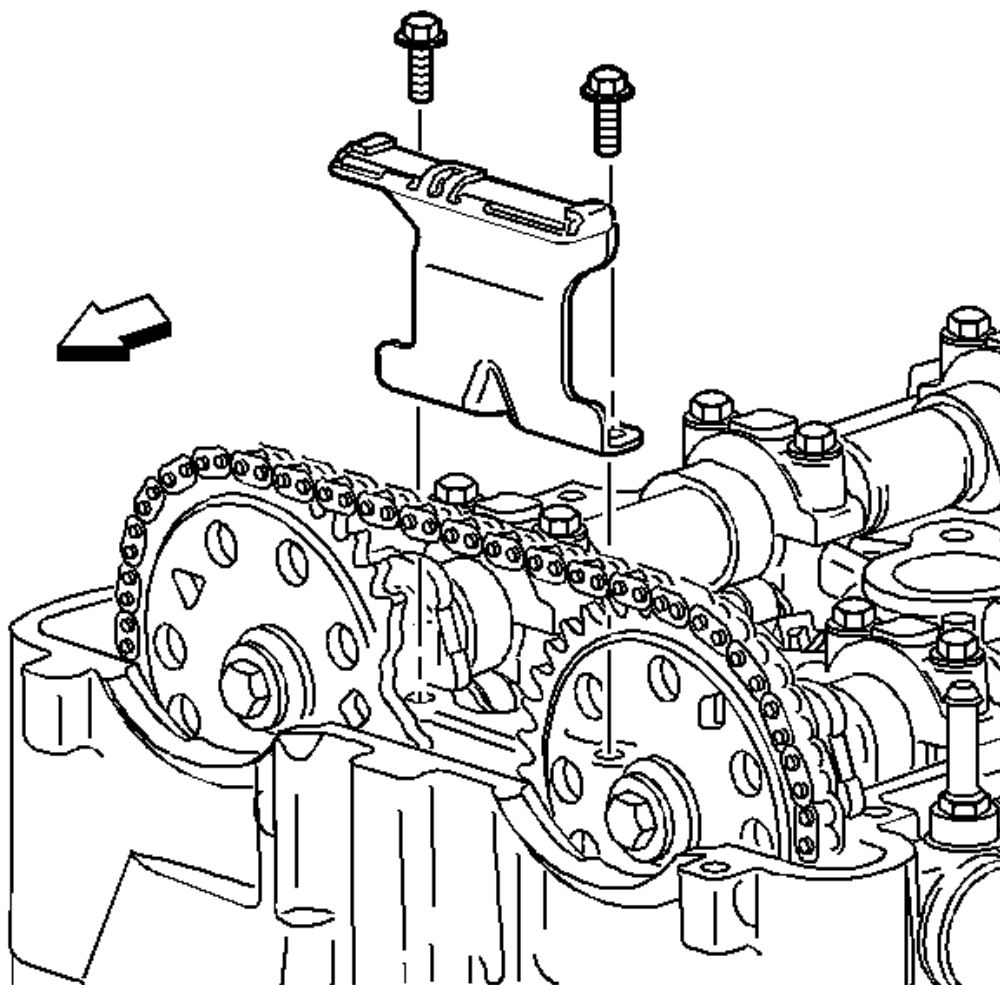


Fig. 270: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

1. Remove the upper timing chain guide bolts.
2. Remove the upper timing chain guide.

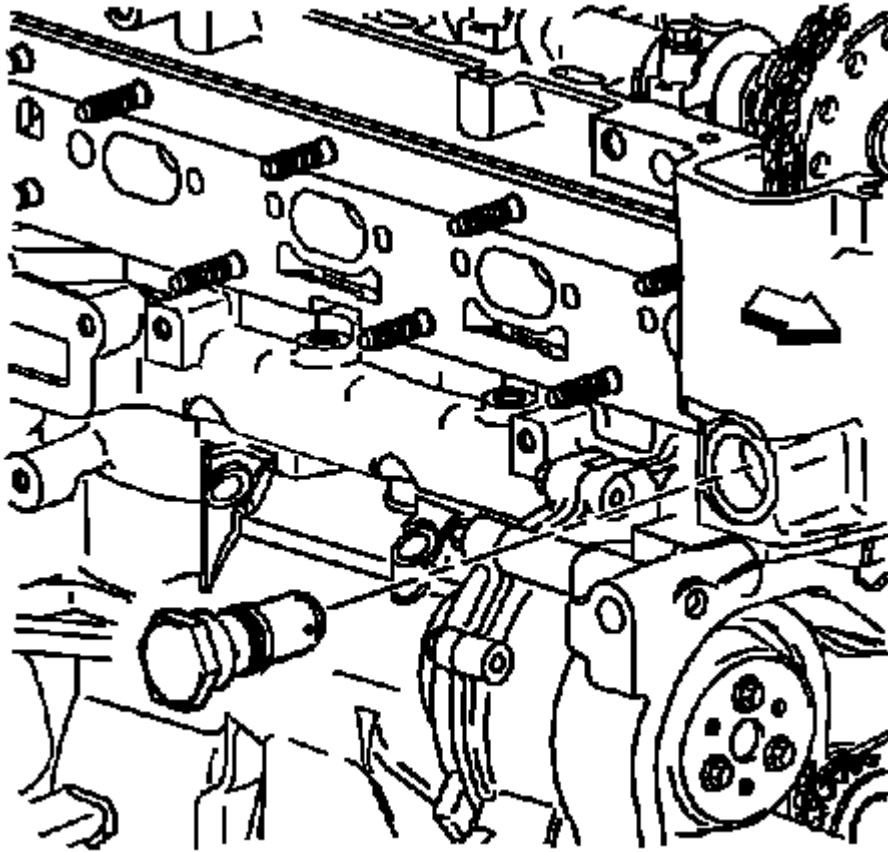


Fig. 271: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: The timing chain tensioner must be removed to unload chain tension before the timing chain is removed.

3. Remove the timing chain tensioner plunger.

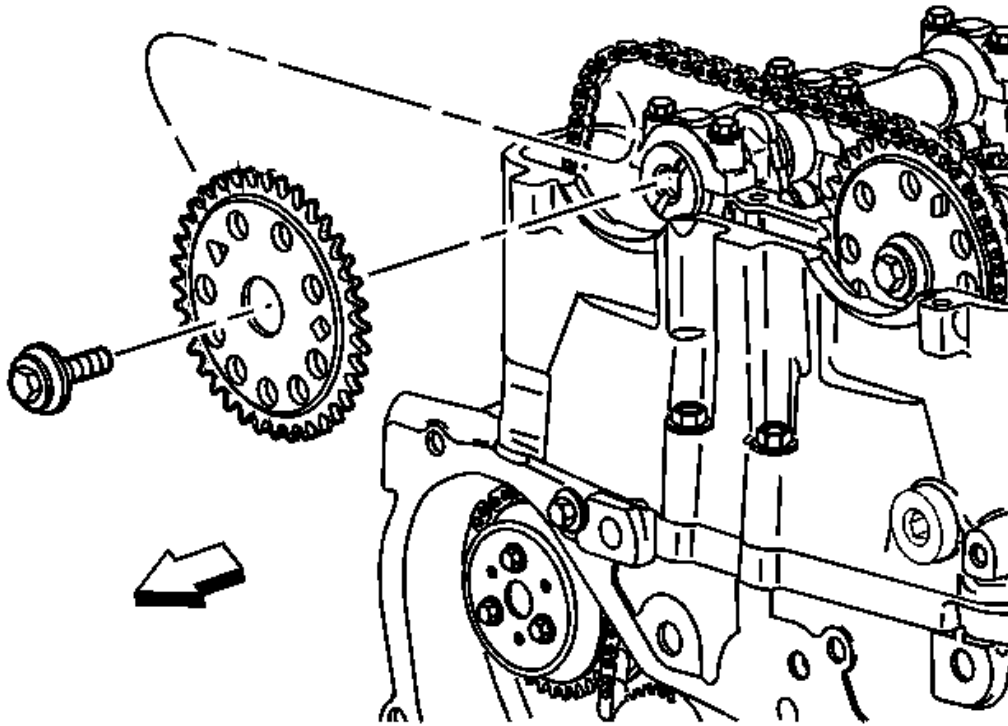


Fig. 272: Identifying Exhaust Camshaft Sprocket
Courtesy of GENERAL MOTORS CORP.

4. Locate hex on the exhaust camshaft and hold with a wrench.
5. Remove the exhaust camshaft bolt and the exhaust camshaft sprocket.

Discard the bolt.

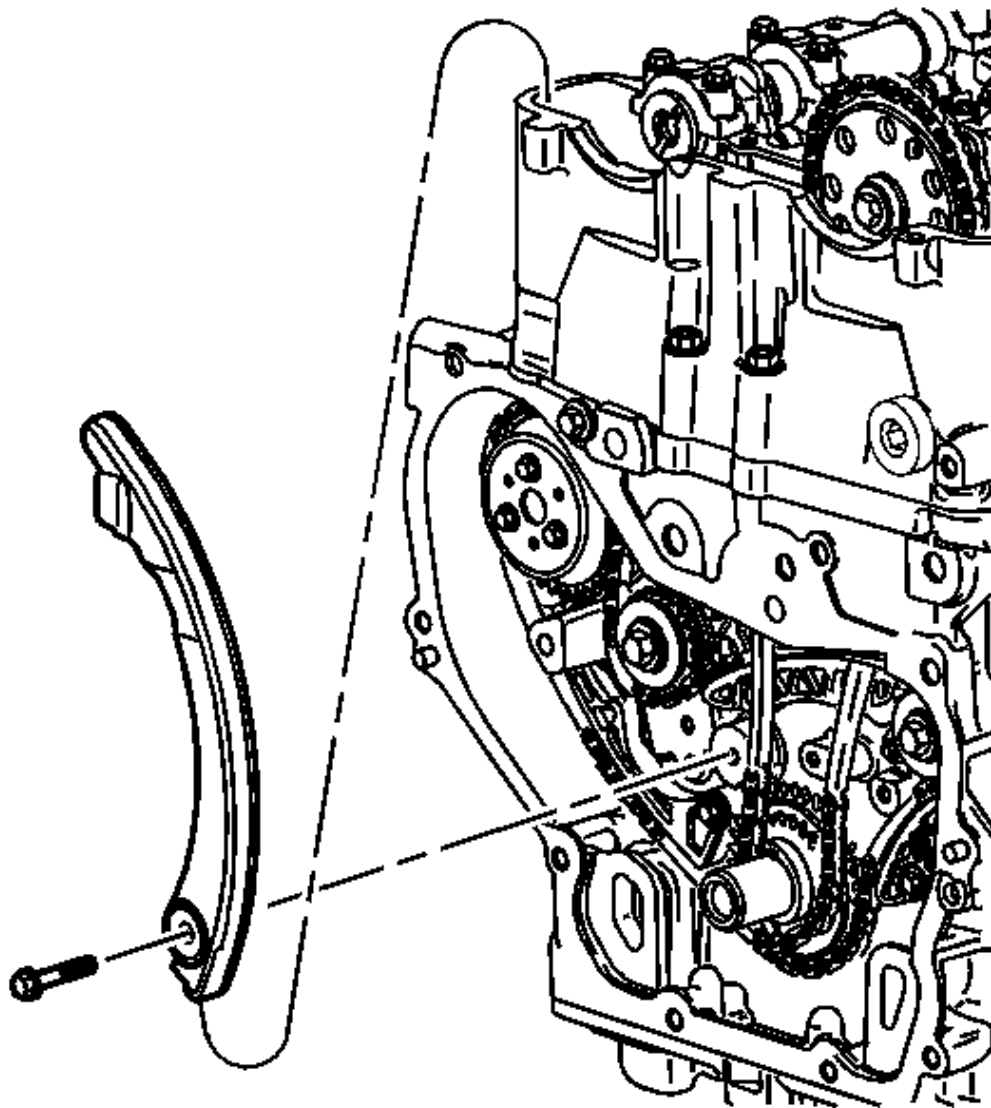


Fig. 273: View Of Timing Chain Tensioner Guide
Courtesy of GENERAL MOTORS CORP.

6. Remove the adjustable timing chain guide bolt.
7. Remove the adjustable timing chain guide.

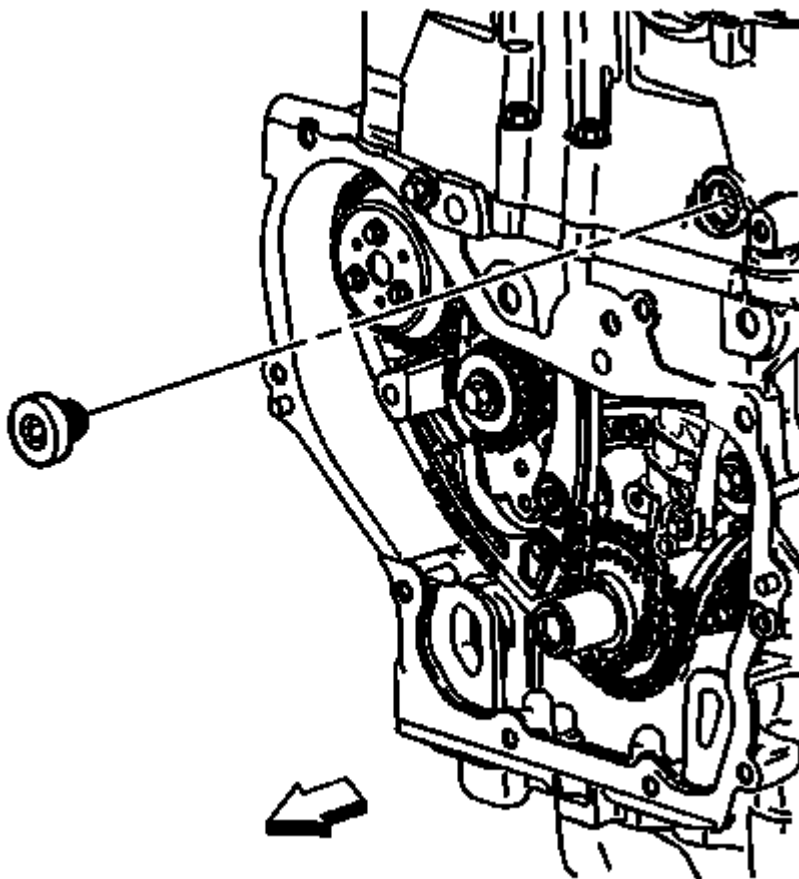


Fig. 274: View Of Fixed Timing Chain Guide Access Plug
Courtesy of GENERAL MOTORS CORP.

8. Remove the plug to gain access to the fixed timing chain guide bolt.

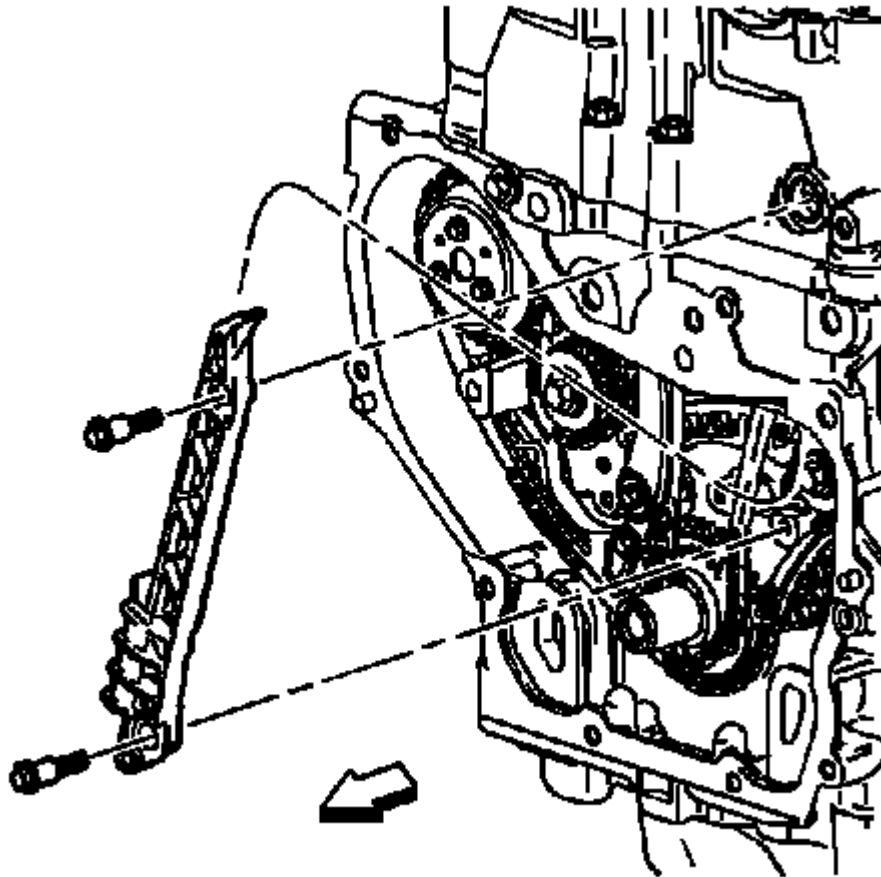


Fig. 275: View Of Fixed Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

9. Remove the fixed timing chain guide bolts.
10. Remove the fixed timing chain guide.

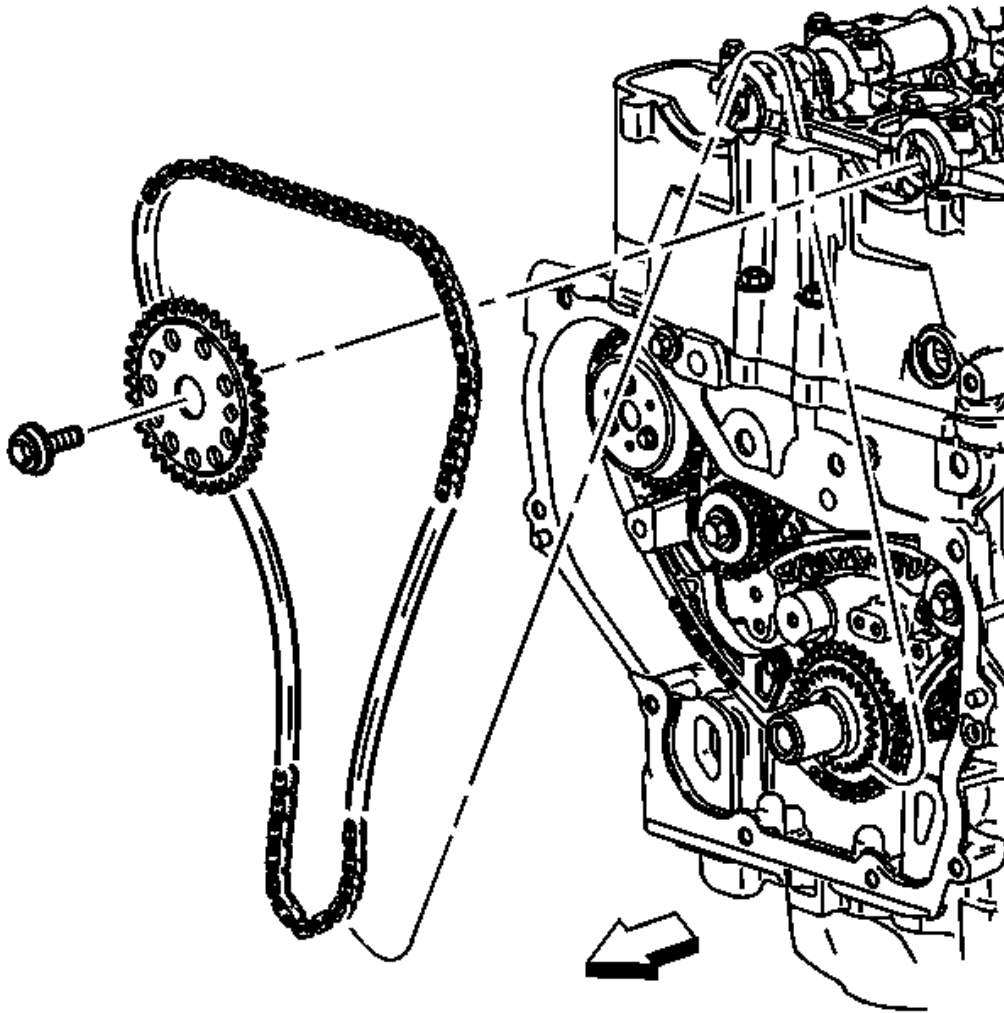


Fig. 276: View Of Intake Camshaft Sprocket And Chain
Courtesy of GENERAL MOTORS CORP.

11. Locate hex on the intake camshaft and hold with a wrench.
12. Remove the intake camshaft sprocket bolt, the intake camshaft sprocket and the timing chain through the top of the cylinder head.

Discard the bolt.

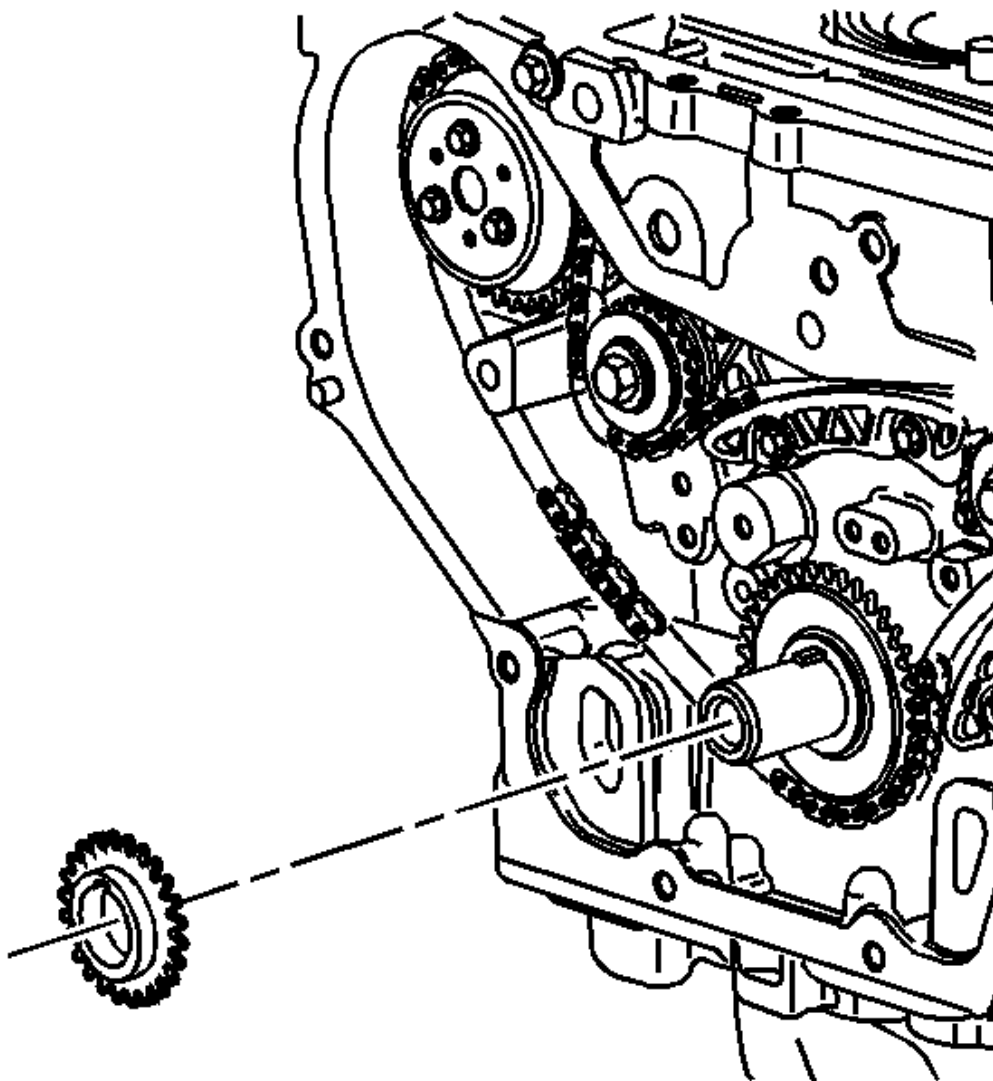


Fig. 277: View Of Crankshaft Sprocket
Courtesy of GENERAL MOTORS CORP.

13. Remove the crankshaft sprocket.

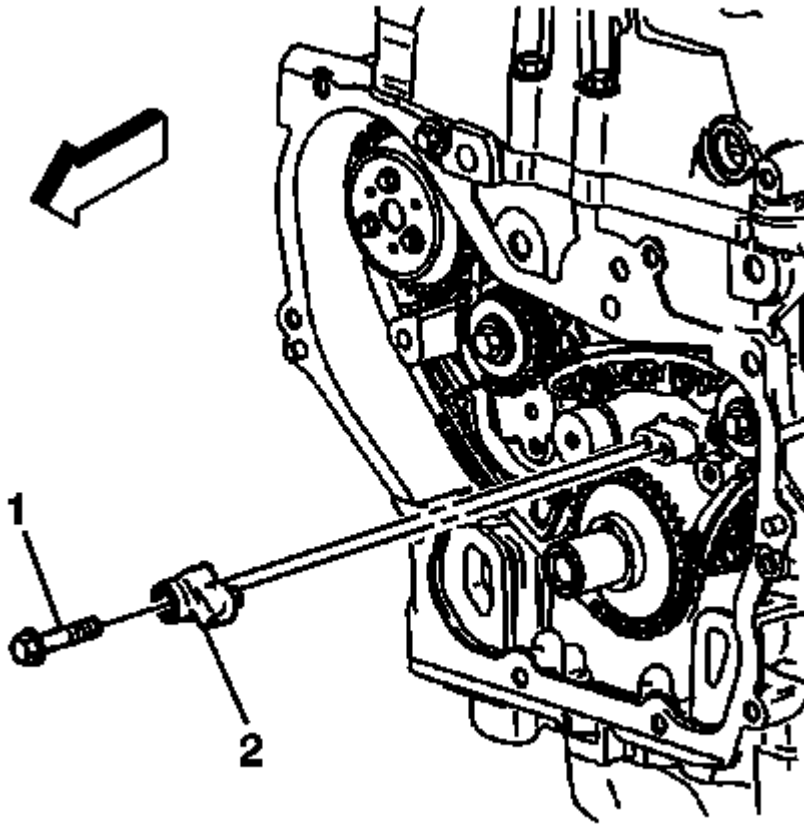


Fig. 278: View Of Oil Nozzle & Bolt
Courtesy of GENERAL MOTORS CORP.

14. Remove the oil nozzle and bolt.

INTAKE CAMSHAFT, BEARING CAP, AND LASH ADJUSTER REMOVAL

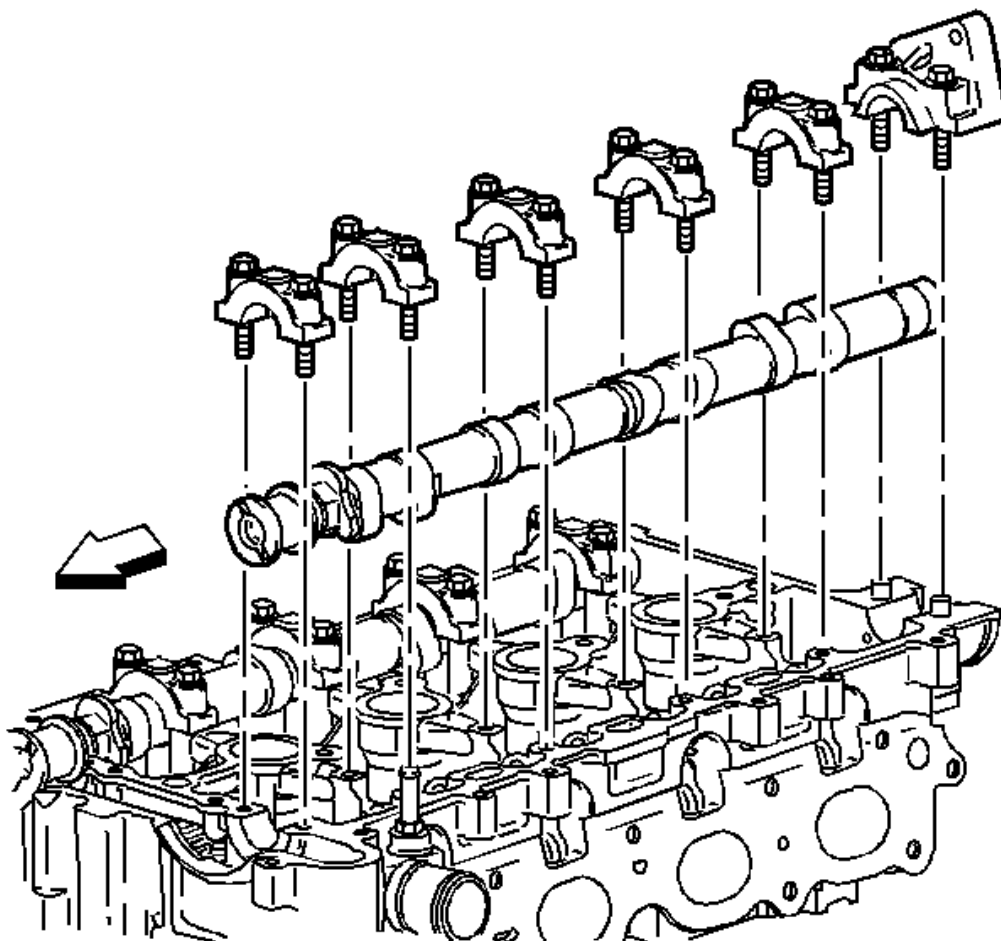


Fig. 279: View Of Intake Camshaft And Caps

Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Remove each bolt on each cap one turn at a time until there is no spring tension pushing on the camshaft.

1. Mark the camshaft caps to ensure they are installed in the same position.
2. Remove the intake camshaft cap bolts.
3. Remove the camshaft caps.
4. Remove the intake camshaft.

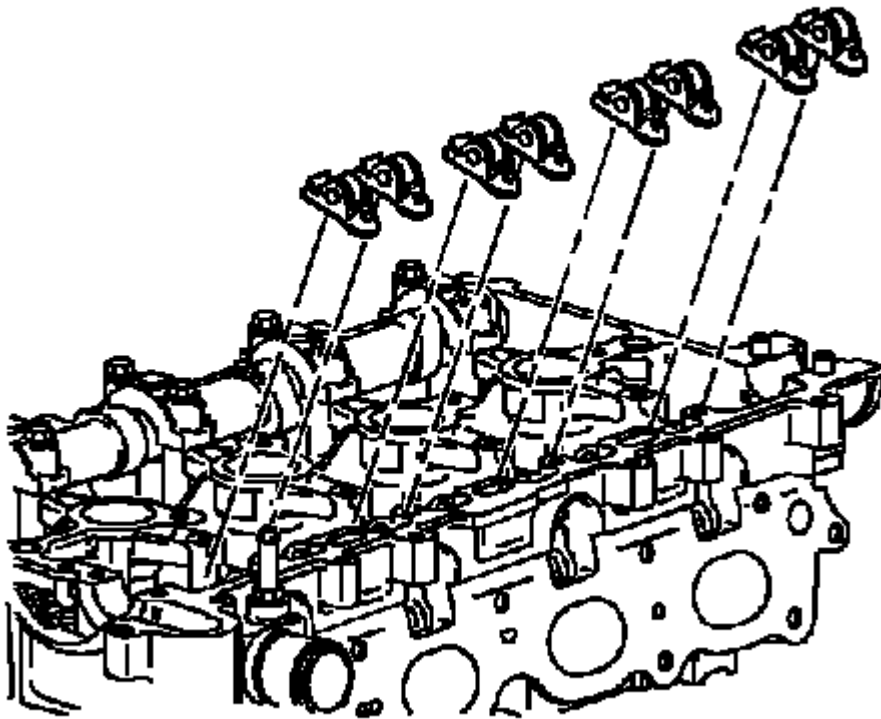


Fig. 280: View Of Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Keep all of the roller finger followers and hydraulic lash adjusters in order so that they can be reinstalled in their respective locations.

5. Remove the intake camshaft roller finger followers.

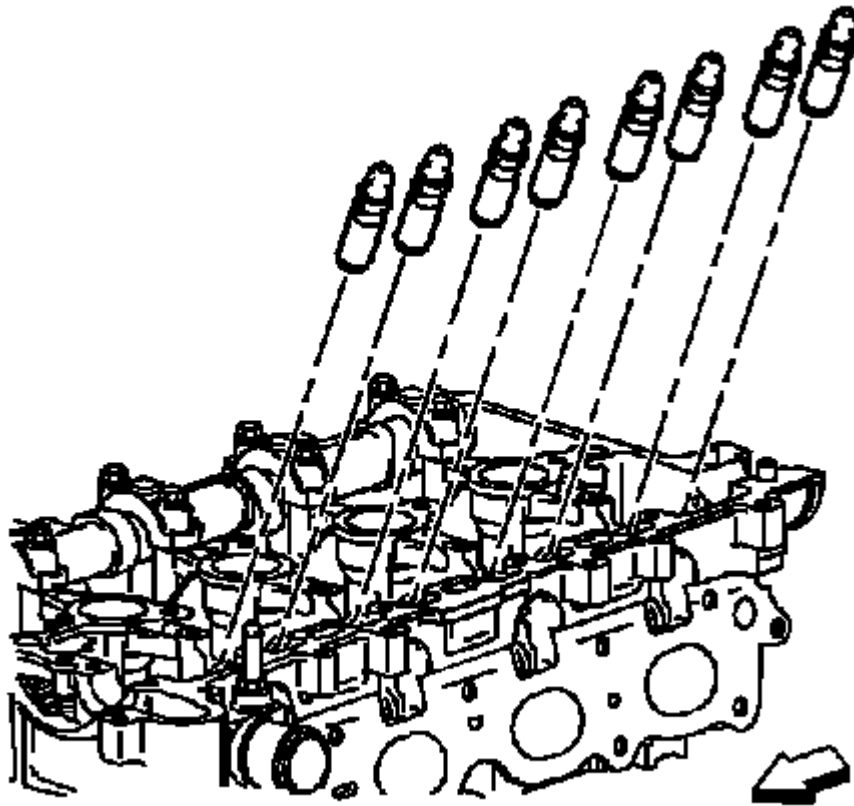


Fig. 281: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

6. Remove the hydraulic lash adjusters.

EXHAUST CAMSHAFT, BEARING CAP, AND LASH ADJUSTER REMOVAL

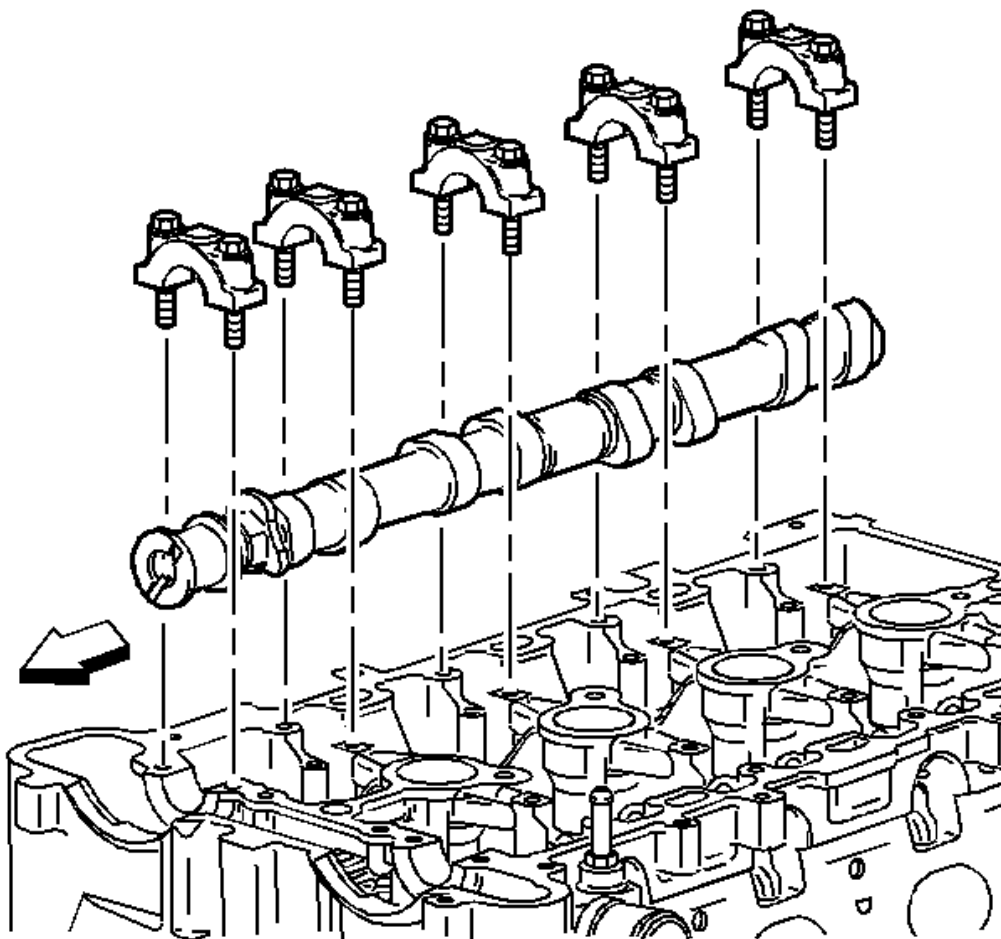


Fig. 282: View Of Camshaft & Bearing Caps

Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Remove each bolt on each cap one turn at a time until there is no spring tension pushing on the camshaft.

1. Mark the caps to ensure they are installed in the same position.
2. Remove the exhaust camshaft cap bolts.
3. Remove the camshaft caps ensuring they are marked and refitted in same position on assembly.
4. Remove the exhaust camshaft.

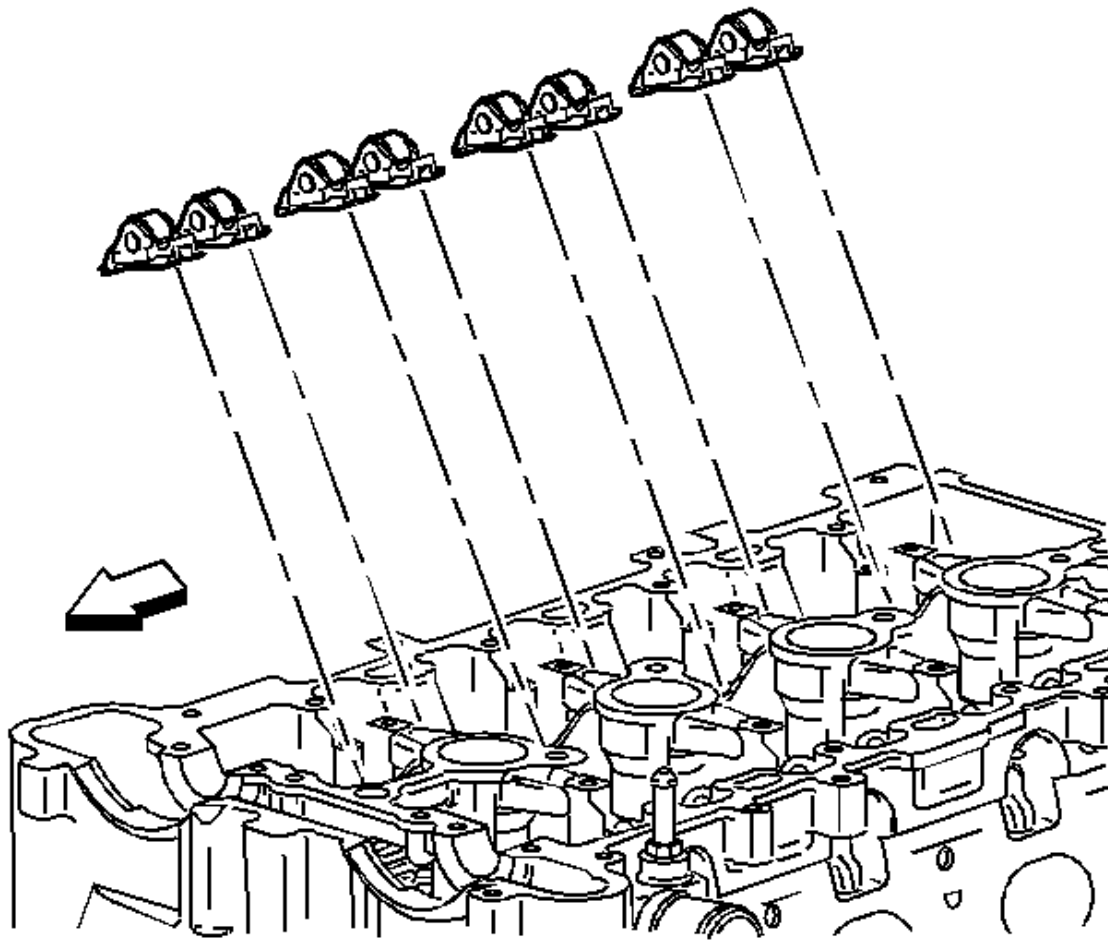


Fig. 283: Identifying Exhaust Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Keep all of the roller finger followers and hydraulic lash adjusters in order so that they can be reinstalled in their respective locations.

5. Remove the exhaust camshaft roller finger followers.

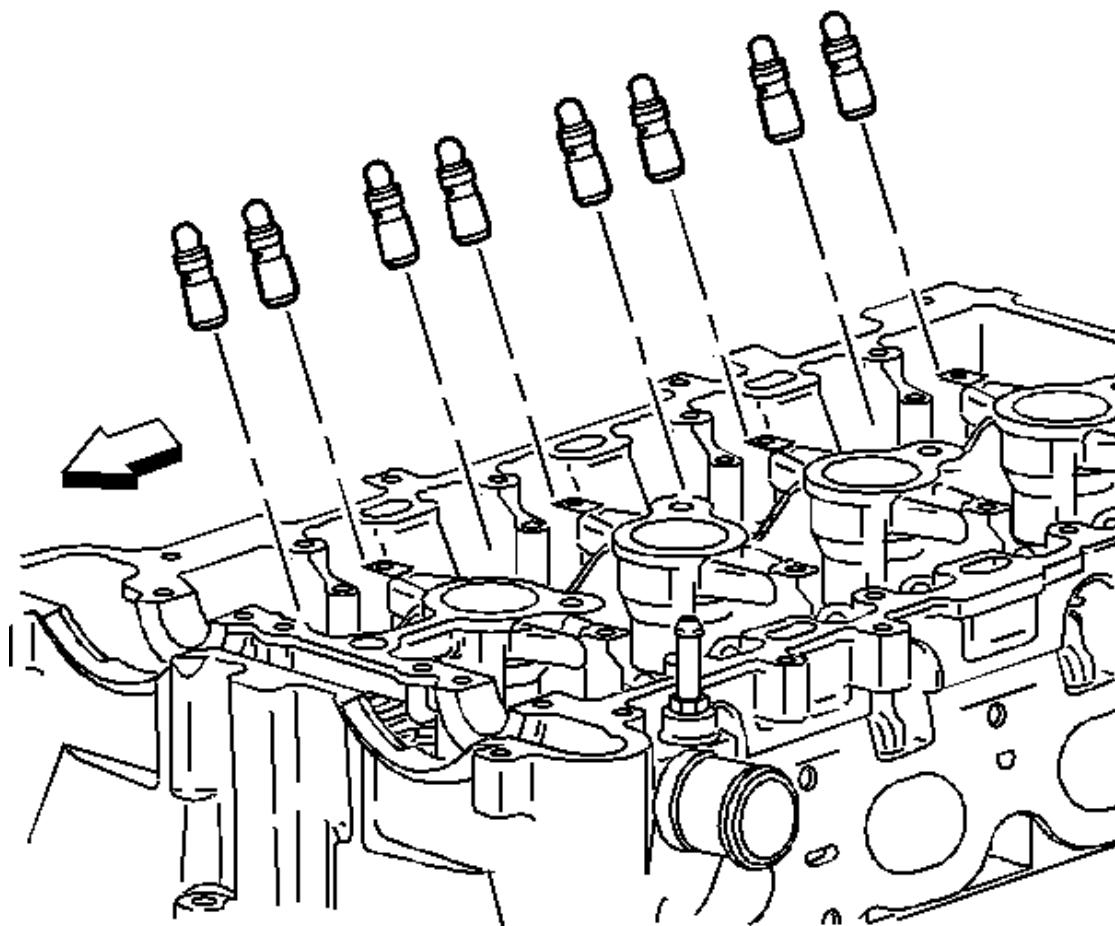


Fig. 284: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

6. Remove the hydraulic lash adjusters.

WATER PUMP AND BALANCE SHAFT CHAIN AND TENSIONER REMOVAL

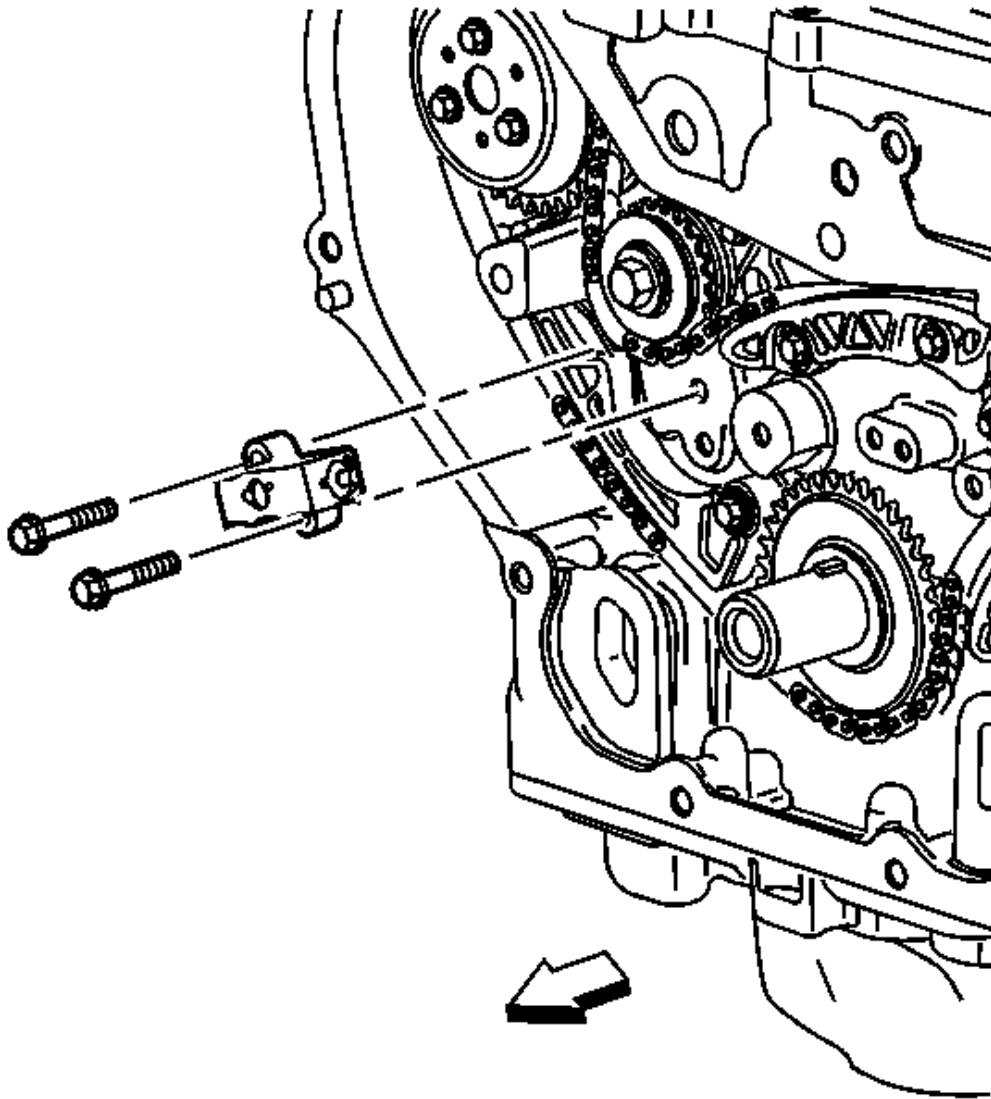


Fig. 285: Identifying Balance Shaft Drive Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

1. Remove the balance shaft drive chain tensioner bolts.
2. Remove the balance shaft drive chain tensioner.

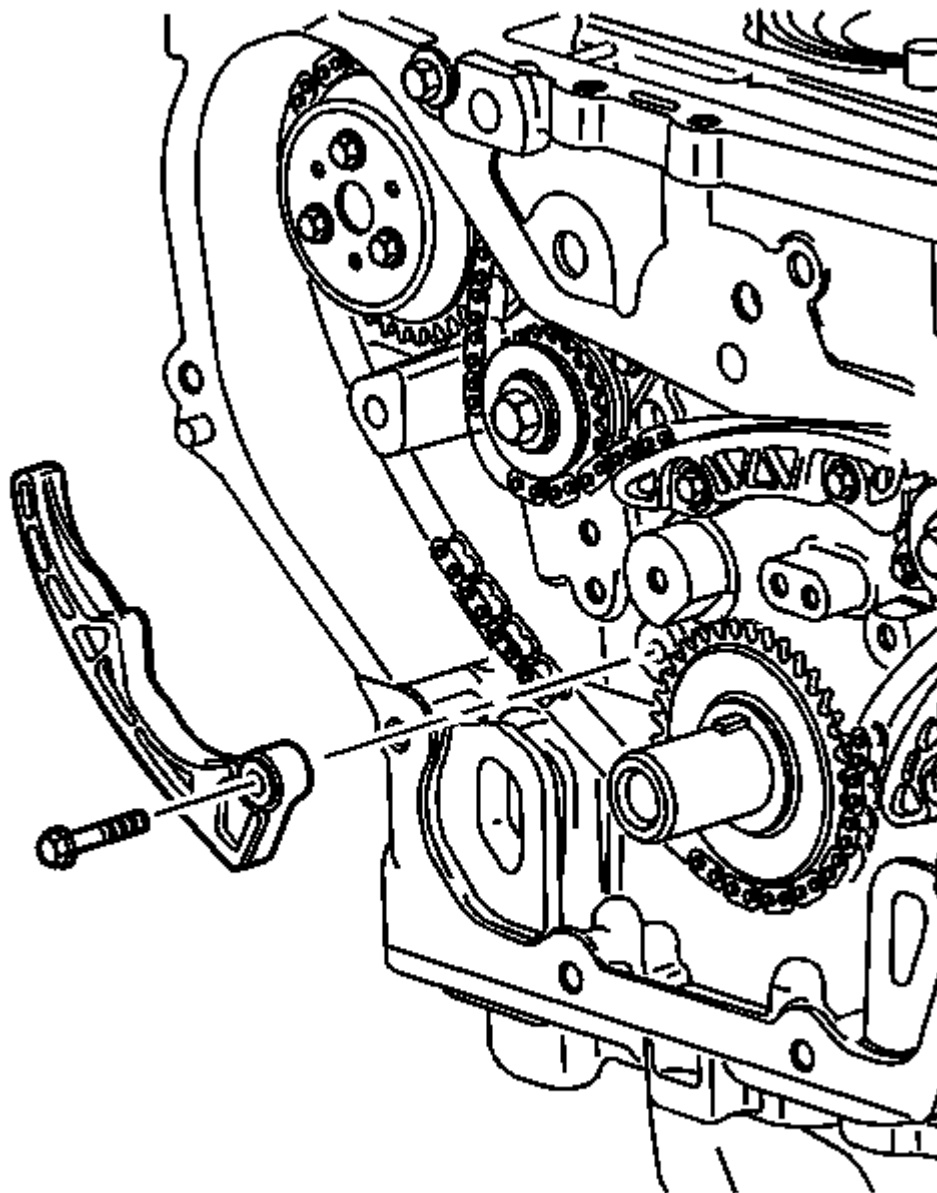


Fig. 286: View Of Adjustable Balance Shaft Chain Guide
Courtesy of GENERAL MOTORS CORP.

3. Remove the adjustable balance shaft chain guide bolt.
4. Remove the adjustable balance shaft chain guide.

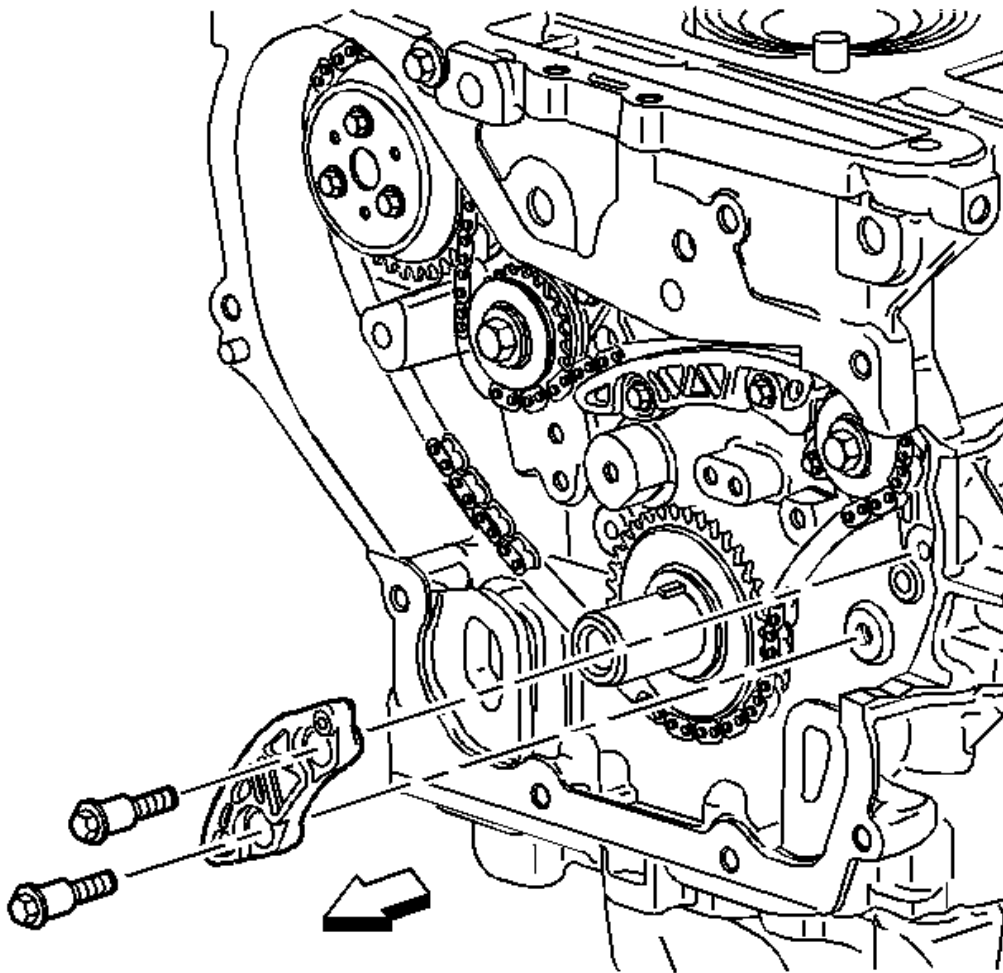


Fig. 287: Exploded View Of Small Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

5. Remove the small balance shaft drive chain guide bolts.
6. Remove the small balance shaft drive chain guide.

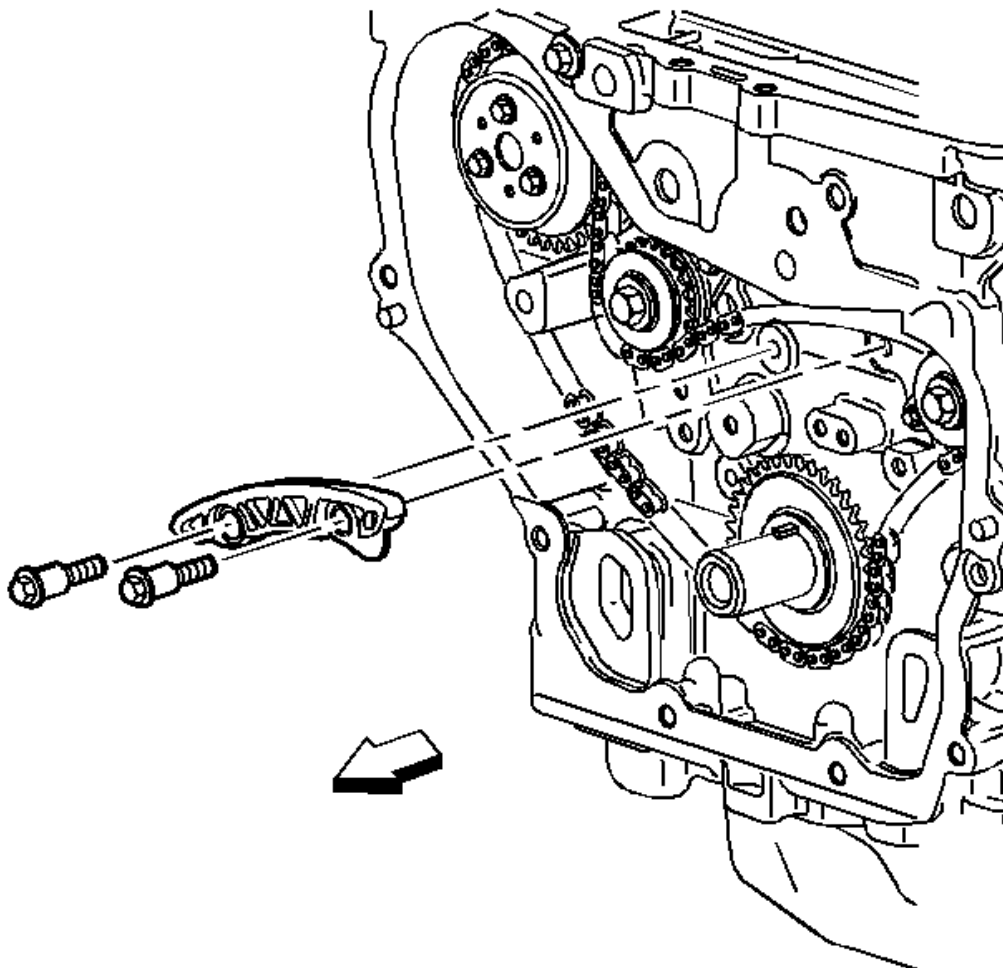


Fig. 288: View Of Upper Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

7. Remove the upper balance shaft drive chain guide bolts.
8. Remove the upper balance shaft drive chain guide.

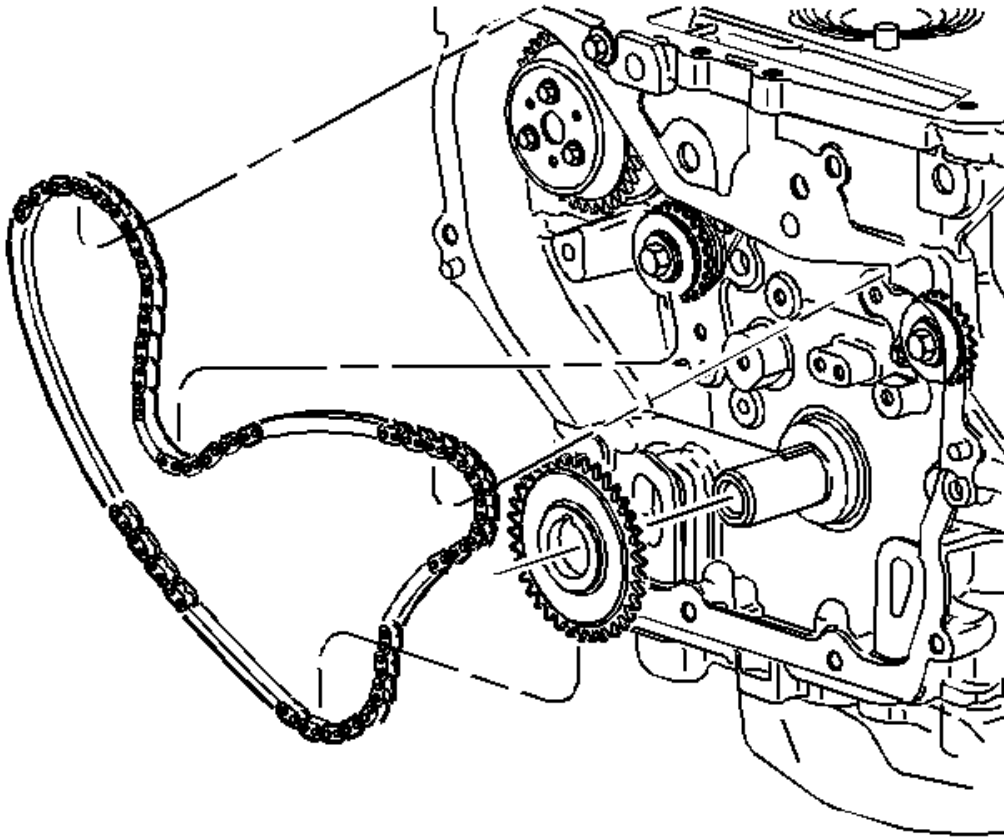


Fig. 289: Identifying Upper Balance Shaft Drive Chain/Sprocket
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: It may ease removal of the balance shaft drive chain to get all of the slack in the chain between the crankshaft and water pump sprockets.

9. Remove the balance shaft drive chain.
10. Remove the balance shaft drive sprocket.

BALANCE SHAFT REMOVAL

Tools Required

J 43650 Balancer Shaft Bearing Remover and Installer

Removal Procedure

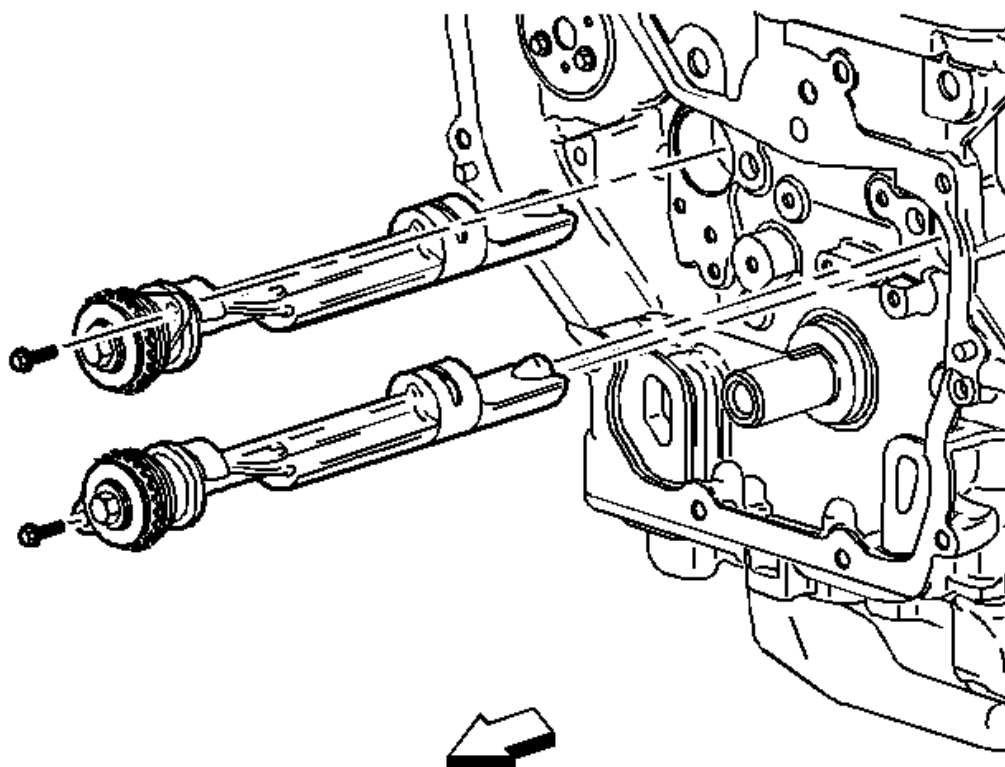


Fig. 290: View Of Balance Shafts assemblies
Courtesy of GENERAL MOTORS CORP.

1. Remove the balance shaft bearing carrier bolts.

IMPORTANT:

- It is possible to install the intake side balance shaft into the exhaust side and vice versa. Please use care not to install the balance shafts into the wrong bores. Engine vibration will result.
- Do not remove the bolt holding the sprocket.

2. Remove the balance shaft assemblies.

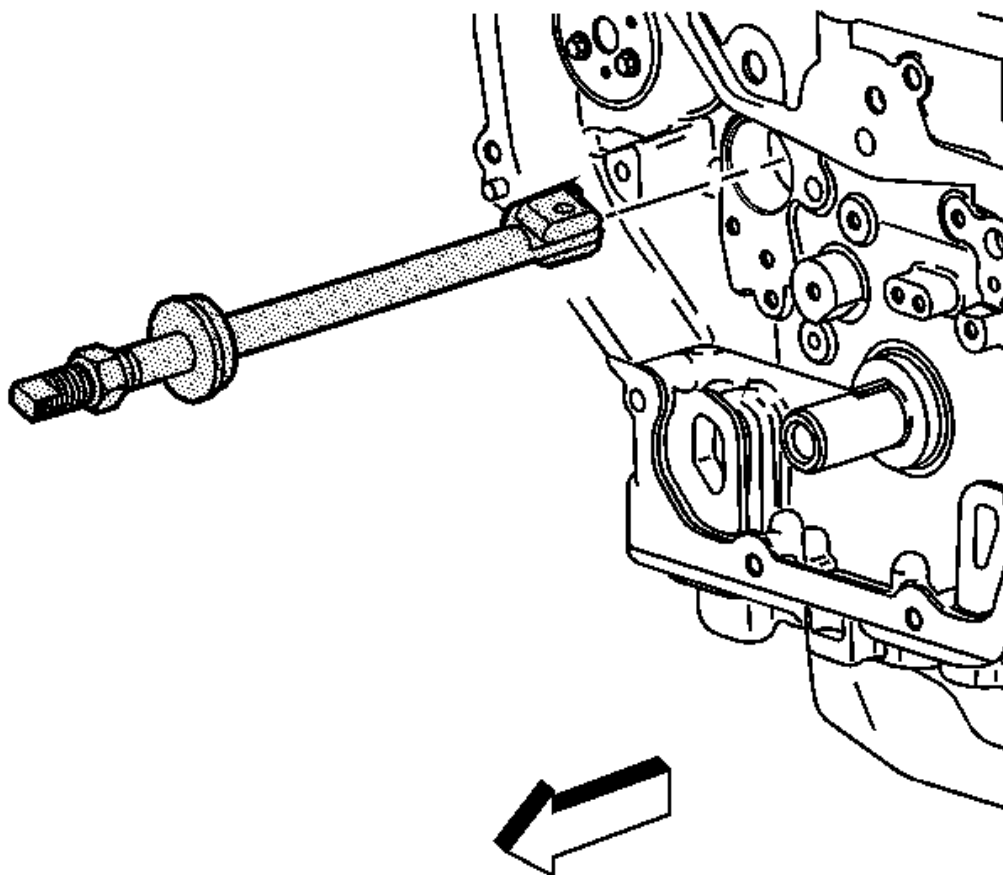


Fig. 291: Identifying J 43650
Courtesy of GENERAL MOTORS CORP.

NOTE: Proper centering of the tool is required on the balance shaft bushing. If the tool is not properly centered then damage to the bearing bore and block will occur.

3. Install the **J 43650** into the balance shaft hole. Insert the tool with the foot parallel to the shaft.

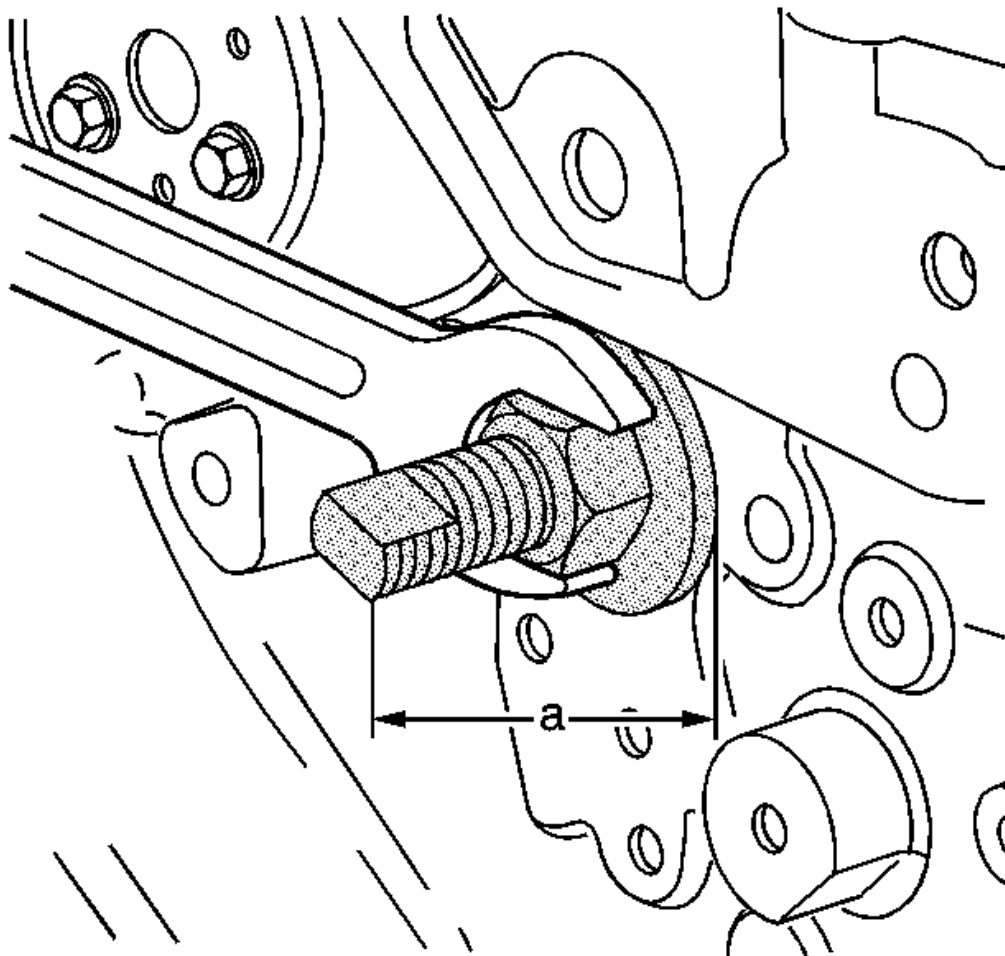


Fig. 292: Using J 43650

Courtesy of GENERAL MOTORS CORP.

4. When the **J 43650** is inserted in the block turn the **J 43650** so that the foot becomes perpendicular to the shaft.
5. Center the foot of the **J 43650** on the balance shaft bushing.
6. Once the **J 43650** is centered on the balance shaft bushing, then insert the centering guide into the front balance shaft bore and tighten the nut with an appropriate wrench.

When the **J 43650** is properly installed, before removing the bushing, the end of the tool should be 116 mm (4.6 in) (a) from the block face.

If the **J 43650** is less than approximately 114 mm (4.5 in) (a), recheck the tool alignment.

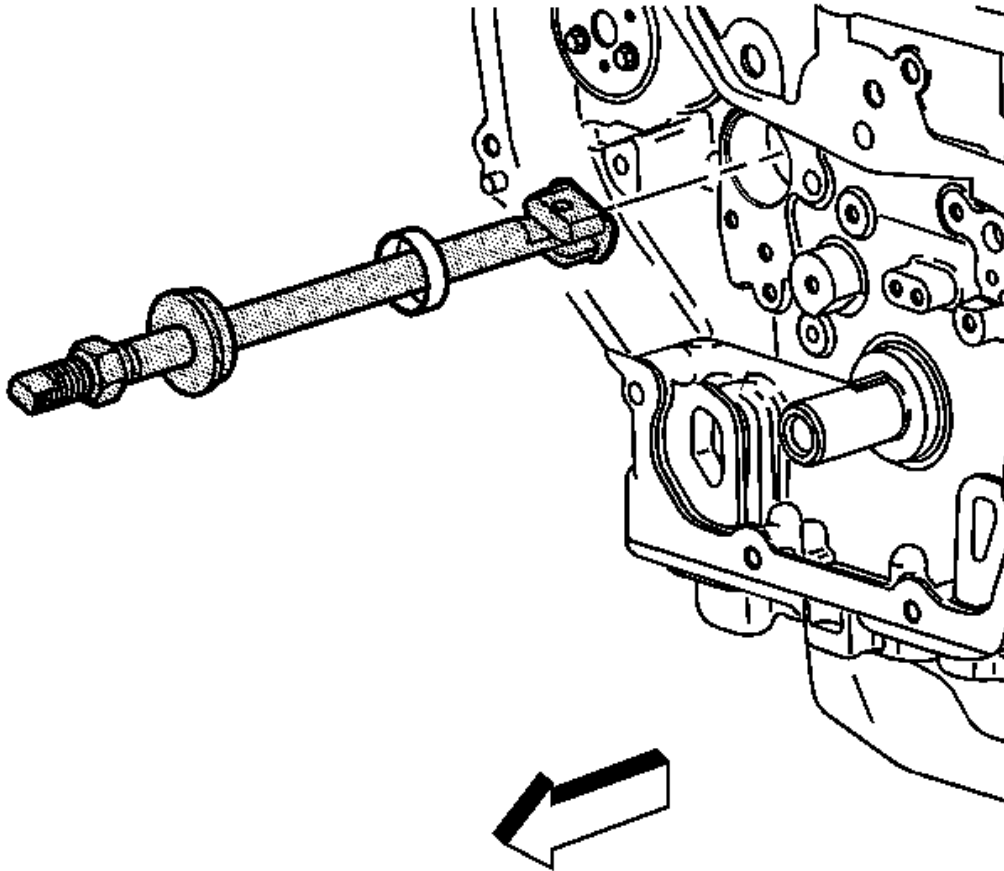


Fig. 293: Removing J 43650 & Balance Shaft Bushing
Courtesy of GENERAL MOTORS CORP.

7. Tighten the nut on the **J 43650** until the tension releases. When the tension releases, remove the **J 43650** and the balance shaft bushing.

WATER PUMP REMOVAL

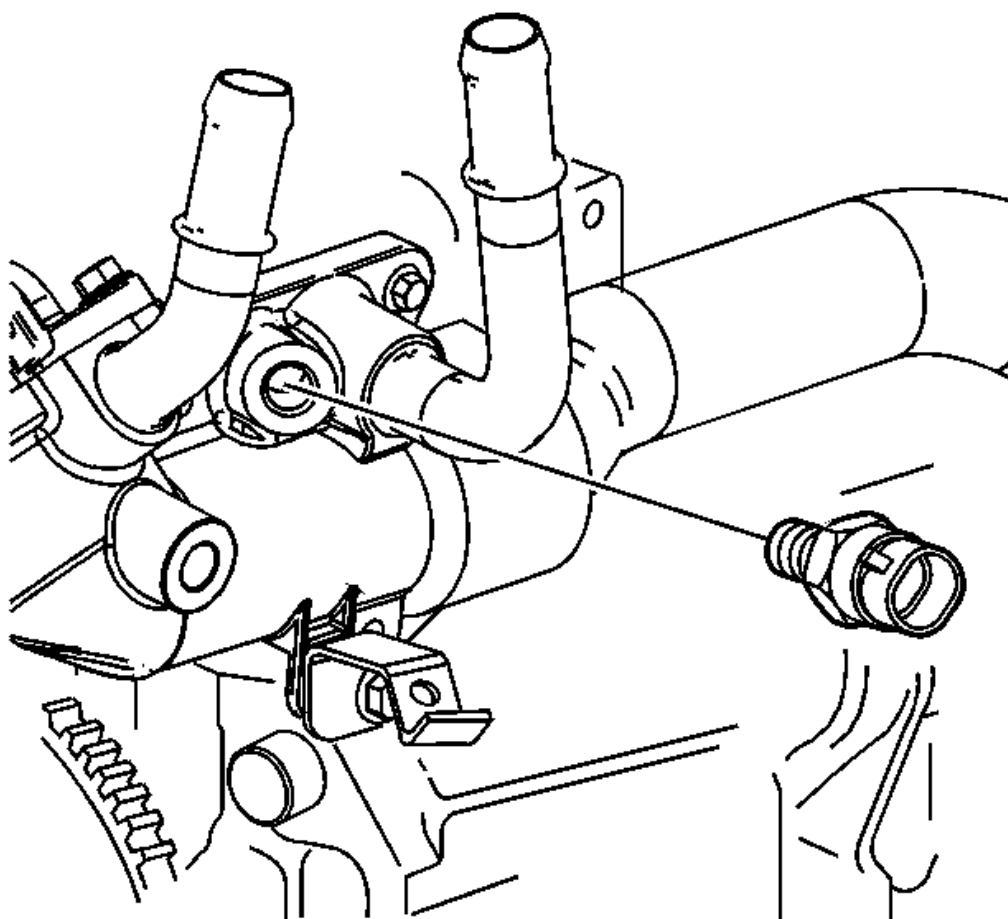


Fig. 294: Locating Engine Coolant Temperature Sensor
Courtesy of GENERAL MOTORS CORP.

1. Remove the engine coolant temperature sensor.

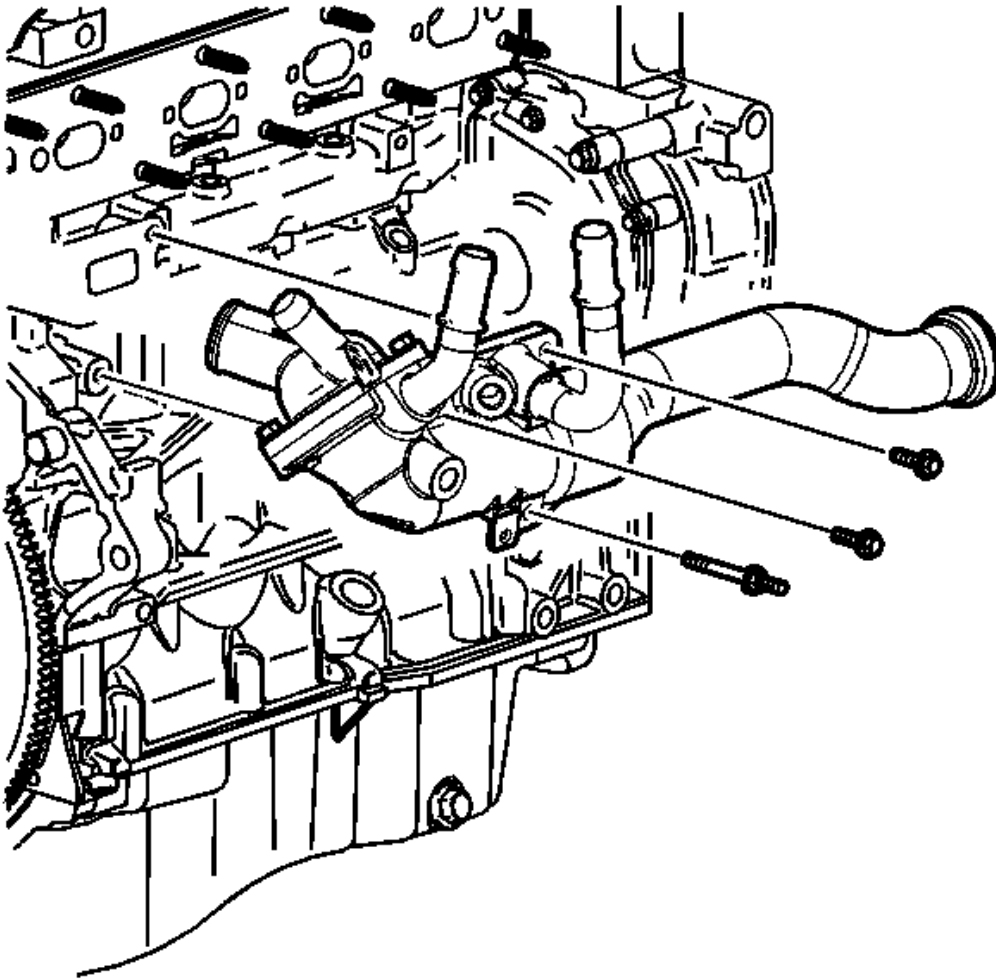


Fig. 295: View Of Thermostat & Water Feed Pipe Retaining Bolts
 Courtesy of GENERAL MOTORS CORP.

2. Remove the thermostat and water feed pipe retaining bolts.

IMPORTANT: Twist the water feed pipe while pulling to remove it from the water pump cover.

3. Remove the thermostat housing and water feed pipe from the water pump cover.

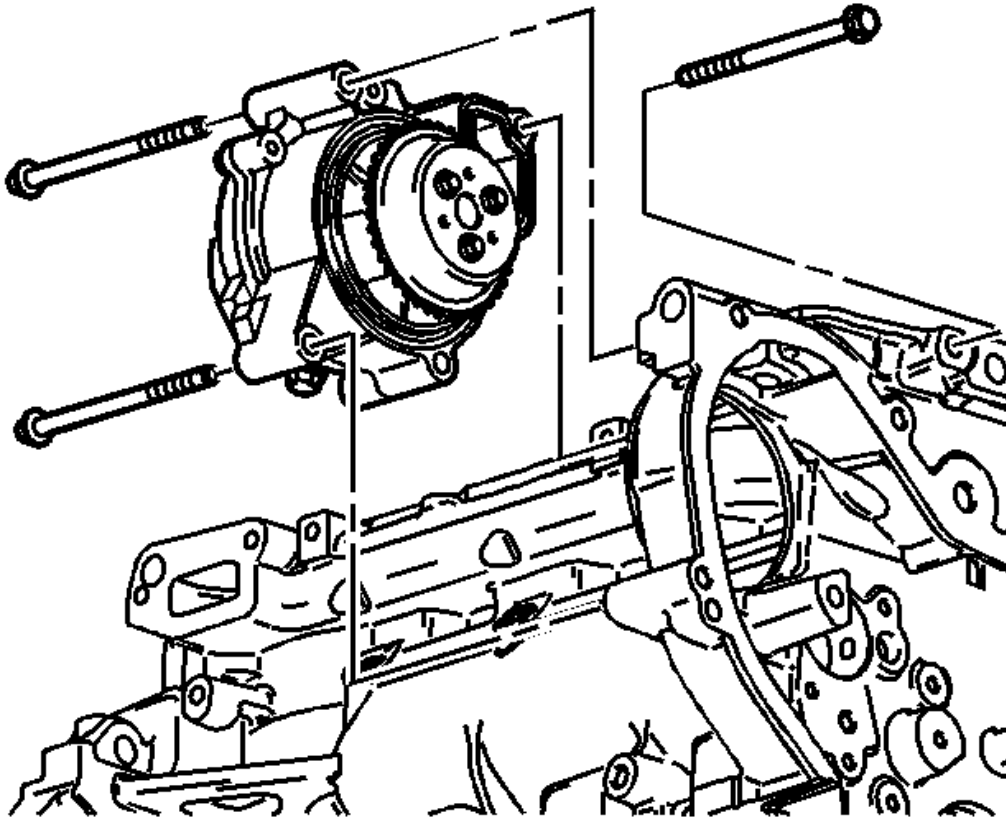


Fig. 296: View Of Water Pump Assembly
Courtesy of GENERAL MOTORS CORP.

4. Remove the water pump retaining bolts. Be sure to remove the bolt that goes through the front of the engine block.
5. Remove the water pump assembly.

CYLINDER HEAD REMOVAL

Tools Required

J 38188 Cylinder Head Broken Bolt Extractor Kit

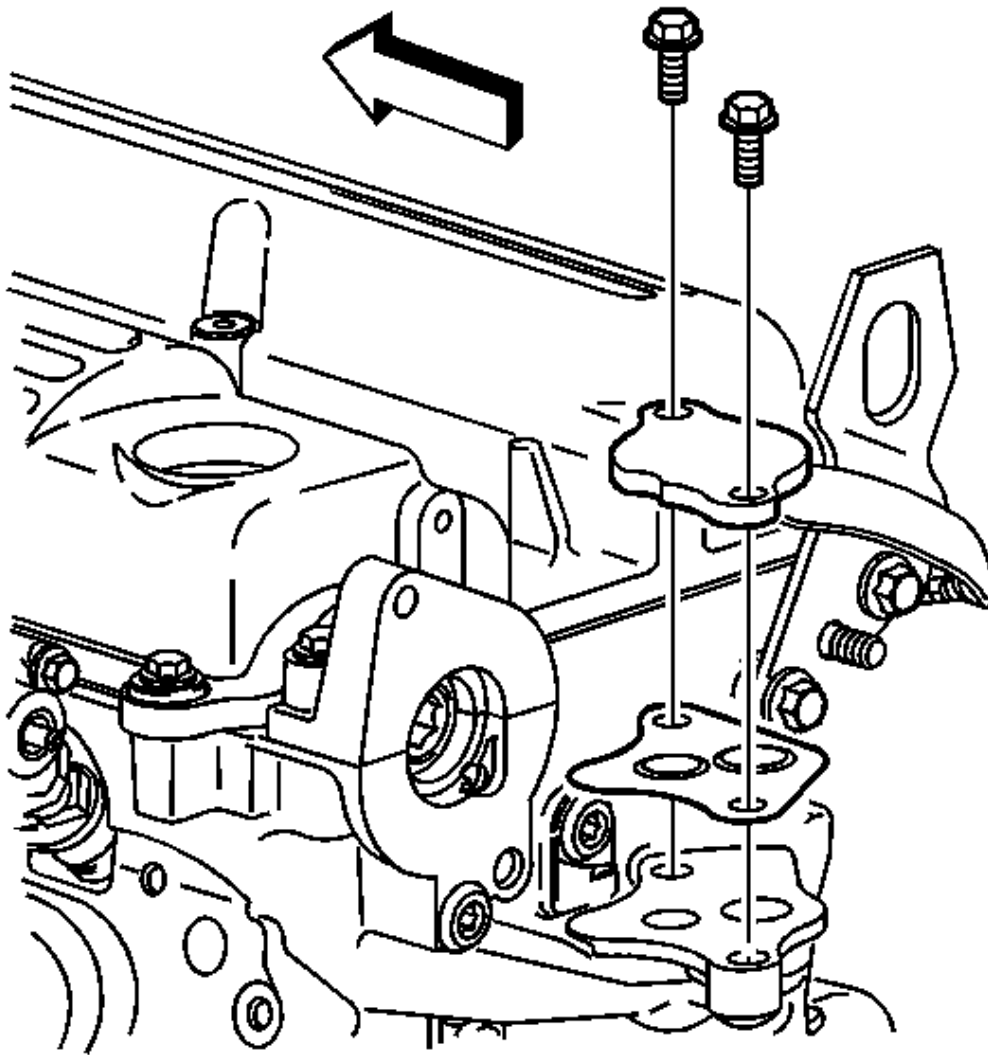


Fig. 297: Identifying EGR Cover, Bolts, And Cover Gasket
Courtesy of GENERAL MOTORS CORP.

1. Remove the exhaust gas recirculation (EGR) cover, bolts, and the EGR cover gasket.

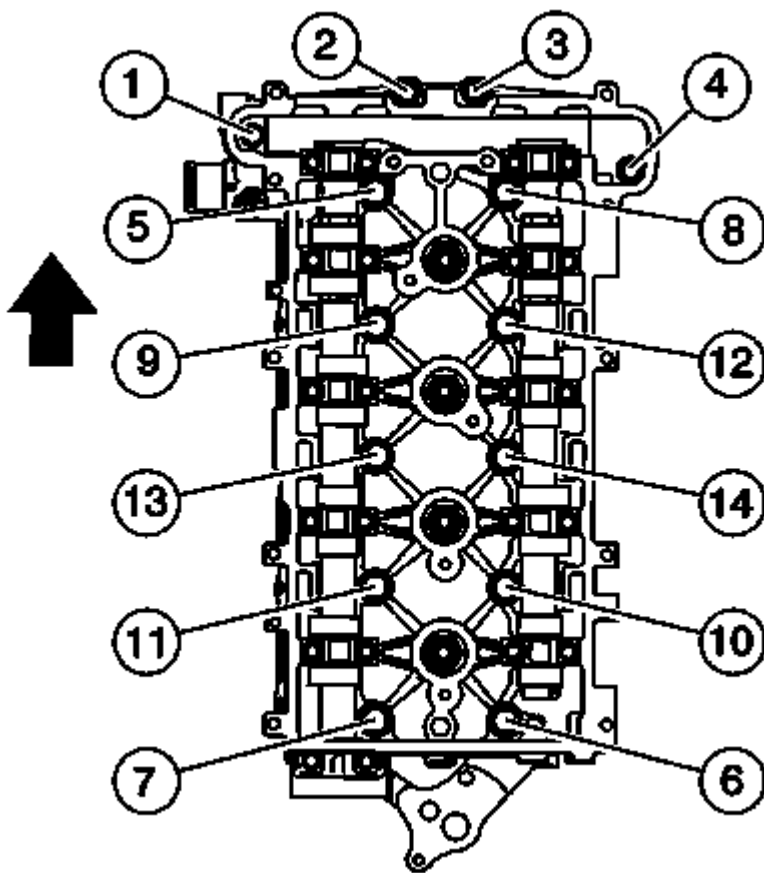


Fig. 298: Cylinder Head Bolt Removal Sequence
Courtesy of GENERAL MOTORS CORP.

2. Remove the cylinder head to the block bolts in sequence.

Discard the bolts.

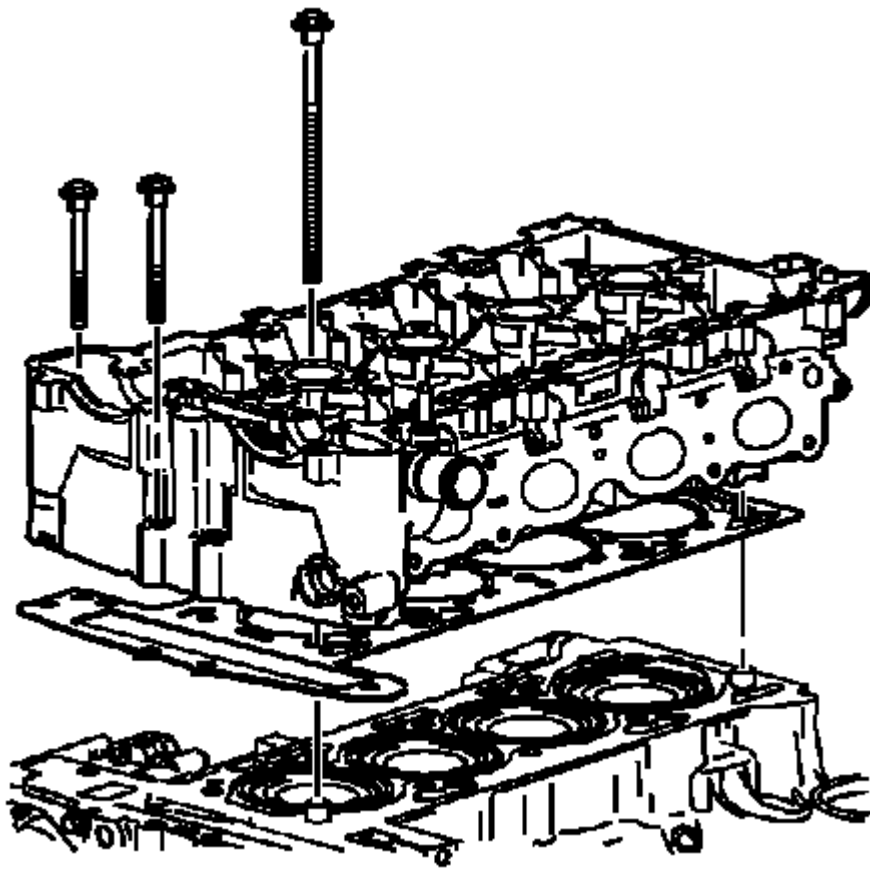


Fig. 299: View Of Cylinder Head And Gasket
Courtesy of GENERAL MOTORS CORP.

3. Remove the cylinder head.
4. Remove the cylinder head gasket.
5. Clean all of the gasket surfaces.
6. Use the following procedures when cleaning the cylinder head and cylinder block surfaces:
 - Use a razor blade gasket scraper to clean the cylinder head and cylinder block gasket surfaces. Do not scratch or gouge any surface.

IMPORTANT: Do not use any other method or technique to clean these gasket surfaces.

- Use a new razor blade for each cylinder head and cylinder block.

IMPORTANT: Be careful not to gouge or scratch the gasket surfaces. Do not gouge or scrape the combustion chamber surfaces. The feel of the gasket surface is important, not the appearance. There will be indentations from the gasket left in the cylinder head after all of the gasket material is removed. These small indentations will be filled in

by the new gasket.

- Hold the razor blade as parallel to the gasket surface as possible.

IMPORTANT: Do not use a tap to clean the cylinder head bolt holes.

7. Clean the old sealer/lube and dirt from the bolt holes.
8. Clean the bolt holes with a nylon bristle brush.

CAUTION: Wear safety glasses to avoid injury when using compressed air or any cleaning solvent. Bodily injury may occur if fumes are inhaled or if skin is exposed to chemicals.

9. When cleaning the cylinder head bolt holes use a suitable commercial spray liquid solvent and compressed air from an extended-tip blow gun to reach the bottom of the holes.
10. Remove any broken long cylinder head bolts using the **J 38188**.

OIL PAN REMOVAL

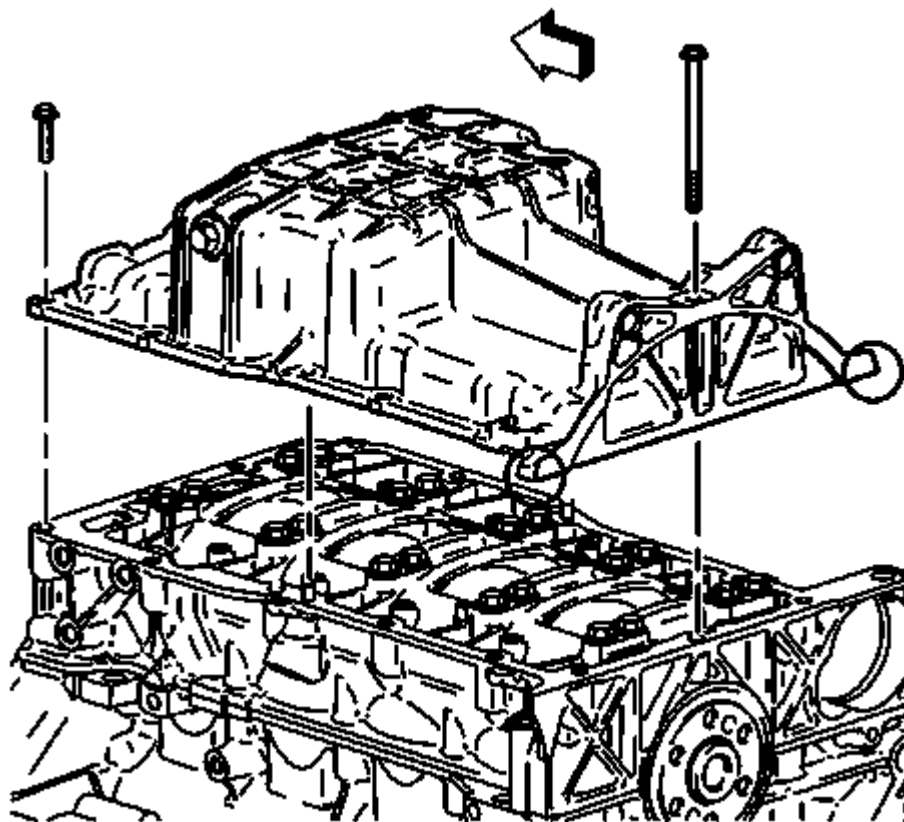


Fig. 300: View Of Oil Pan

Courtesy of GENERAL MOTORS CORP.

1. Remove the oil pan bolts.
2. Remove the oil pan at pry points.

PISTON, CONNECTING ROD, AND BEARING REMOVAL

Tools Required

J-43966-1 Connecting Rod Guides

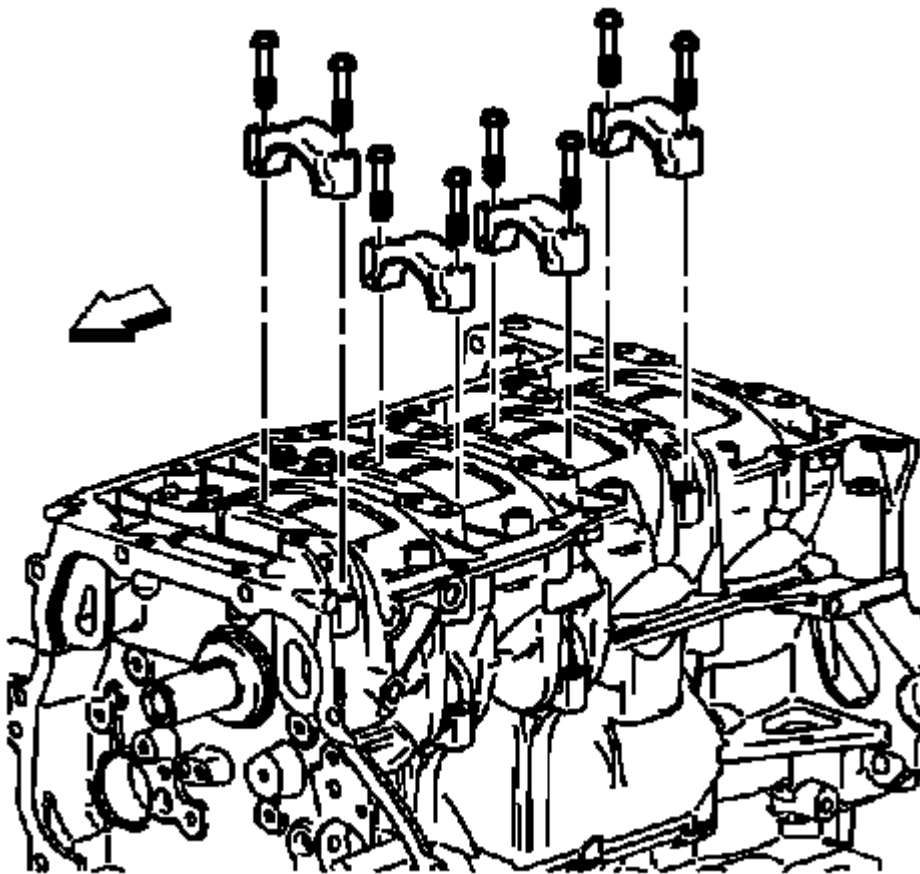


Fig. 301: View Of Connecting Rod Nuts And Caps
Courtesy of GENERAL MOTORS CORP.

1. Rotate the crankshaft to a position where the connecting rod bolts are the most accessible.
2. Mark the connecting rod and cap with the cylinder position. Also mark their orientation. This will ensure the caps and connecting rods are re-assembled properly.
3. Remove any ridge at the top of the cylinder bore to avoid damage to the piston ring lands.
4. Remove the connecting rod bolts.
5. Remove the connecting rod cap.

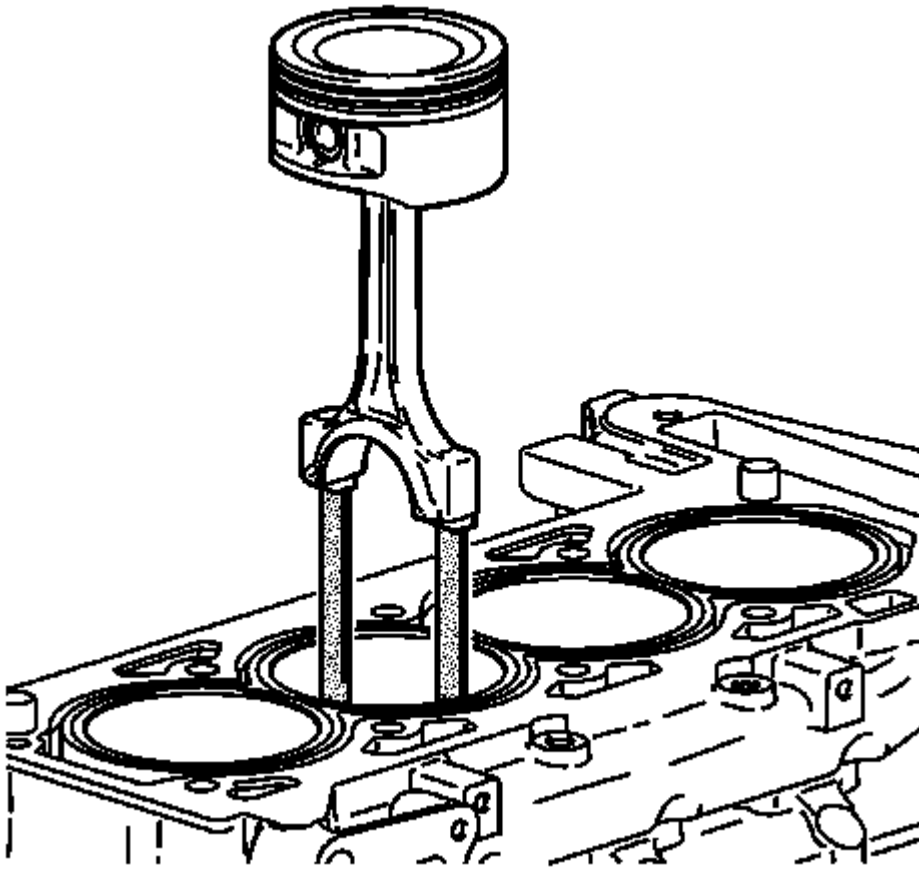


Fig. 302: J-43966-1 Installed On Connecting Rod Bolts
Courtesy of GENERAL MOTORS CORP.

6. Install **J-43966-1** on the connecting rod bolts before removing the piston and connecting rod assembly.
7. Remove the piston and connecting rod assembly.

LOWER CRANKCASE REMOVAL

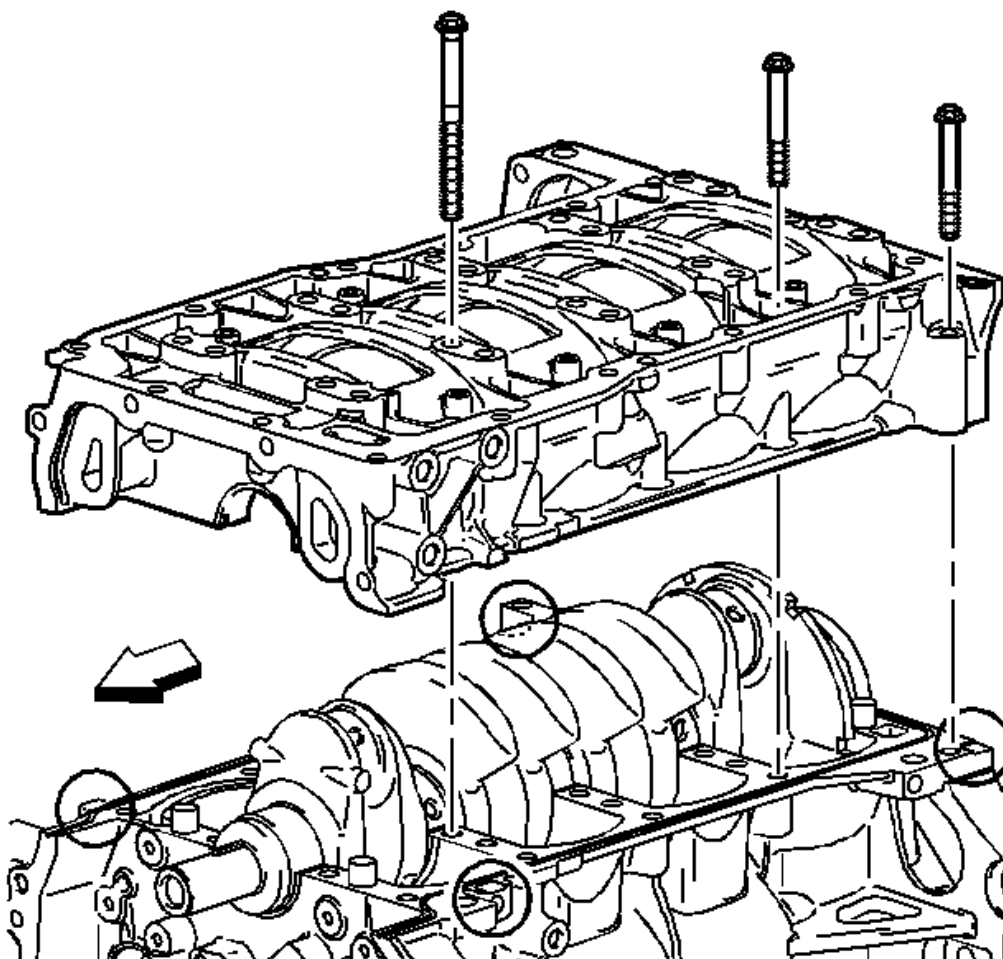


Fig. 303: View Of Upper & Lower Crankcase W/Bolts
 Courtesy of GENERAL MOTORS CORP.

1. Remove the crankshaft position sensor.
2. Inspect the crankshaft position sensor for damage and replace, if necessary.
3. Remove the bedplate perimeter bolts.

IMPORTANT: Do not forget the 2 outside rear bolts.

4. Remove and discard the crankshaft bearing bolts.
5. Using the pry-points and an appropriate prying tool, gently separate the upper and lower crankcase.

CRANKSHAFT AND BEARING REMOVAL

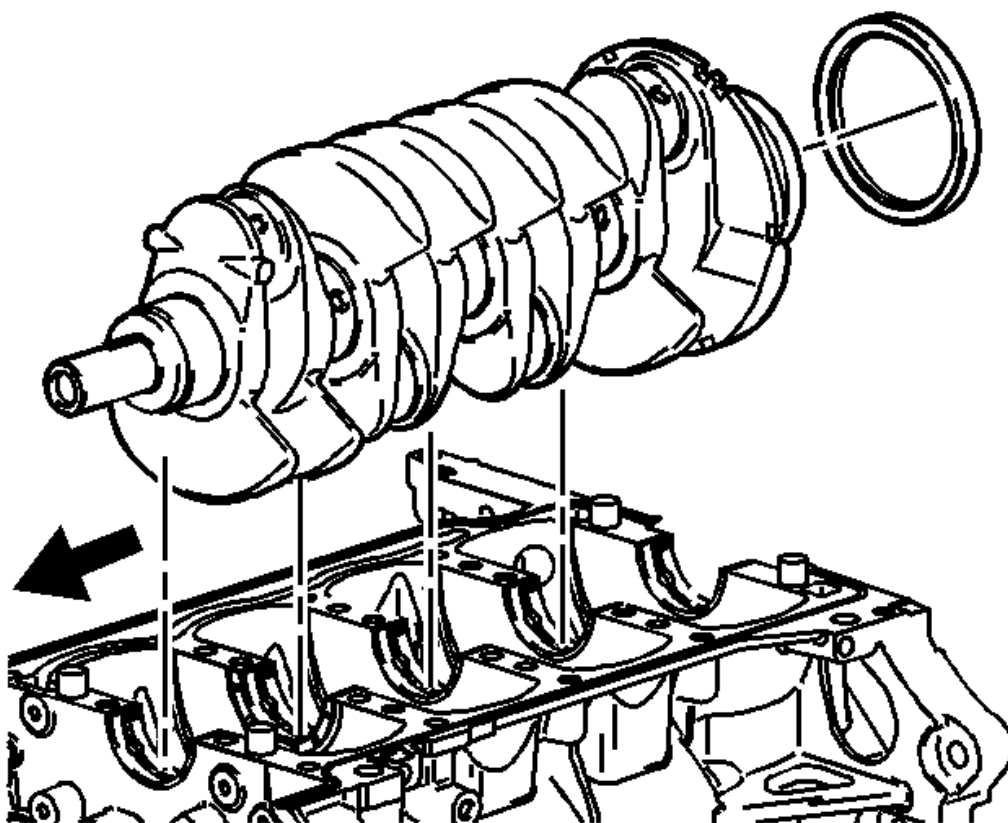


Fig. 304: View Of Crankshaft Rear Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Remove the crankshaft from the block.
2. Remove the crankshaft rear oil seal from the block.

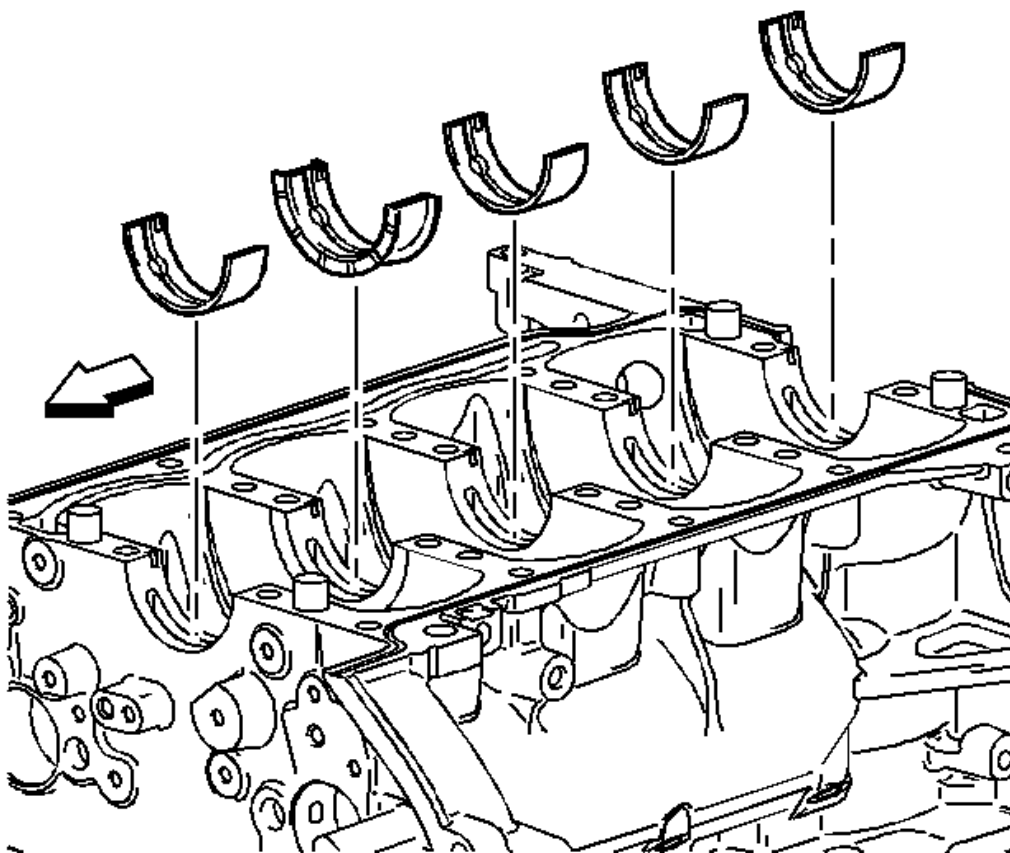


Fig. 305: View Of Crankshaft Bearing Inserts
Courtesy of GENERAL MOTORS CORP.

3. Remove the bearing inserts from the block.

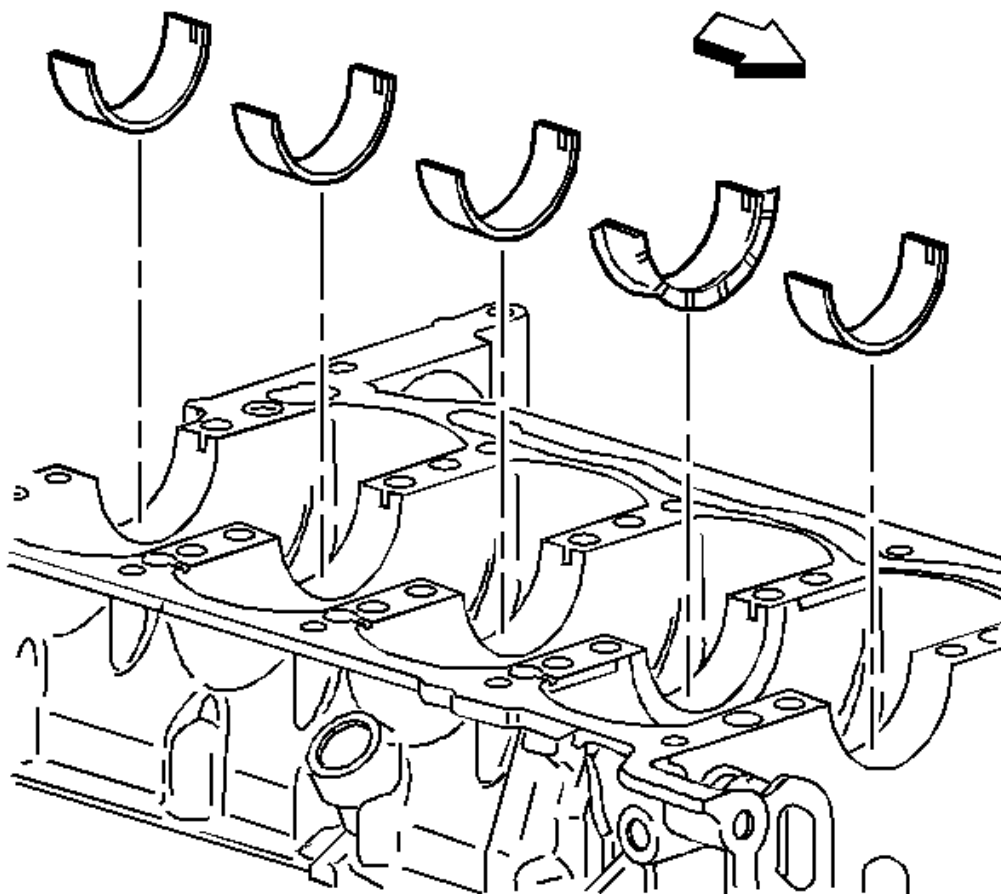


Fig. 306: Identifying Crankshaft Bearing Inserts
Courtesy of GENERAL MOTORS CORP.

4. Remove the bearing inserts from the bed plate.
5. Clean the oil, sludge, and carbon.
6. Inspect the oil passages for obstructions.
7. Inspect the threads.
8. Inspect the bearing journals and the thrust surfaces for the following conditions:
 - Cracks
 - Chips
 - Gouges
 - Roughness
 - Grooves

- Overheating (discoloration)

9. Inspect the corresponding bearing inserts for imbedded foreign material. If foreign material exists find the cause and repair it.

IMPORTANT: Replace the crankshaft if cracks, severe gouges or burned spots are found. Slight roughness may be removed with a fine polishing cloth soaked in clean engine oil. Burrs may be removed with a fine oil stone.

10. Measure the crankshaft journals. Use a micrometer or dial indicator to measure the taper and runout. Note the result for the later selection of bearing inserts. If not within limits the crankshaft must be replaced.

Note the location of the main bearing high spots. If they are not in line, the crankshaft is bent and must be replaced.

ENGINE BLOCK DISASSEMBLE

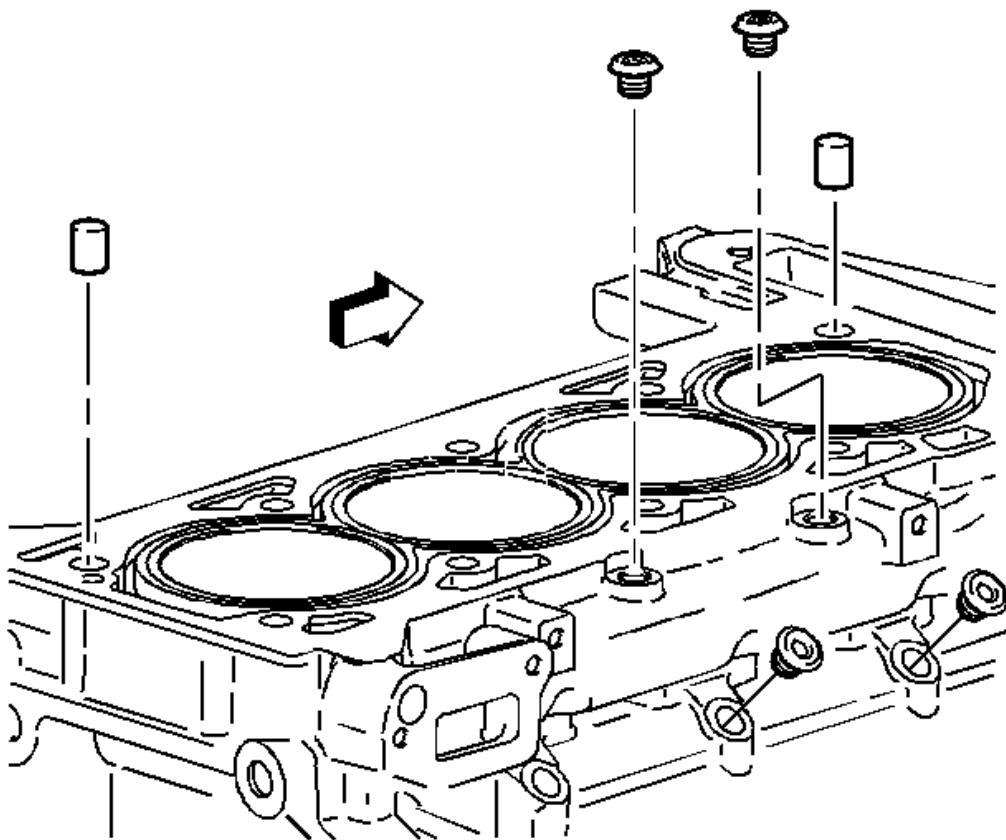


Fig. 307: View Of Oil Passage Plug, Oil Flow Check Valve & Water Jacket Drain Plug
Courtesy of GENERAL MOTORS CORP.

1. Remove the water jacket drain plug.
2. Remove the oil flow check valve.
3. Remove the rear oil passage plug.
4. Remove the six oil passage plugs on the sides of the block.
5. Remove the two water passage plugs on the top of the block.
6. Remove the two front oil passage plugs.

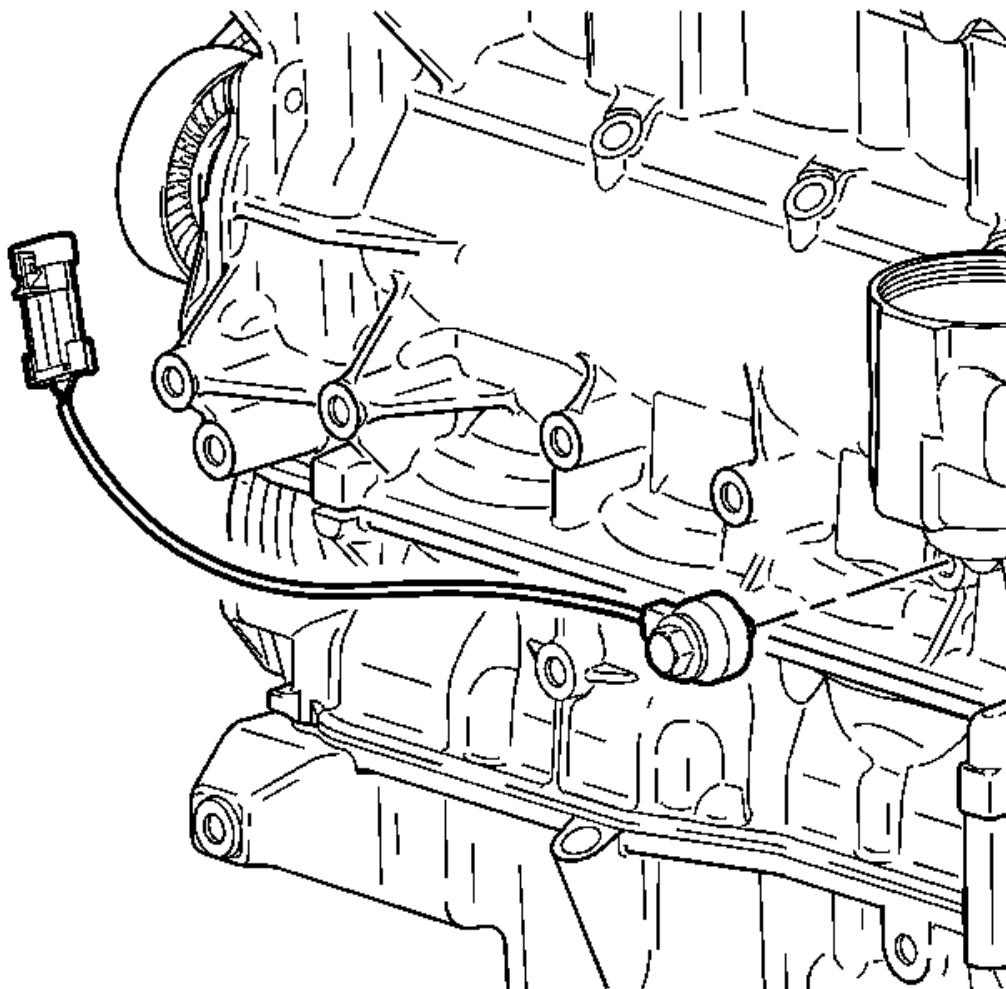


Fig. 308: View of Knock Sensor
Courtesy of GENERAL MOTORS CORP.

7. Remove the knock sensor and bolt.

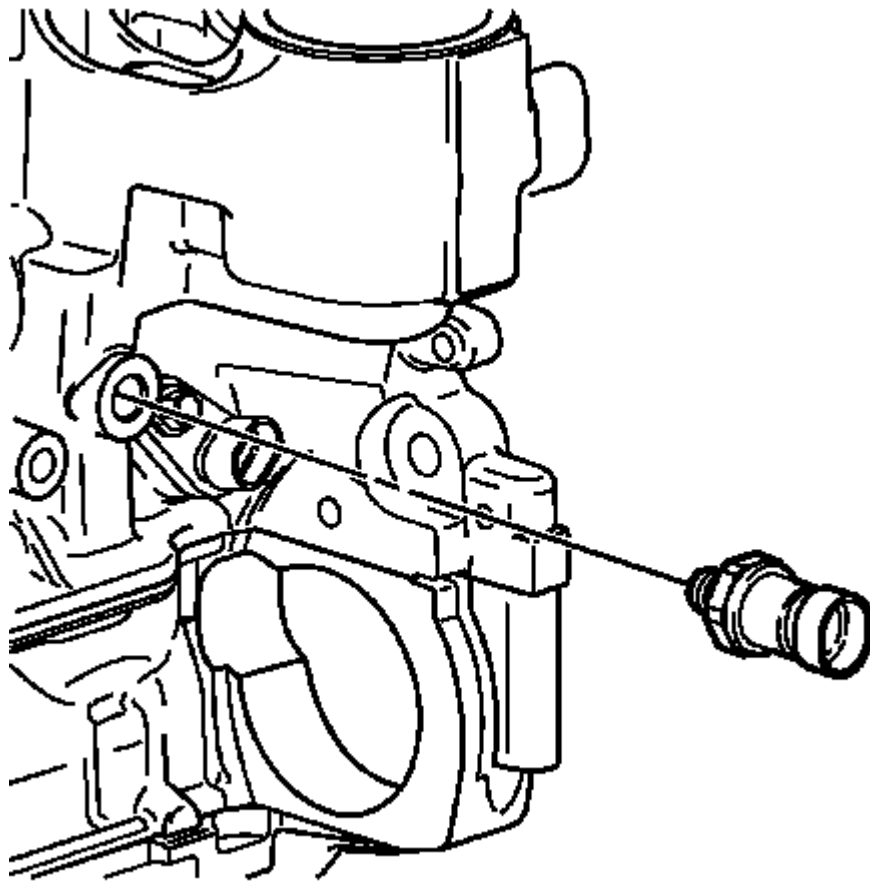


Fig. 309: View Of Engine Oil Pressure Sensor
Courtesy of GENERAL MOTORS CORP.

8. Remove the oil pressure switch.

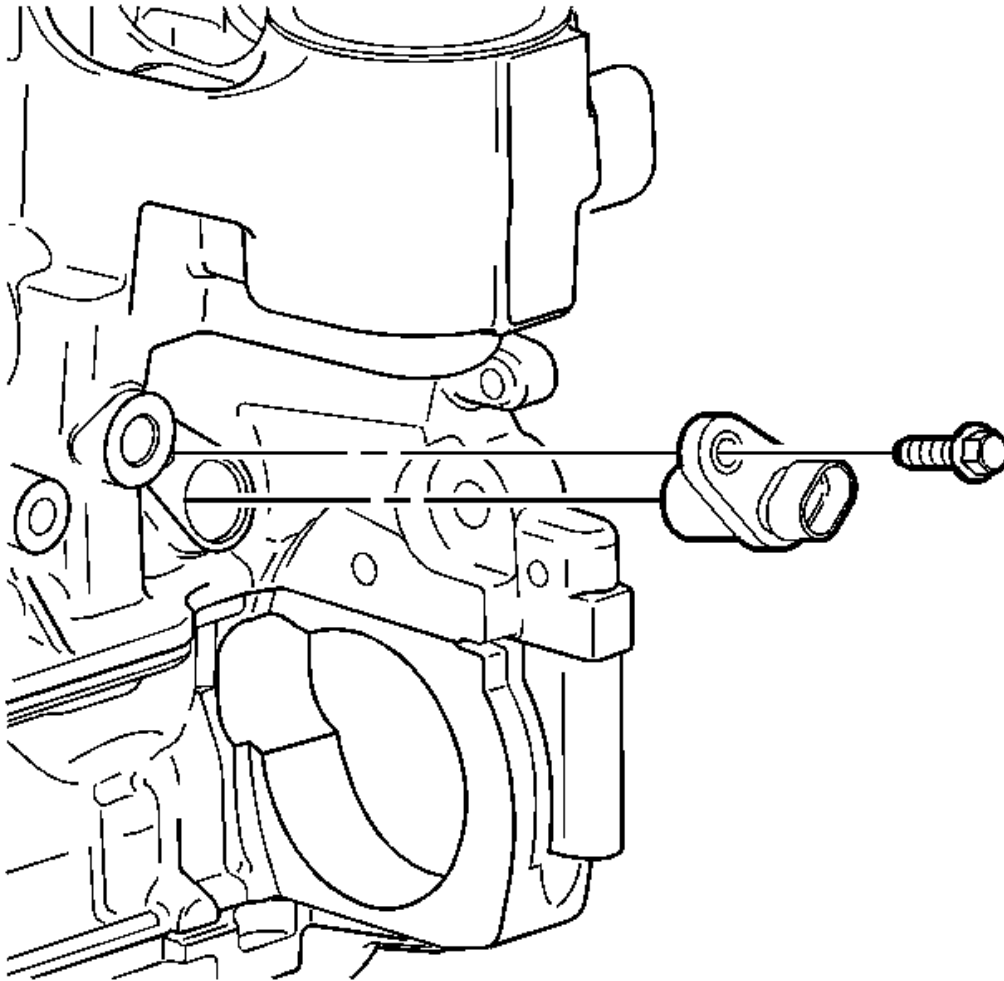


Fig. 310: View Of Crankshaft Position Sensor
Courtesy of GENERAL MOTORS CORP.

9. Remove the crankshaft position sensor and bolt.

ENGINE BLOCK CLEANING AND INSPECTION

Tools Required

- **J 7872** Magnetic Base Dial Indicator
- **J 8087** Cylinder Bore Gage

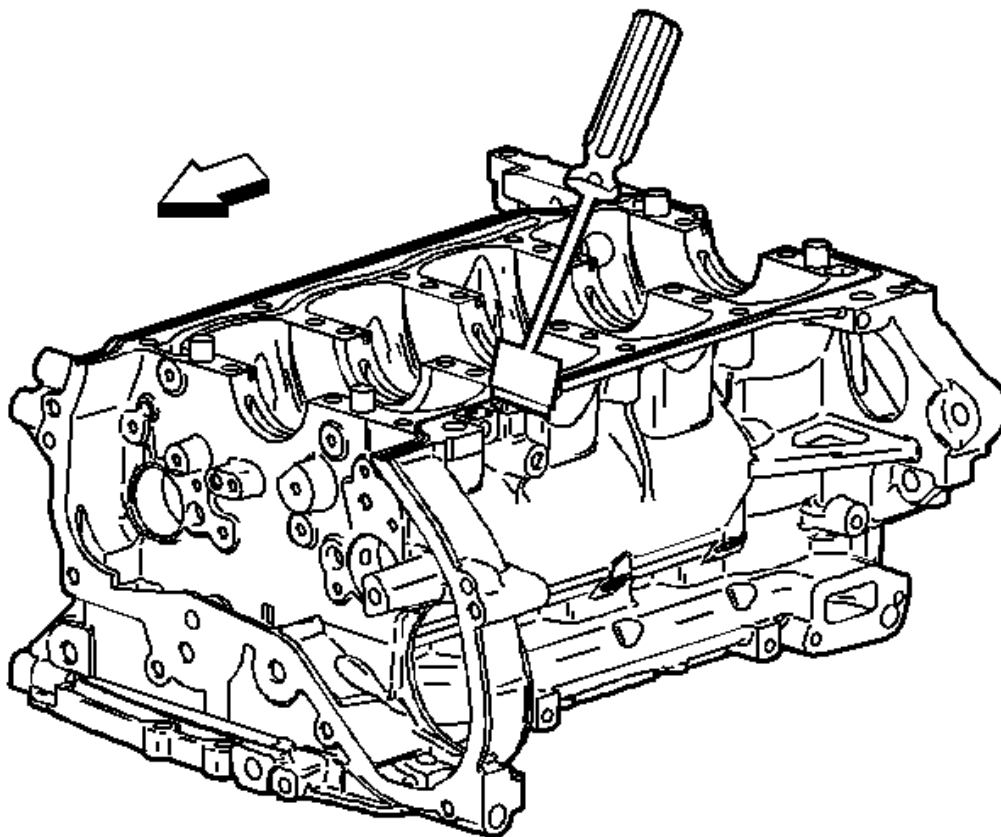


Fig. 311: Cleaning Gasket Mating Surfaces
Courtesy of GENERAL MOTORS CORP.

1. Clean the sealing material from the gasket mating surfaces.
2. Clean the engine block and lower crankcase in a cleaning tank with solvent appropriate for aluminum.
3. Flush the engine block with clean water or steam.
4. Clean the oil passages.
5. Clean the blind holes.
6. Spray the cylinder bores and the machined surfaces with engine oil.
7. Inspect the threaded holes. Clean the threaded holes with a rifle brush. If necessary, drill out the holes and install thread inserts. Refer to **Thread Repair**.

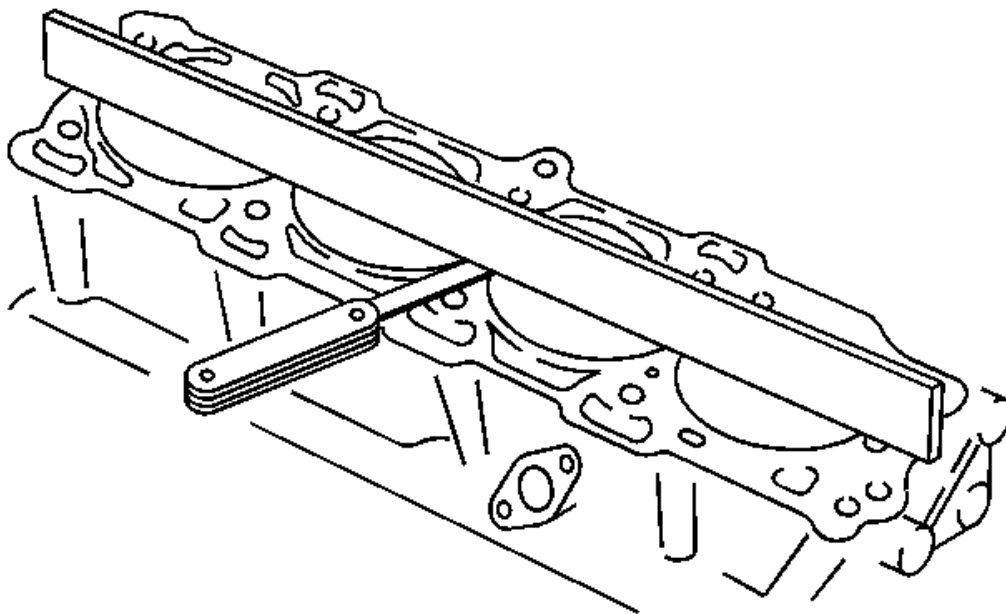


Fig. 312: Checking Deck Surface For Flatness
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not attempt to machine the lower crankcase to engine block surfaces.

8. Use a straight edge and a feeler gage to check the deck surface for flatness. Carefully machine minor irregularities. Replace the block if more than 0.254 mm (0.010 in) must be removed.
9. Inspect the oil pan rail for nicks. Inspect the front cover attaching area for nicks. Use a flat mill file to remove any nicks.

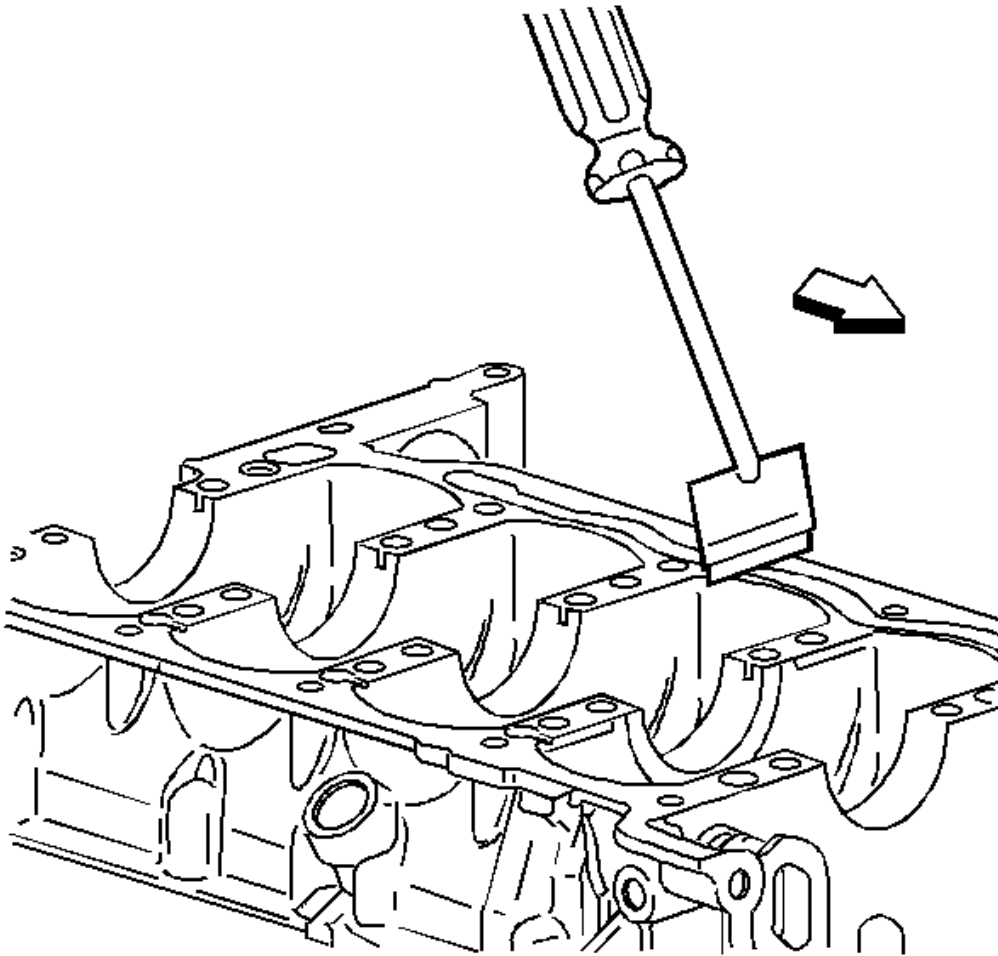


Fig. 313: Cleaning Sealing Material From Gasket Mating Surfaces - Engine Block Side
Courtesy of GENERAL MOTORS CORP.

10. Clean the sealing material from the gasket mating surfaces on the lower crankcase engine block side.

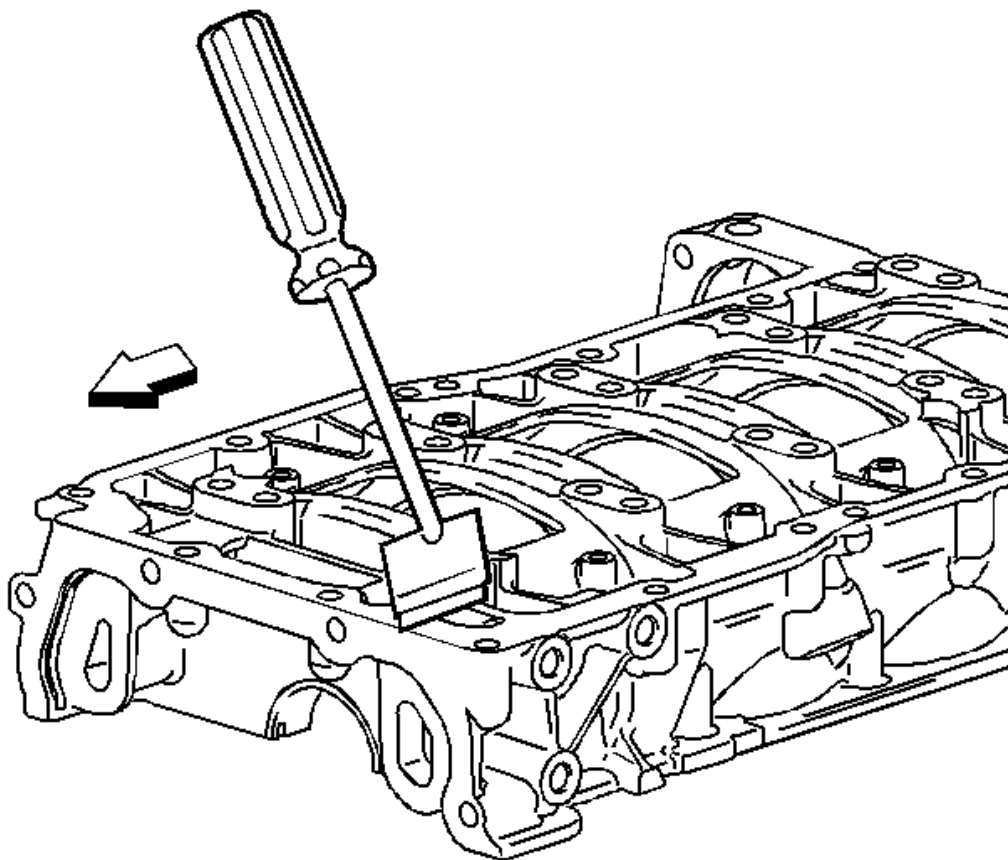


Fig. 314: Cleaning Sealing Material From Gasket Mating Surfaces - Oil Pan Side
Courtesy of GENERAL MOTORS CORP.

11. Clean the sealing material from the gasket mating surfaces on the lower crankcase oil pan side.

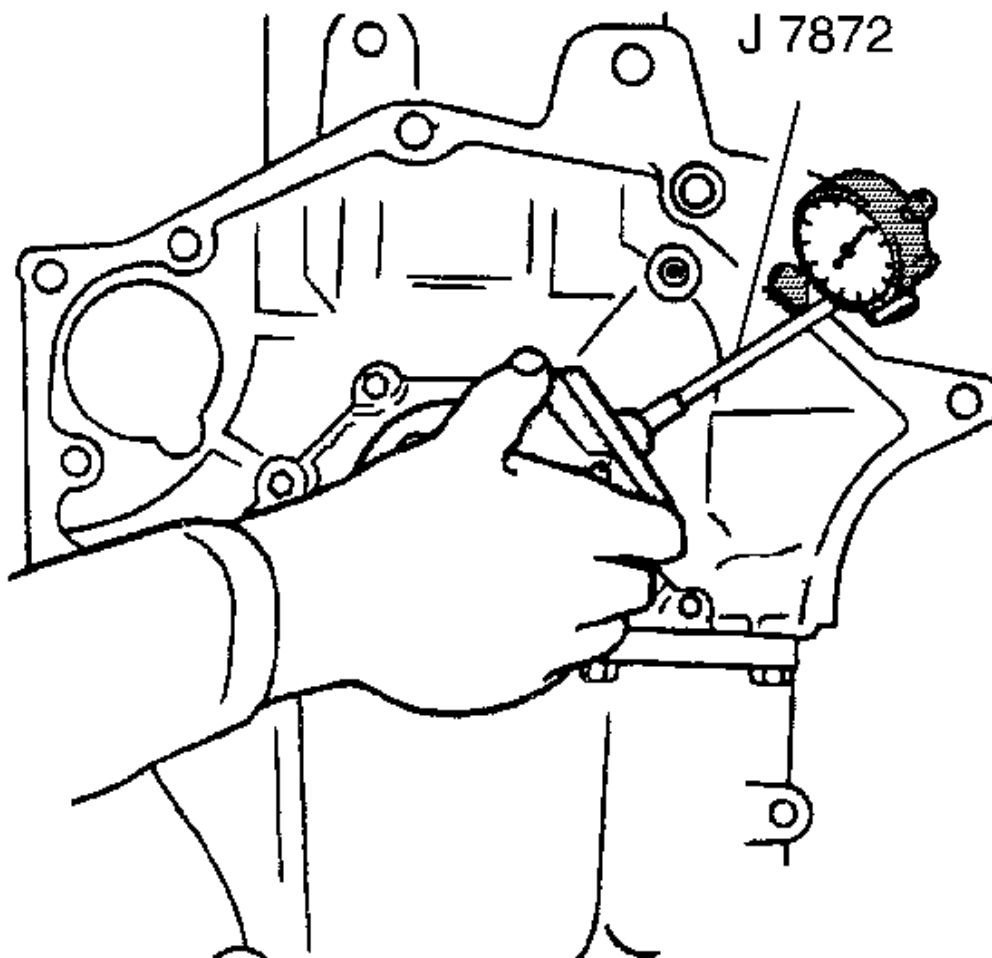


Fig. 315: Measuring Engine Block Flange Runout
Courtesy of GENERAL MOTORS CORP.

12. Inspect the mating surfaces of the transmission face.

NOTE: A broken flywheel may result if the transmission case mating surface is not flat.

13. Use the following procedure in order to measure the engine block flange runout at the mounting bolt hole bosses:
 1. Temporarily install the crankshaft and upper bearings. Measure the crankshaft flange runout using the **J 7872**.
 2. Hold the gage plate flat against the crankshaft flange.

3. Place the dial indicator stem on the transmission mounting bolt hole boss. Set the indicator to 0.
4. Record the readings obtained from all of the bolt hole bosses. The measurements should not vary more than 0.203 mm (0.008 in).
5. Recheck the crankshaft flange runout if the readings vary more than 0.203 mm (0.008 in).
6. Remove the crankshaft and bearings.

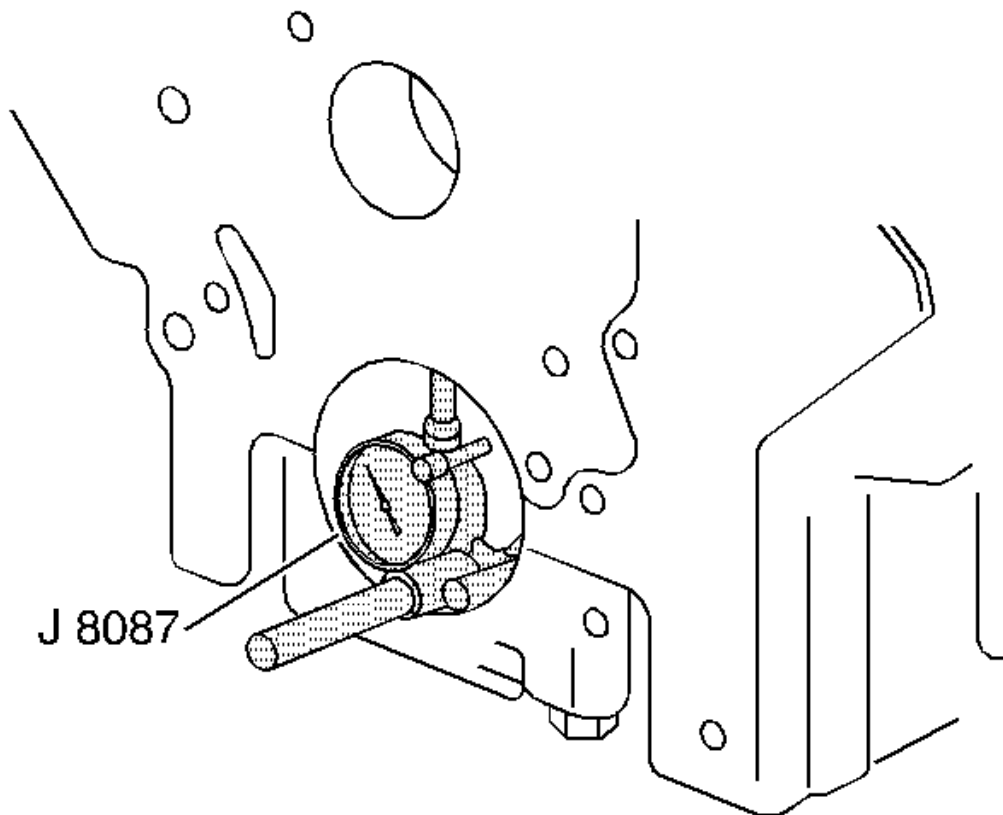


Fig. 316: Inspecting Crankshaft Main Bearing Bores
Courtesy of GENERAL MOTORS CORP.

14. Install the bed plate and bolts. Tighten the bed plate bolts to specification.
15. Inspect the crankshaft main bearing bores. Use the **J 8087** to measure the bearing bore concentricity and alignment. Refer to **Engine Mechanical Specifications**.
16. Replace the engine block and bed plate if the crankshaft bearing bores are out of specification.
17. Remove the bed plate.

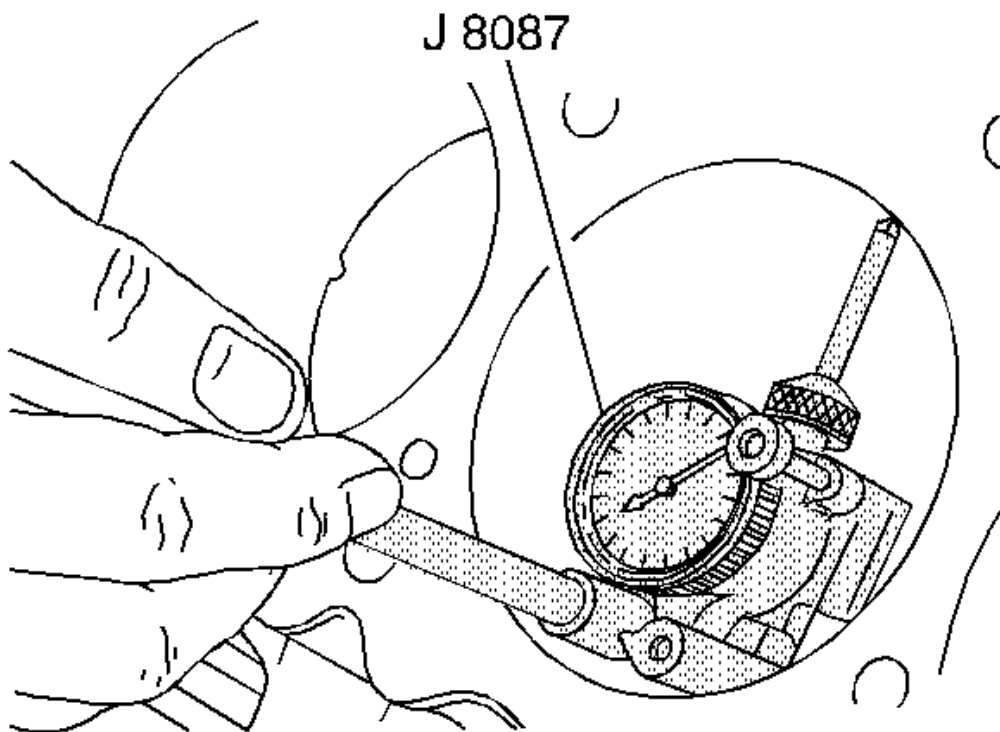


Fig. 317: Inspecting Cylinder Bores Using J 8087
Courtesy of GENERAL MOTORS CORP.

18. Inspect the cylinder bores using the **J 8087** . Inspect for the following items:
 - Wear
 - Taper
 - Runout
 - Ridging
19. If the cylinder bores are out of specification, install a NEW cylinder bore sleeve. Refer to **Cylinder Sleeve Removal** and **Cylinder Sleeve Installation** .

CYLINDER HONING

Tools Required

J 8087 Cylinder Bore Gage

Honing Procedure

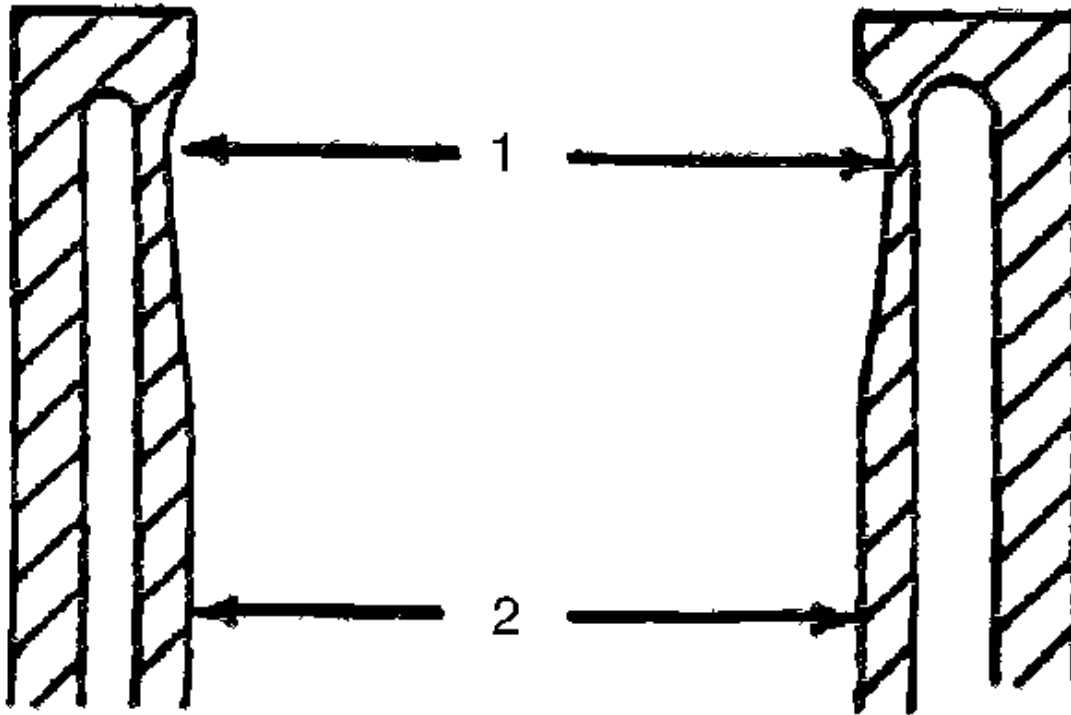


Fig. 318: Measuring Head Gasket Dimensions
Courtesy of GENERAL MOTORS CORP.

1. Measure the cylinder bore for out-of-round and taper.
2. Measure dimension (1) at 13 mm (1/2 in) below the head gasket surface. Measure dimension (2) at 100 mm (4 in) below the head gasket surface.

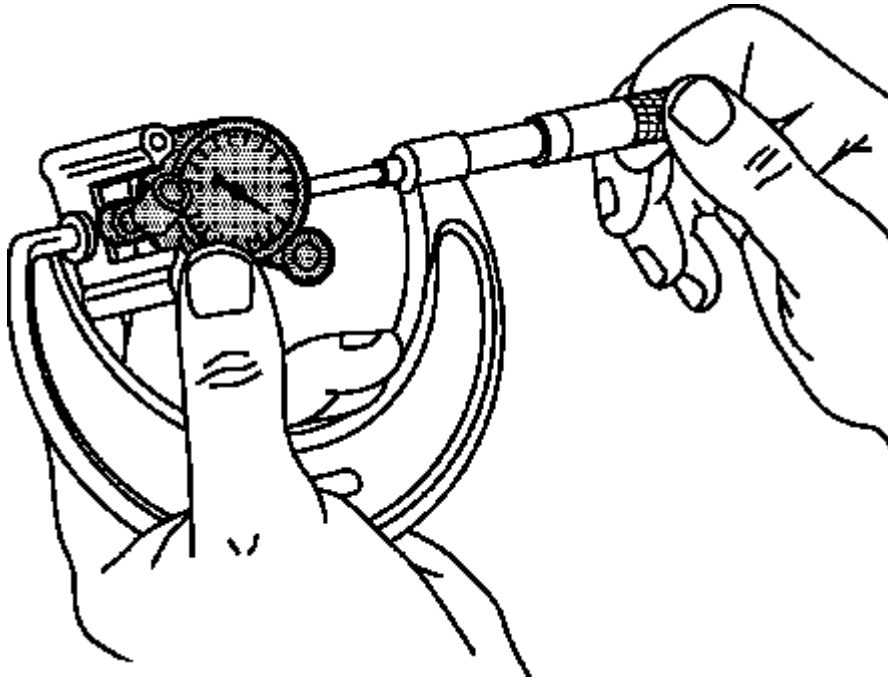


Fig. 319: Measuring Bore Gauge With Micrometer
Courtesy of GENERAL MOTORS CORP.

3. Measure the cylinder bores by setting the **J 8087** dial at zero in the cylinder at the point of the desired measurement. Lock the dial indicator at zero before removing the dial from the cylinder. Measure across the gage contact points with an outside micrometer, with the gage at the same zero setting as when the gage was removed from the cylinder.
4. Fine vertical scratches made by the ring ends do not, by themselves, cause excessive oil consumption. Do not hone the cylinder in order to remove these scratches.
5. If the bore is glazed but otherwise serviceable, lightly break the glaze with a hone. Replace the piston rings. Refer to **Piston, Connecting Rod, and Bearing Installation** .
 1. The honing stones must be clean, sharp, and straight.
 2. Move the hone slowly up and down to produce a 45 degree cross-hatch pattern.
 3. Clean the bore thoroughly with soap and water.
 4. Dry the bore.
 5. Rub clean engine oil in the bore.
 6. Re-measure the bore.
6. If the cylinder bore is out of specification, install a new cylinder bore sleeve. Refer to **Cylinder Sleeve Removal** and **Cylinder Sleeve Installation** .
7. If honing is not required, clean the cylinder bores with hot water and detergent. Apply clean engine oil to the bore after washing and drying the bore.

CYLINDER SLEEVE REMOVAL

Tools Required

EN 45680-850 Cylinder Sleeve Removal and Installation Kit**Removal Procedure**

NOTE: Do not chill or heat the cylinder bore sleeve or the cylinder block when removing or installing a new cylinder bore sleeve. Chilling or heating the cylinder bore sleeve or the cylinder block will cause engine damage and will not aid the removal or installation of the new cylinder bore sleeve.

NOTE: Do not damage the crankshaft connecting rod journals or reluctor ring or engine damage will occur.

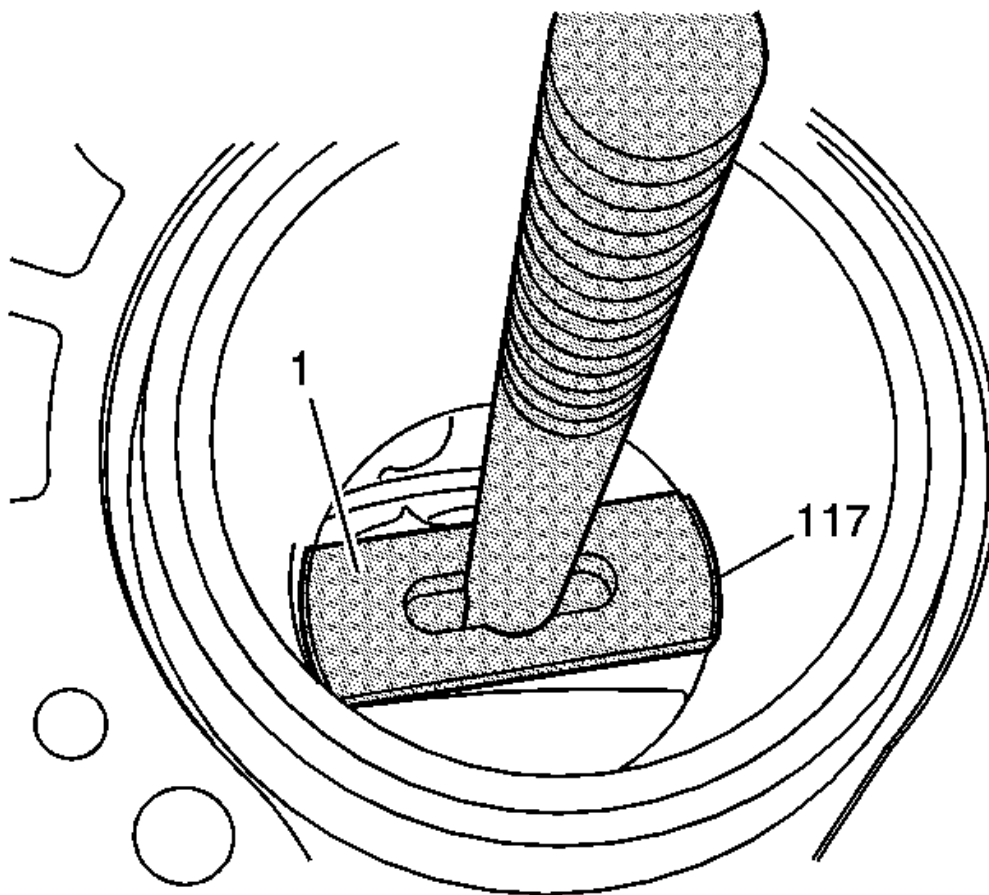


Fig. 320: View Of Cylinder Bore Liner Puller
Courtesy of GENERAL MOTORS CORP.

1. If the crankshaft is still installed, rotate the crankshaft so that the counterweight is to the right side and the connecting rod journal is to the left side and not in alignment with the cylinder bore.
2. Install the cylinder bore sleeve puller EN-45680-852 (1) from **EN 45680-850** through the cylinder bore.

NOTE: Ensure that the shoe is flat against the bottom of the cylinder bore sleeve or damage to the cylinder bore sleeve puller will occur.

3. Align the shoe (1) of the cylinder bore sleeve puller EN-45680-852 to the bottom of the cylinder bore sleeve (117).

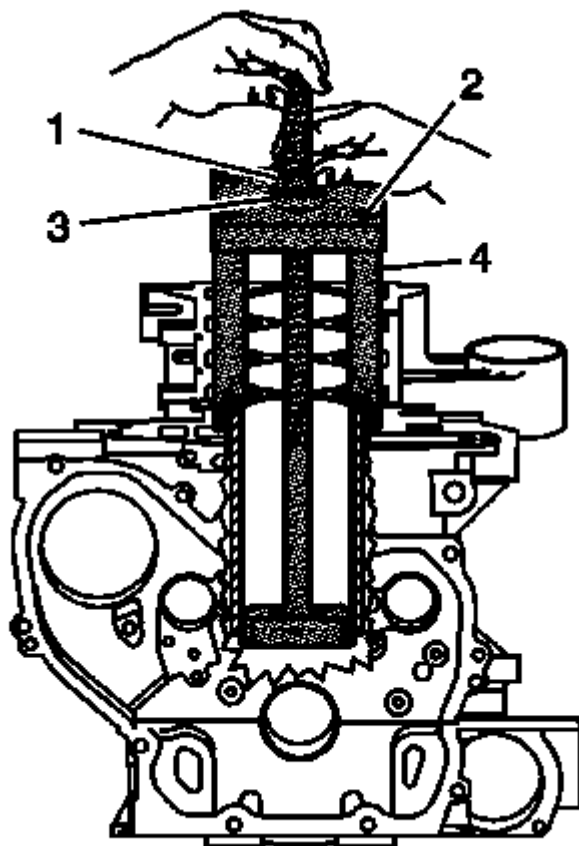


Fig. 321: Aligning Cylinder Bore Sleeve Puller
Courtesy of GENERAL MOTORS CORP.

4. Hold the threaded shaft of the cylinder bore sleeve puller EN-45680-852 upward in order to retain the shoe alignment to the bottom of the cylinder bore sleeve.
5. Install the fixture EN-45680-851 (4) from **EN 45680-850** onto the threaded shaft of the cylinder bore sleeve puller EN-45680-852 and the engine block.
6. Install the bearing (3) and the nut (1).
7. Tighten the nut (1) to the bearing (3).

NOTE: Refer to Fastener Notice .

IMPORTANT: Use four old cylinder head bolts for the attaching bolts.

8. Install and tighten the 4 attaching bolts (2) into the cylinder head bolt holes of the block.

Tighten: Tighten the bolts to 15 N.m (11 lb ft).

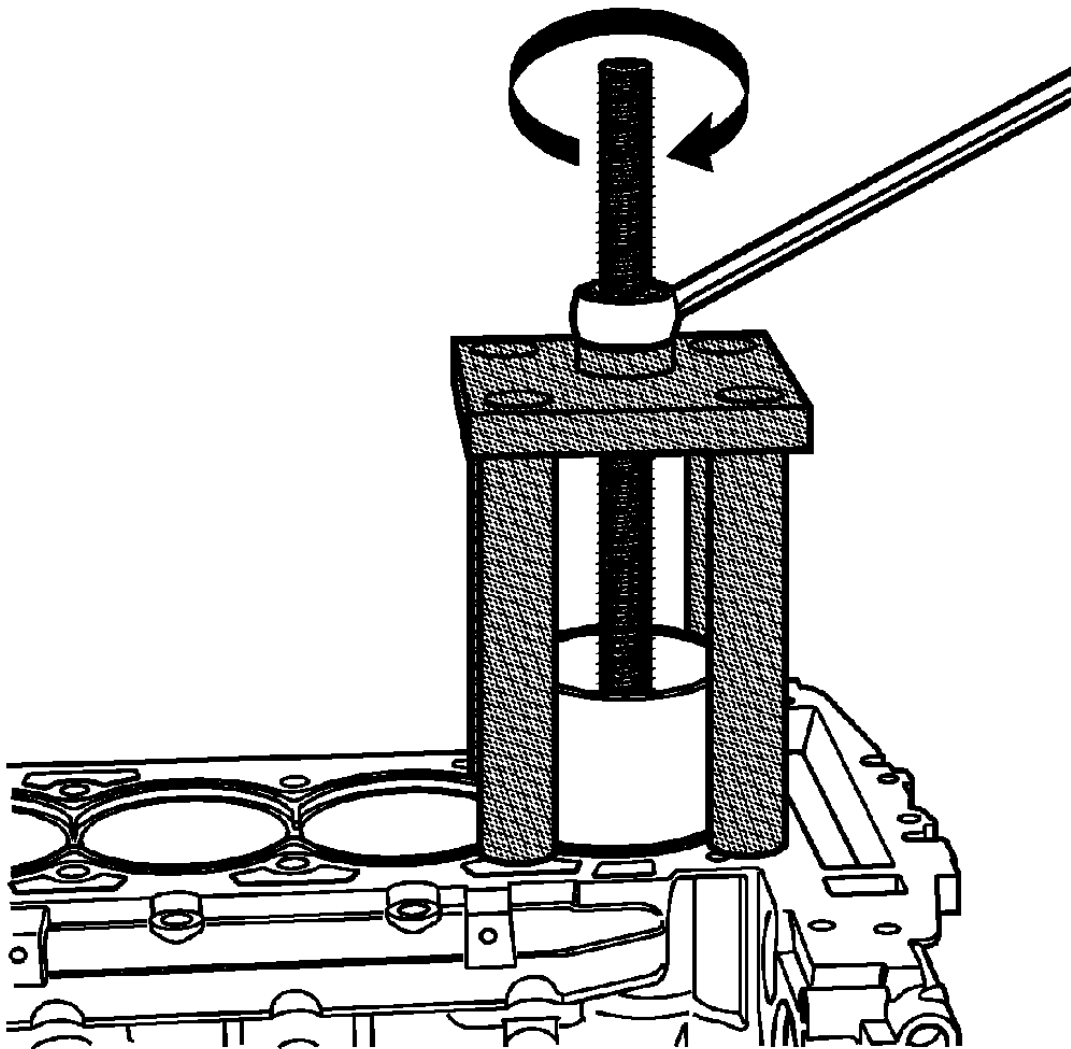


Fig. 322: Removing Cylinder Bore Sleeve By Rotating Nut
Courtesy of GENERAL MOTORS CORP.

9. Rotate the nut clockwise in order to remove the cylinder bore sleeve.

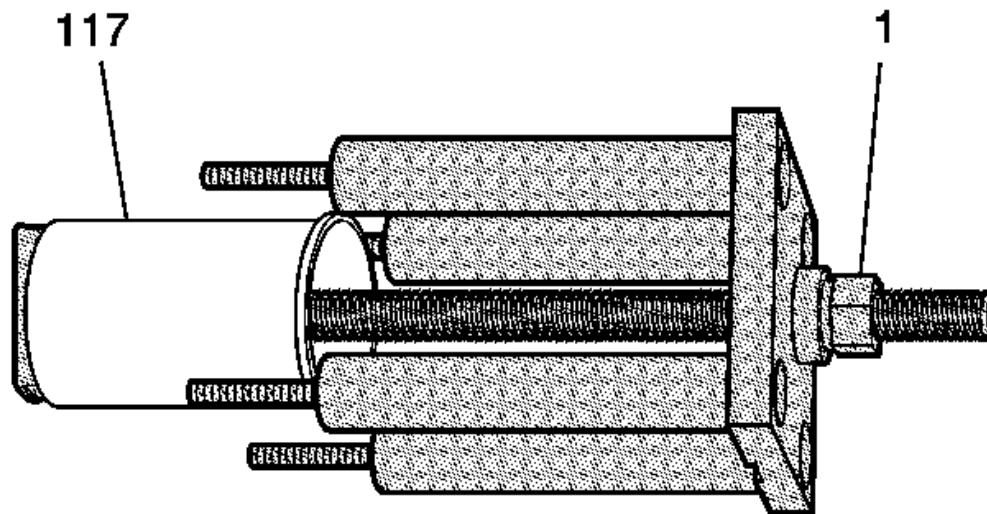


Fig. 323: Removing Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

NOTE: Do not damage the cylinder block surface. Damage to the cylinder block surface can cause engine failure.

10. Remove the fixture EN-45680-851, cylinder bore sleeve puller EN-45680-852, and the cylinder bore sleeve (117) from the engine block.
11. Loosen the nut (1) to remove the cylinder bore sleeve (117).
12. Inspect the cylinder bore in the cylinder block for cracks or damage. If cracked or damaged, replace the cylinder block.
13. Inspect the piston, piston rings, and connecting rod for damage. Refer to **Piston, Connecting Rod, and Bearing Cleaning and Inspection.**

CYLINDER SLEEVE INSTALLATION

Special Tools

EN 45680-850 Cylinder Sleeve Removal and Installation Kit**Installation Procedure**

NOTE: Do not use assembly aids or lubricants on the cylinder bore sleeve or the cylinder bore block when installing a new cylinder bore sleeve, or engine damage will occur. These items will not aid in the installation of the new cylinder bore sleeve.

NOTE: Do not chill or heat the cylinder bore sleeve or the cylinder block when removing or installing a new cylinder bore sleeve. Chilling or heating the cylinder bore sleeve or the cylinder block will cause engine damage and will not aid the removal or installation of the new cylinder bore sleeve.

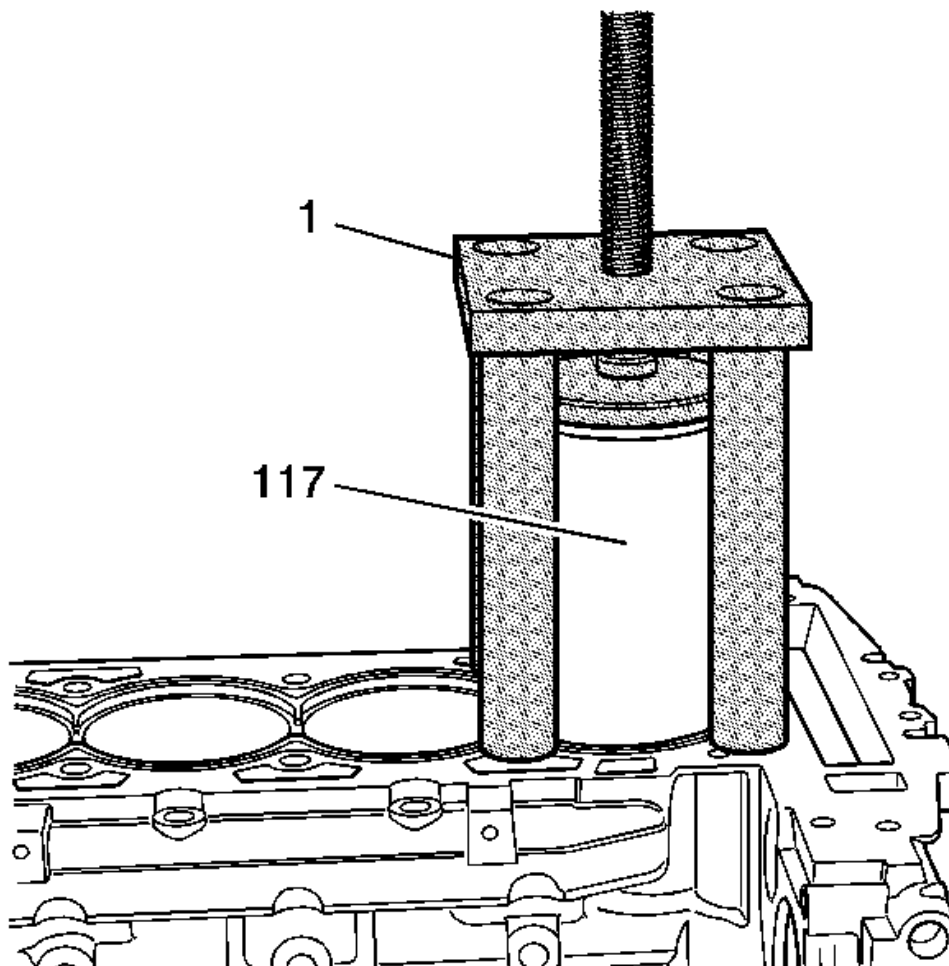


Fig. 324: View Of Cylinder Bore Sleeve Fixture
Courtesy of GENERAL MOTORS CORP.

1. Place the NEW cylinder bore sleeve (117) onto the cylinder block.

2. Install the fixture EN-45680-851 and the cylinder bore sleeve installer EN-45680-853 (1) from **EN 45680-850** over the cylinder bore sleeve (117) and onto the cylinder block. Do not apply downward pressure to the cylinder bore sleeve (117).

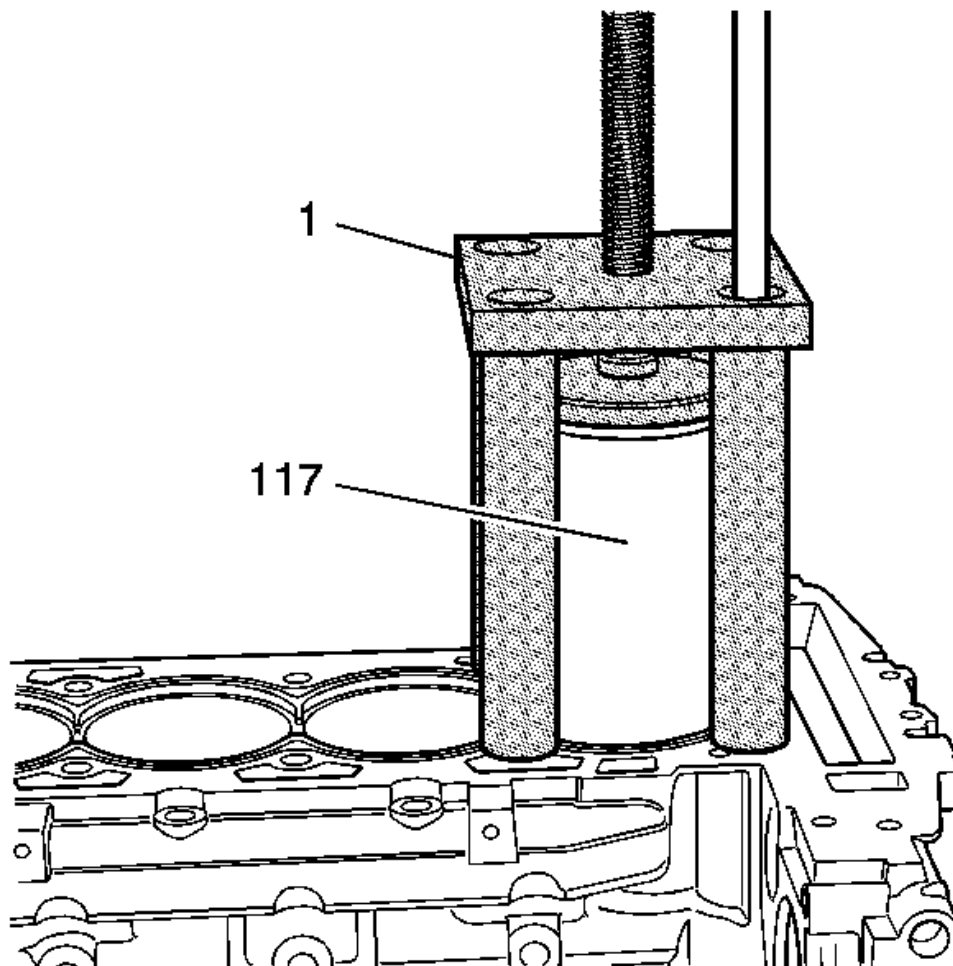


Fig. 325: Installing Cylinder Bore Sleeve Puller Attachment Bolts
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Use 4 old cylinder head bolts for the attaching bolts.

3. Insert the 4 attachment bolts into the legs of the fixture EN-45680-851 (1).

NOTE: Refer to **Fastener Notice** .

4. Tighten the 4 attachment bolts. Do not apply downward pressure to the cylinder bore sleeve (117).

Tighten: Tighten the 4 attachment bolts to 15 N.m (11 lb ft).

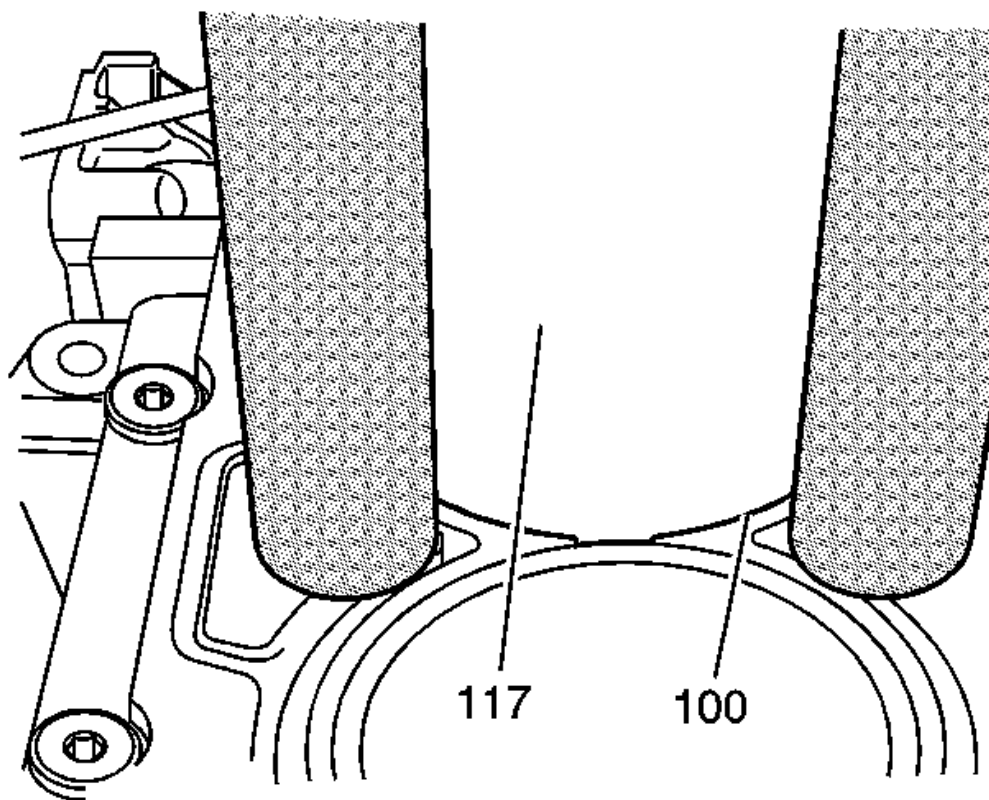


Fig. 326: View Of Proper Liner Alignment
Courtesy of GENERAL MOTORS CORP.

5. Align the bottom of the cylinder bore sleeve (117) with the cylinder bore of the block (100).

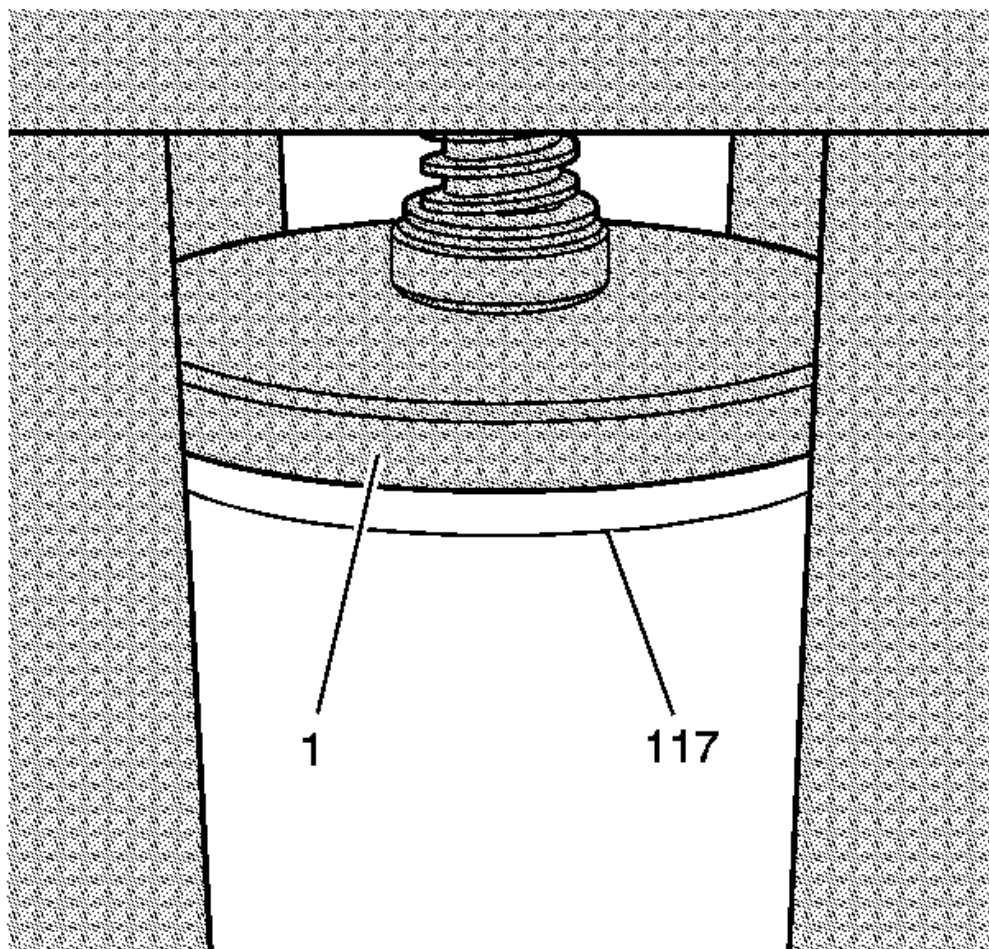


Fig. 327: View Of Installation Arbor
Courtesy of GENERAL MOTORS CORP.

6. Align the installation arbor (1) of the cylinder bore sleeve installer EN-45680-853 onto the top of the cylinder bore sleeve (117).

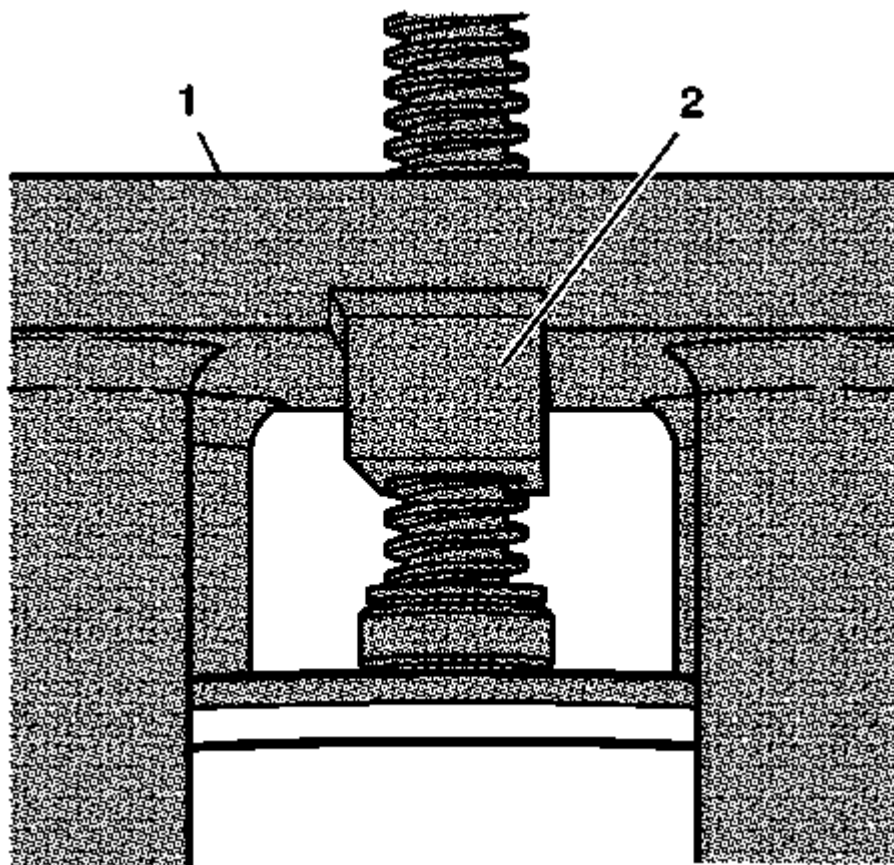


Fig. 328: View Of Pusher Block
Courtesy of GENERAL MOTORS CORP.

7. Align the pusher block (2) of the cylinder bore sleeve installer EN 45680-853 into the groove of fixture EN 45680-851 (1).

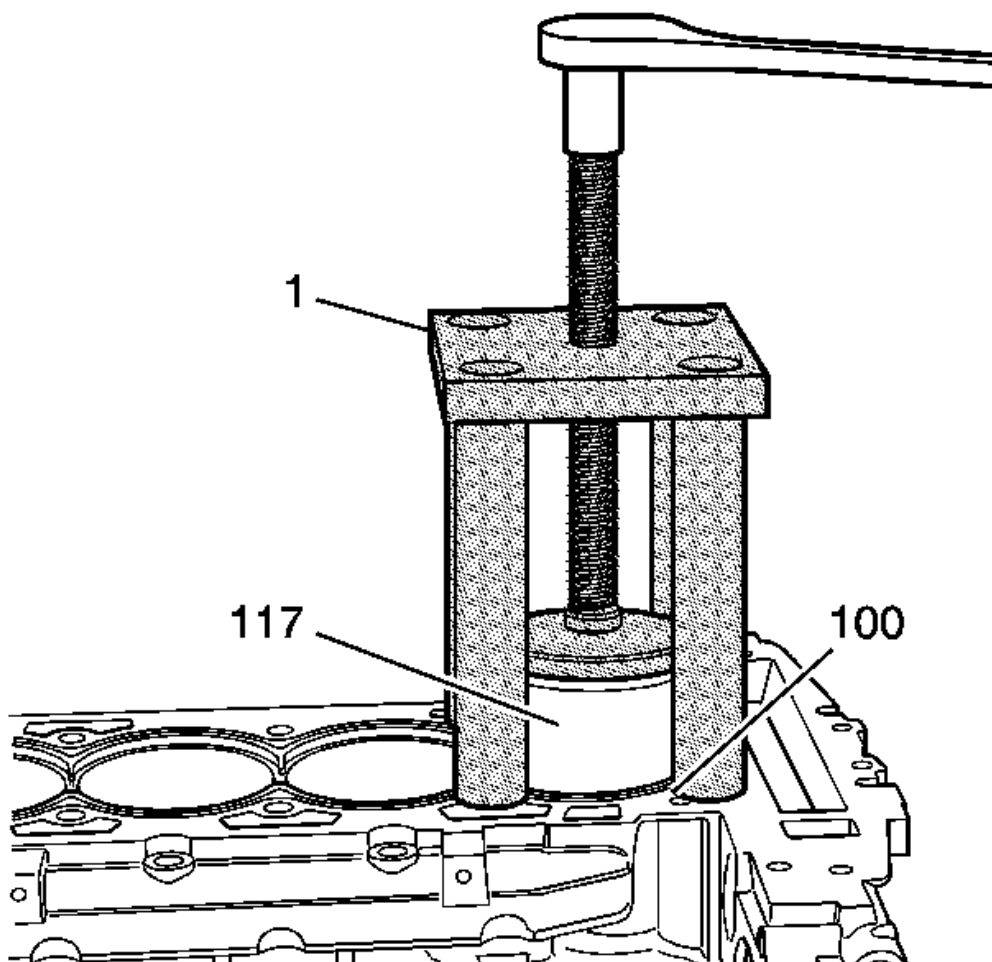


Fig. 329: Installing Cylinder Bore Sleeve Into Engine Block Using Tool
Courtesy of GENERAL MOTORS CORP.

NOTE: Do not use any air powered or electric tools to rotate the threaded shaft of the cylinder bore sleeve installer in the fixture assembly or damage to the cylinder bore sleeve will occur.

8. Using a ratchet, rotate the threaded shaft of the cylinder bore sleeve installer EN 45680-853 (1) in order to install the cylinder bore sleeve (117) into the engine block (100).
9. Do not completely seat the cylinder bore sleeve in the block. Leave approximately 1/16 inch of the cylinder bore sleeve above the surface of the cylinder block.

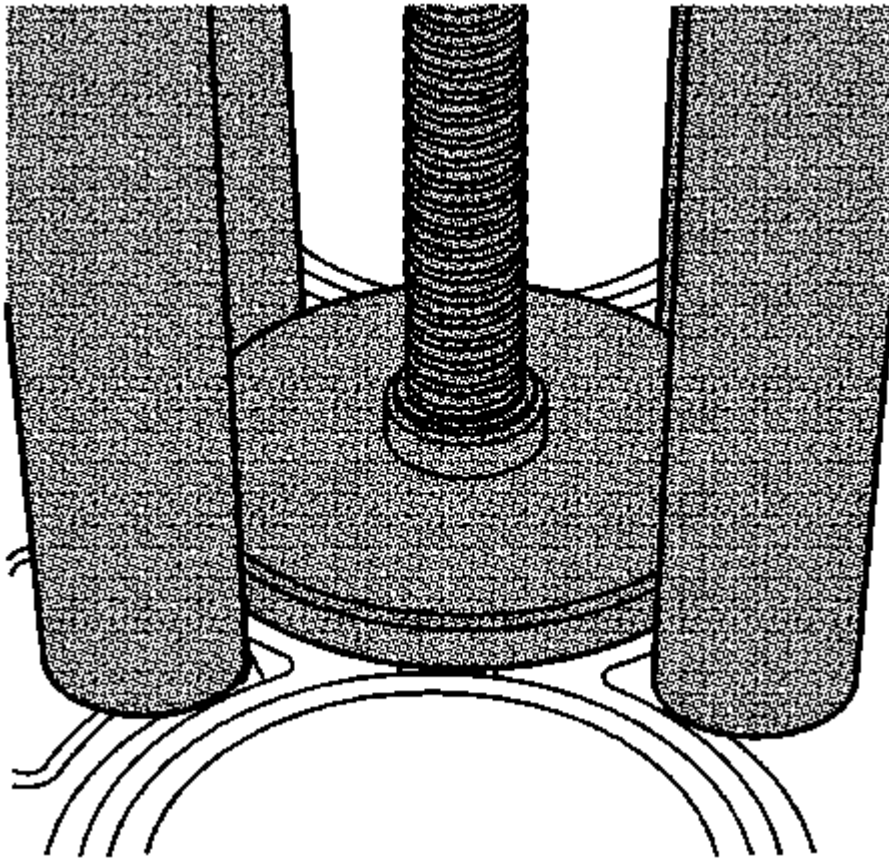


Fig. 330: Seating Cylinder Bore Sleeve Completely Using Tool
Courtesy of GENERAL MOTORS CORP.

10. Using a torque wrench, torque the threaded shaft to 102 N.m (75 lb ft) to completely seat the cylinder bore sleeve in the cylinder block. With the cylinder bore sleeve properly installed, a minimal portion of the cylinder bore sleeve flange will protrude above the block deck surface.

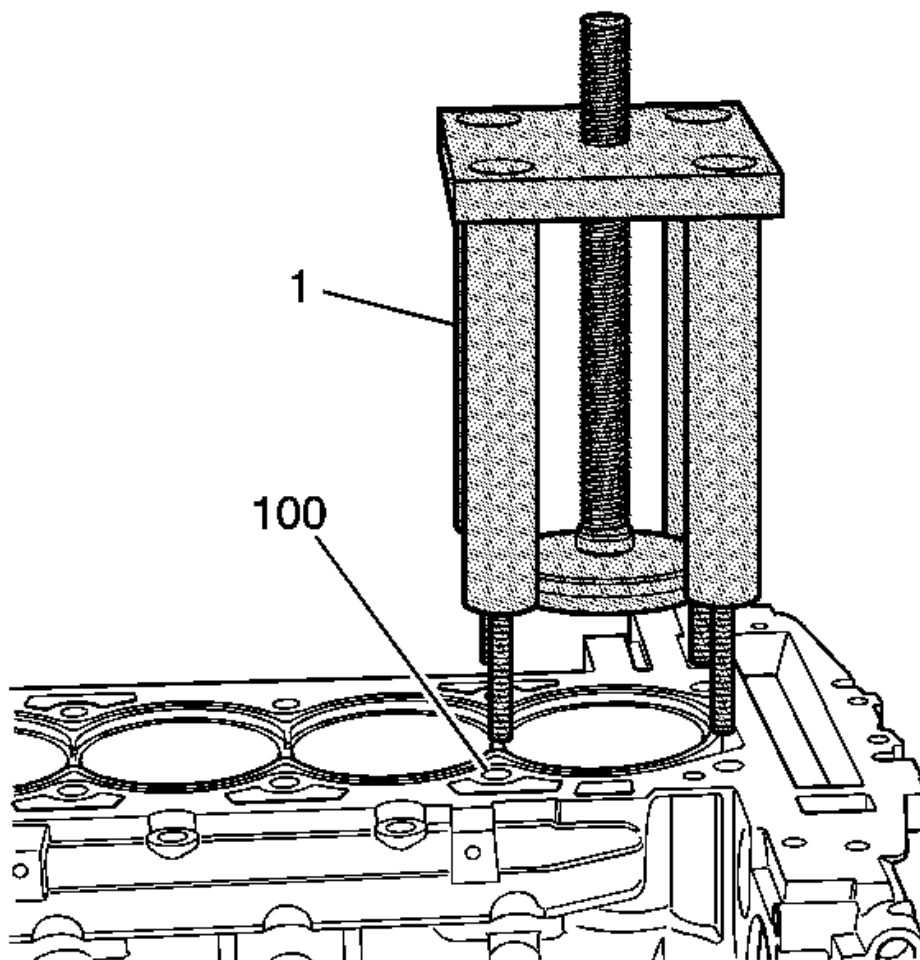


Fig. 331: View Of Service Tool Assembly
Courtesy of GENERAL MOTORS CORP.

11. Remove the fixture assembly EN 45680-851 with the cylinder bore sleeve installer EN 45680-853 (1) from the cylinder block (100).

Cylinder Sleeve Trimming

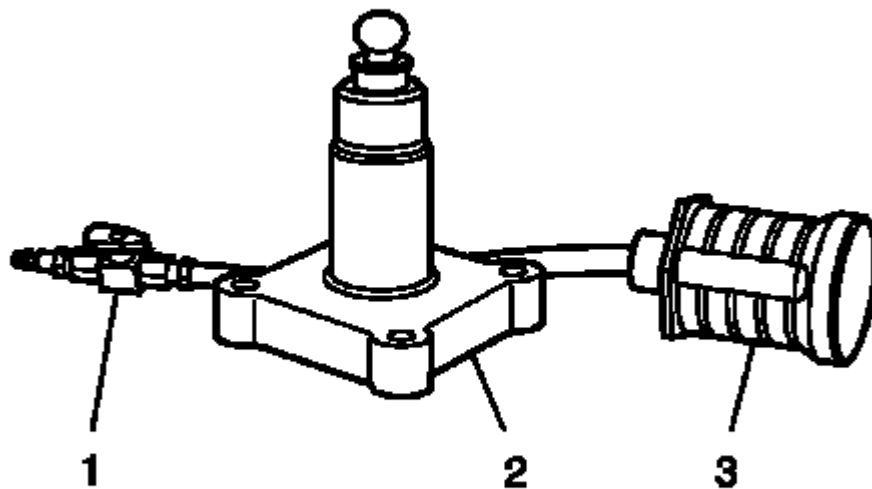


Fig. 332: View Of Cylinder Liner Trimming Tools (1 Of 2)
Courtesy of GENERAL MOTORS CORP.

The EN 45680-861 trim tool assembly (2) from **EN 45680-850** contains or requires the following components to complete 86 mm cylinder sleeve trimming:

- Debris collector (3) with filter EN-45680-865 from **EN 45680-850**
- Air control valve (1)
- Drill motor with 1/2 inch chuck, 1 1/8 hp, 7 amps, triple gear reduction, and a 450-600 RPM rotational speed in a clockwise direction
- EN 45680-869 bore cutter bit and screw from **EN 45680-850**
- EN 45680-899 Bore trimmer pilot from **EN 45680-850** , white in color

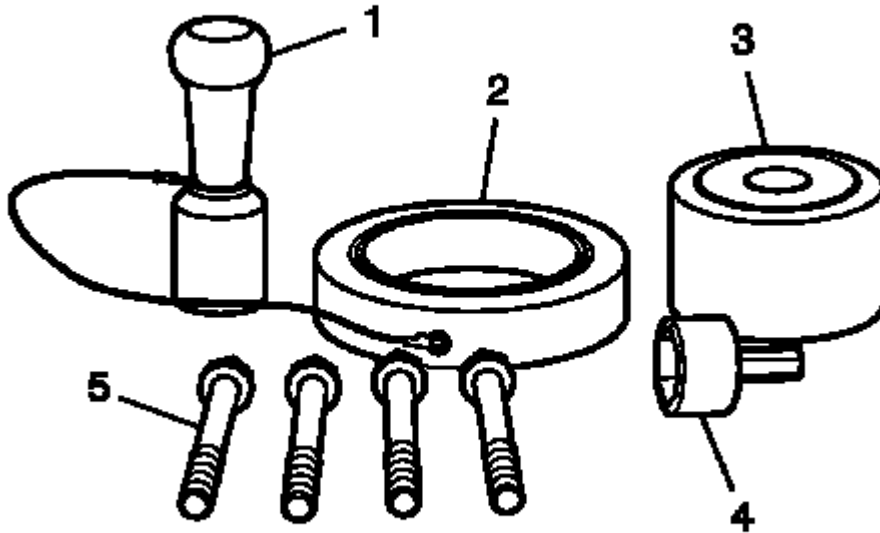


Fig. 333: View Of Cylinder Liner Trimming Tools (2 Of 2)
Courtesy of GENERAL MOTORS CORP.

- Gage ring assembly EN-45680-862 from **EN 45680-850**
 - Trim tool preloader (1)
 - Set gage ring (2)
- EN 45680-412 Set Gage Ring (2)
- EN 45680-863 metal shavings catch plug (3) from **EN 45680-850**
- EN 45680-866 drive adapter (4) from **EN 45680-850**
- EN 45680-864 bolts (5) from **EN 45680-850**

NOTE: Do not bore or hone the cylinder bore sleeve. The cylinder bore sleeve inside diameter (I.D) is fully machined and honed to size and is optimally finished as shipped. Any attempt to modify this factory-produced sizing and finish with additional boring and honing will lead to engine damage, excessive noise or abnormal oil consumption.

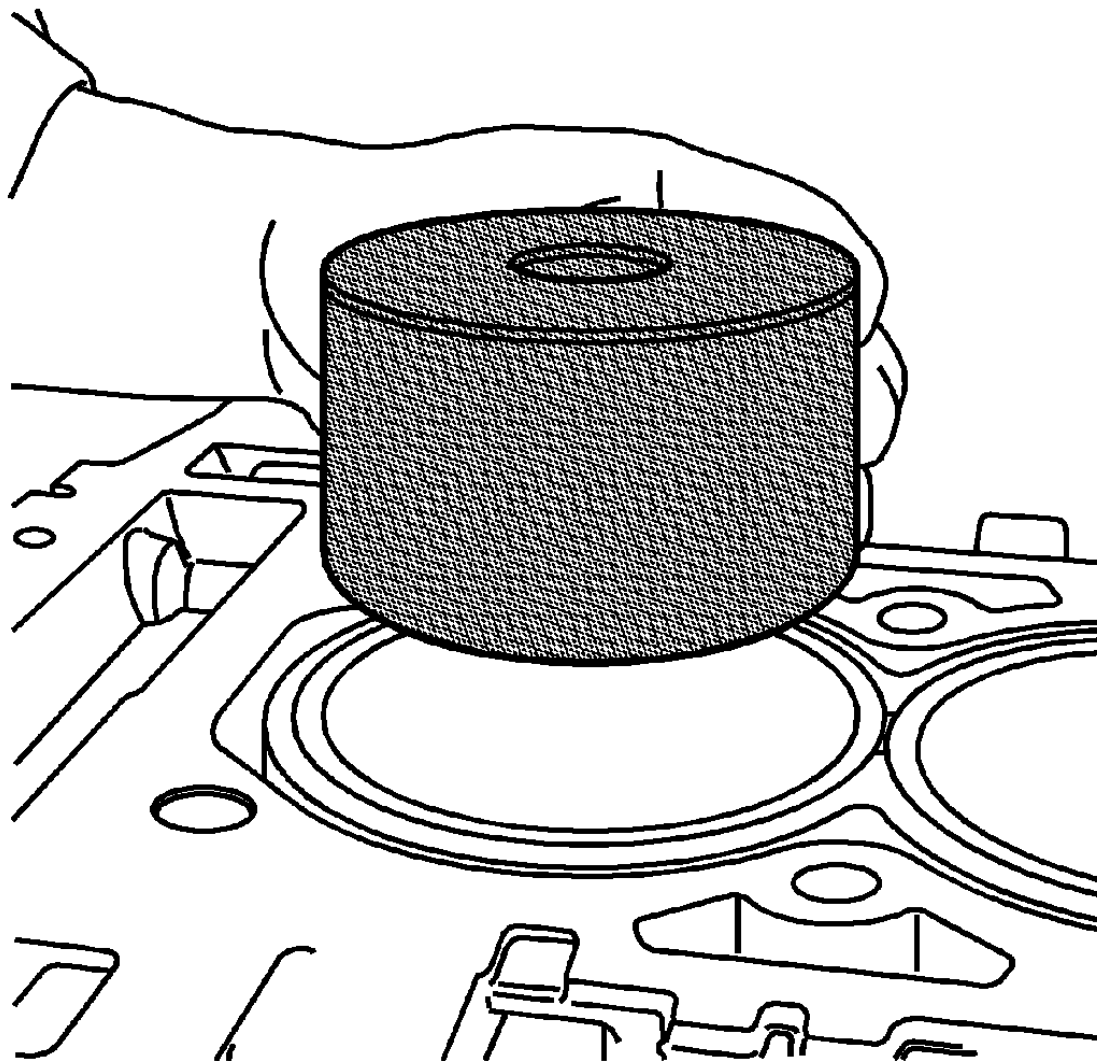


Fig. 334: Placing Metal Shaving Catch Plug Into Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

1. After installing the NEW cylinder bore sleeve(s) into the engine block, trim the excess material from the cylinder bore sleeve flange.

NOTE: **Ensure that all the metal particles are collected in order to prevent internal damage to the engine or bearings.**

2. Place the metal shaving catch plug EN 45680-863 into the cylinder bore sleeve to be trimmed. Position the top approximately 3.0 mm (0.12 in) below the top surface of the cylinder bore sleeve.
3. Place an additional metal shaving catch plug EN 45680-863 into all remaining cylinder bore sleeves.

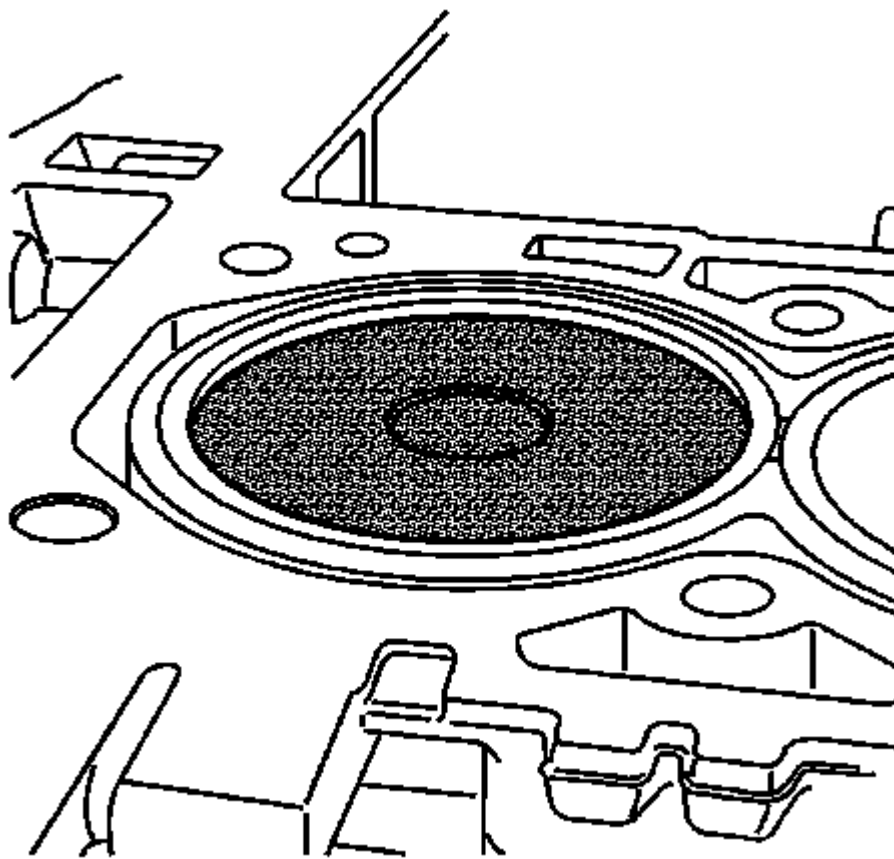


Fig. 335: Identifying Catch Plug Positioning
Courtesy of GENERAL MOTORS CORP.

NOTE: Installing the metal shaving catch plug deeper than the recommended depth will create a decrease in vacuum system performance. A decrease in vacuum system performance will cause metal shavings to enter the engine and cause engine failure.

NOTE: Installing the metal shaving catch plug above the recommended depth will cause damage to the metal shaving catch plug.

4. Ensure that the metal shaving catch plug EN 45680-863 is 3.0 mm (0.12 in) below the top surface of the cylinder bore sleeve.
5. Ensure that the correct bore trimmer pilot and cutter bit are installed on the trimmer base assembly EN 45680-861:
 - EN 45680-869 cutter bit and screw
 - EN 45680-899 trimmer pilot, 86 mm sleeve

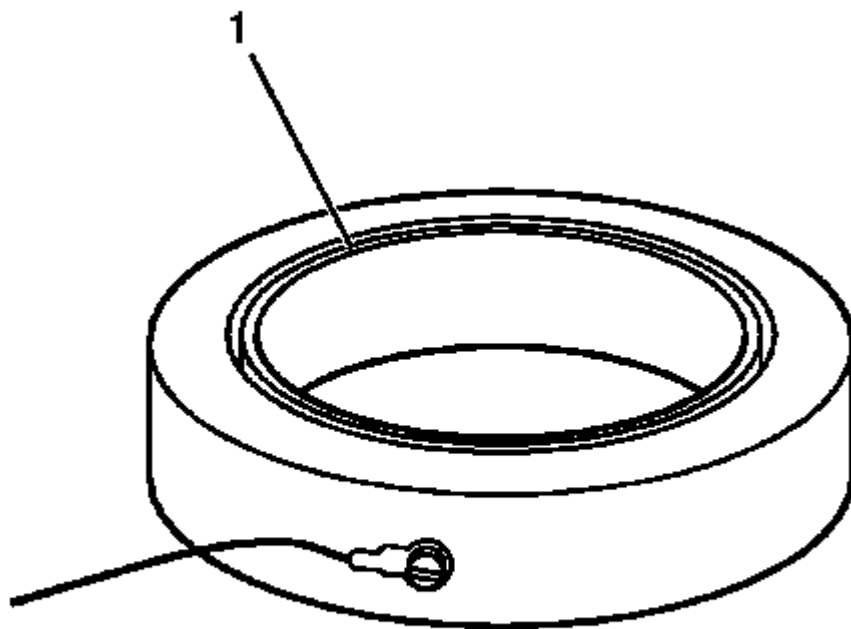


Fig. 336: Identifying Set Gauge Ring Groove
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Before using the trim tool assembly, the height of the cutting blades must be set to the proper specification. The proper specification is that the cylinder bore sleeve flange must be flush to $+0.02$ mm (0.0008 in) above the block deck surface.

6. The groove side of the set gage ring (1) on the gage ring assembly EN 45680-862 should be positioned upward on a flat surface.

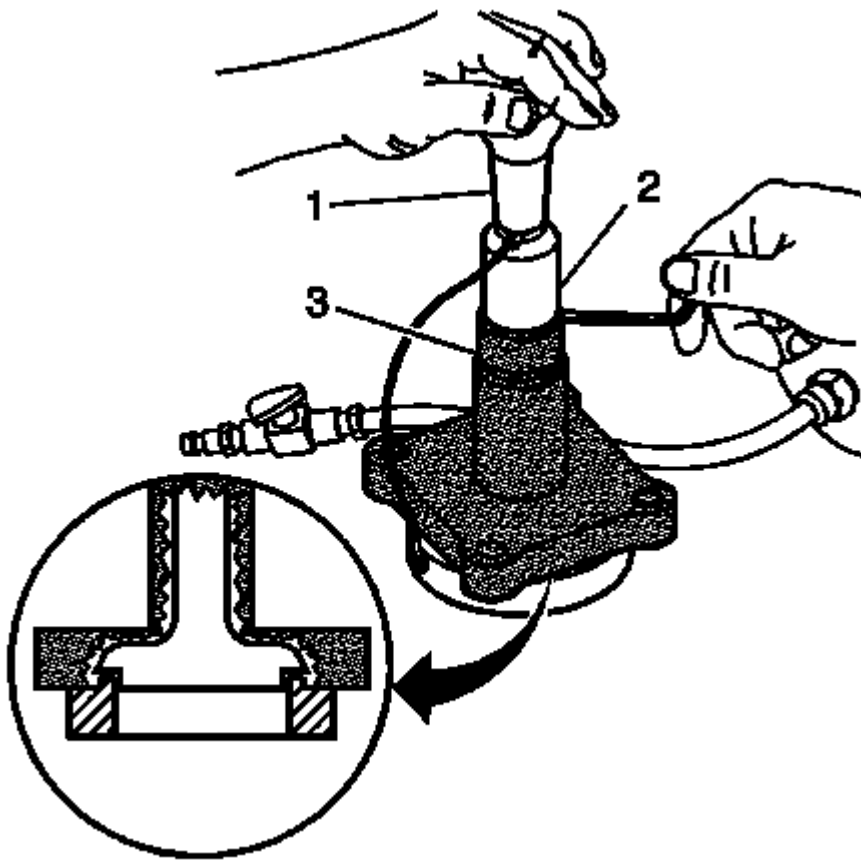


Fig. 337: View Of Trim Tool Assembly Components And Positioning
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Ensure that the set gage ring surfaces are clean.

7. Carefully position the trim tool assembly EN 45680-861 onto the set gage ring.
8. Loosen the shaft collar screw (2).
9. Push the shaft collar (2) downward using the trim tool preloader (1) on the gage ring assembly EN 45680-862 until the shaft collar is positioned against the top of the flange bearing (3).

IMPORTANT: Once this procedure is done, it is not necessary to reset the trim tool assembly height until the blades are worn, damaged, or replaced.

10. Apply downward pressure on the collar and inner drive shaft using the trim tool preloader (1), then tighten the shaft collar screw.

Tighten: Tighten the shaft collar screw to 19 N.m (14 lb ft).

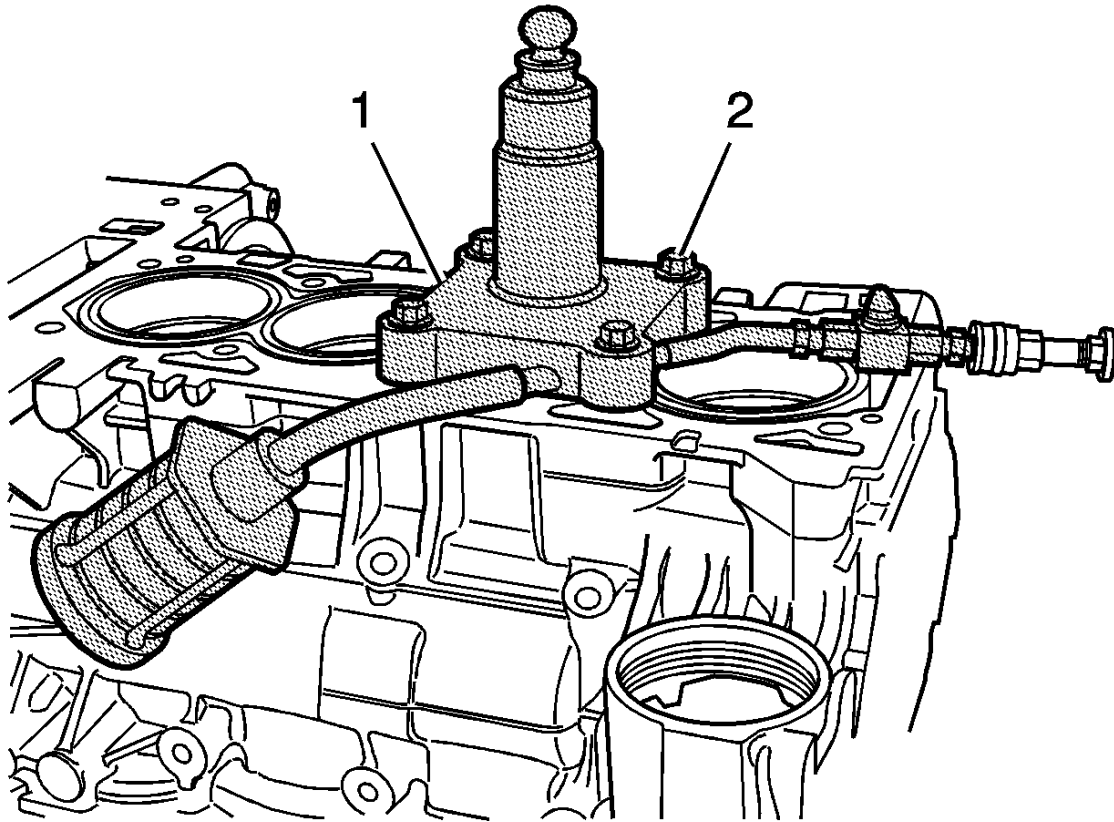


Fig. 338: Aligning Trim Tool Assembly
 Courtesy of GENERAL MOTORS CORP.

11. Place the trim tool assembly EN 45680-861 onto the cylinder to be trimmed with the directional arrow (1) pointing in line with the crankshaft centerline and the front of the block.
12. Install the 4 bolts EN 45680-864 (2) into the cylinder head bolt holes in the block.

Tighten: Tighten the bolts to 20 N.m (15 lb ft).

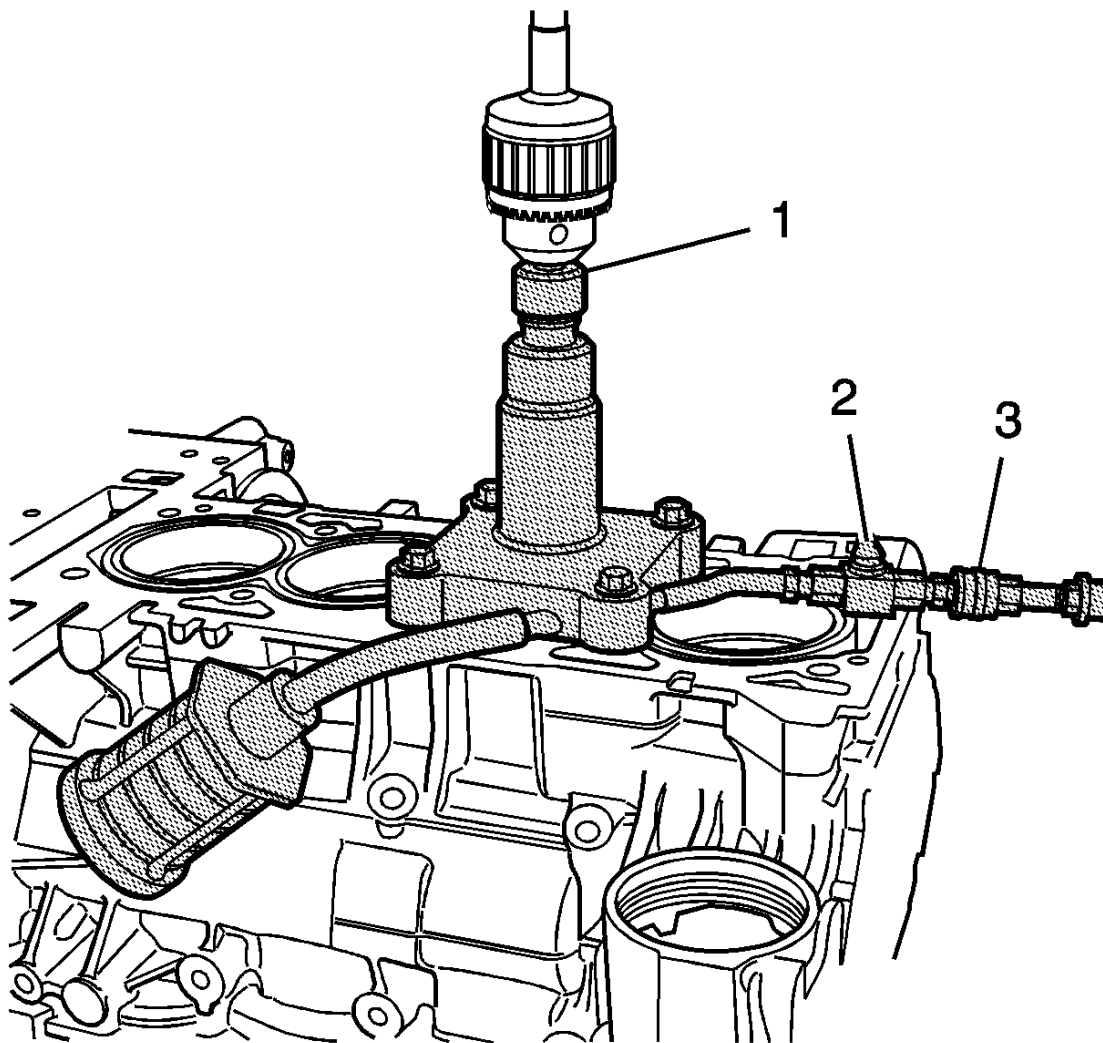


Fig. 339: View Of Drive Adapter
Courtesy of GENERAL MOTORS CORP.

NOTE: For proper tool operation, a drill motor with a 1/2 inch chuck, 1 1/8 hp, 7 amps, triple gear reduction, and a 450-600 RPM rotational speed in a clockwise direction must be used. If the proper drill motor is not used, damage to the cylinder bore sleeve will occur.

13. Fasten the drive adapter EN 45680-866 (1) into the drill chuck.

NOTE: Ensure that there are no crimps in the air feed hose or the vacuum hose. Crimps in the hose may cause metal shavings to exit the cutting tool in any direction, causing engine damage.

14. Connect a compressed air supply 517.10-861.84 kPa (75-125 psi) to the male quick connect (3) located on trim tool assembly EN 45680-861. Turn the compressed air valve (2) to the open position. This starts the venturi vacuum system that will catch the metal shavings.

IMPORTANT: It should not take longer than 15 seconds to complete the trimming procedure. If it does, the trimming bits must be repositioned to a new cutting surface.

15. Place the drive adapter EN 45680-866 and drill assembly (1) vertically onto the drive adapter end of trim tool assembly EN 45680-861. Do not apply downward force on the drill until full rotational speed has been reached. After reaching full rotational speed, apply firm downward force until the cutting action is complete.
16. Remove the drive adapter EN 45680-866 (1) and drill assembly from the trim tool assembly EN 45680-861.
17. Turn off the compressed air valve (2).
18. Remove the trim tool assembly EN 45680-861 from the engine block.
19. Remove any material shavings that may be found on the metal shaving catch plug EN 45680-863.
20. Wipe the cylinder bore sleeve and surrounding areas free of any powder residue and then remove the metal shaving catch plug EN 45680-863.

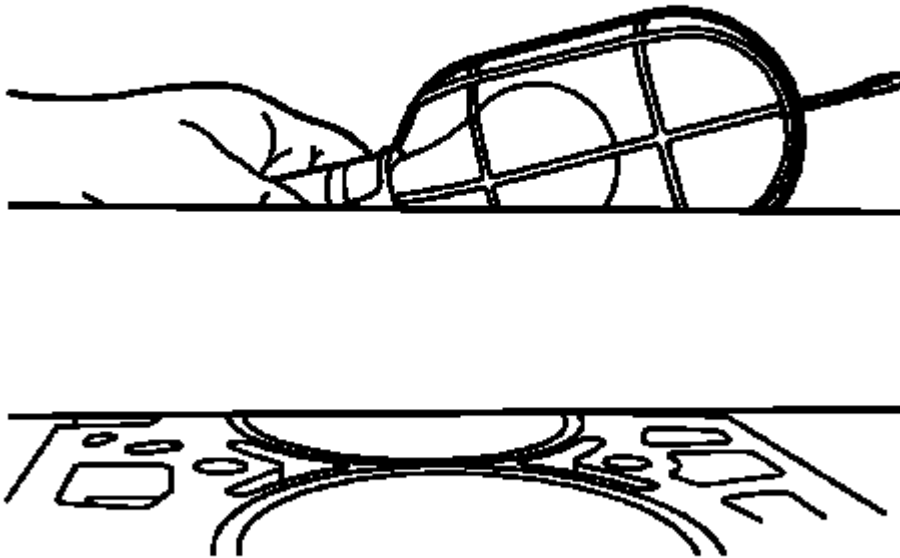


Fig. 340: Checking Cylinder Block Deck Surface With Straight Edge
Courtesy of GENERAL MOTORS CORP.

21. Install a straight edge on the cylinder block perpendicular to the crankshaft center line.

22. Using a light, illuminate the backside of the straight edge.

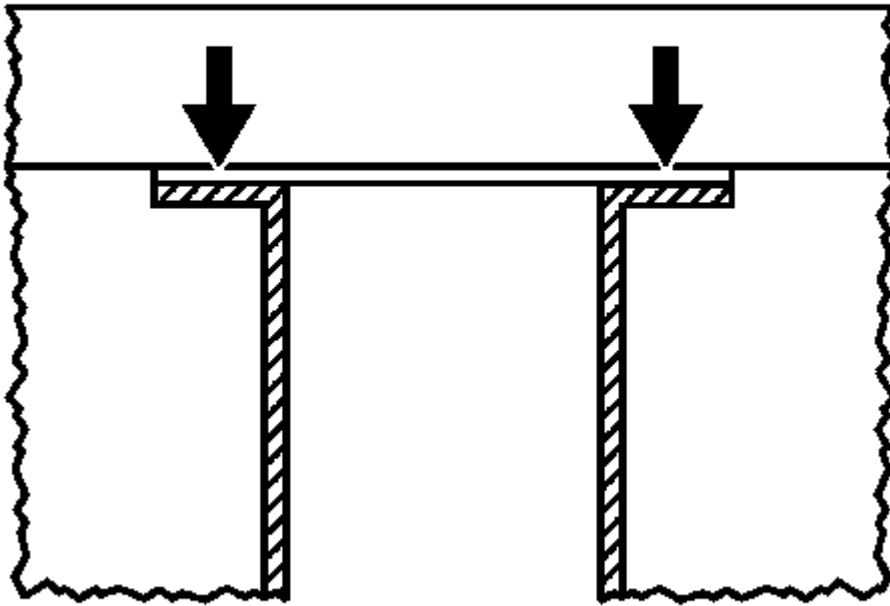


Fig. 341: View Of Improperly Cut Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

23. Looking at the front of the straight edge, check to see if light is protruding through the bottom of the straight edge and the top of the cylinder bore sleeve flange. If light is present on either side or both sides of the cylinder bore sleeve, the cylinder bore sleeve is cut incorrectly and a new cylinder bore sleeve needs to be installed.

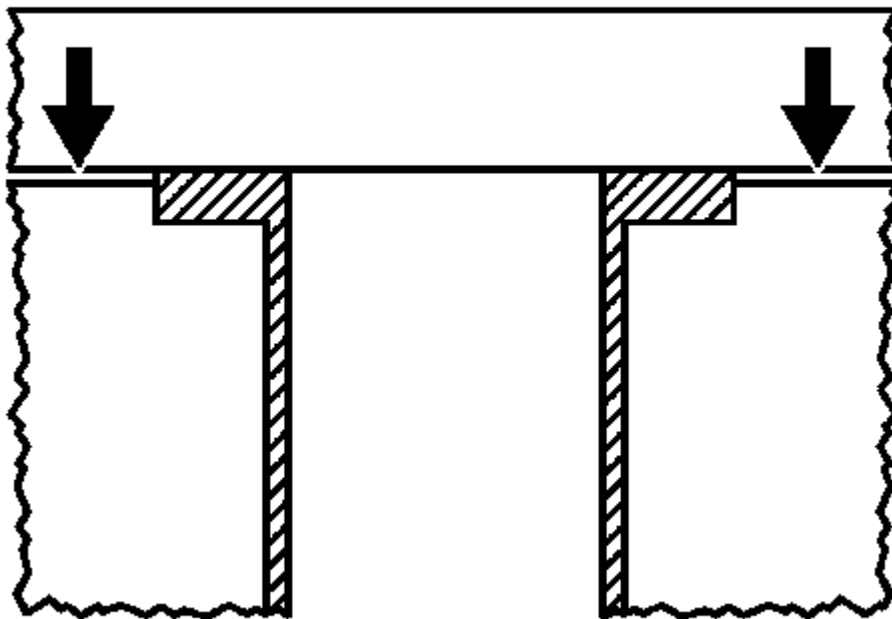


Fig. 342: View Of For Properly Cut Cylinder Bore Sleeve
Courtesy of GENERAL MOTORS CORP.

24. Looking at the front of the straight edge, check to see if light is protruding through the bottom of the straight edge and the top of the cylinder block deck surface. If light is present on both sides of the cylinder block, the cylinder bore sleeve is cut correctly.
25. Proceed to the next bore sleeve to be trimmed repeating steps 10-23 if necessary.

CRANKSHAFT BALANCER CLEANING AND INSPECTION

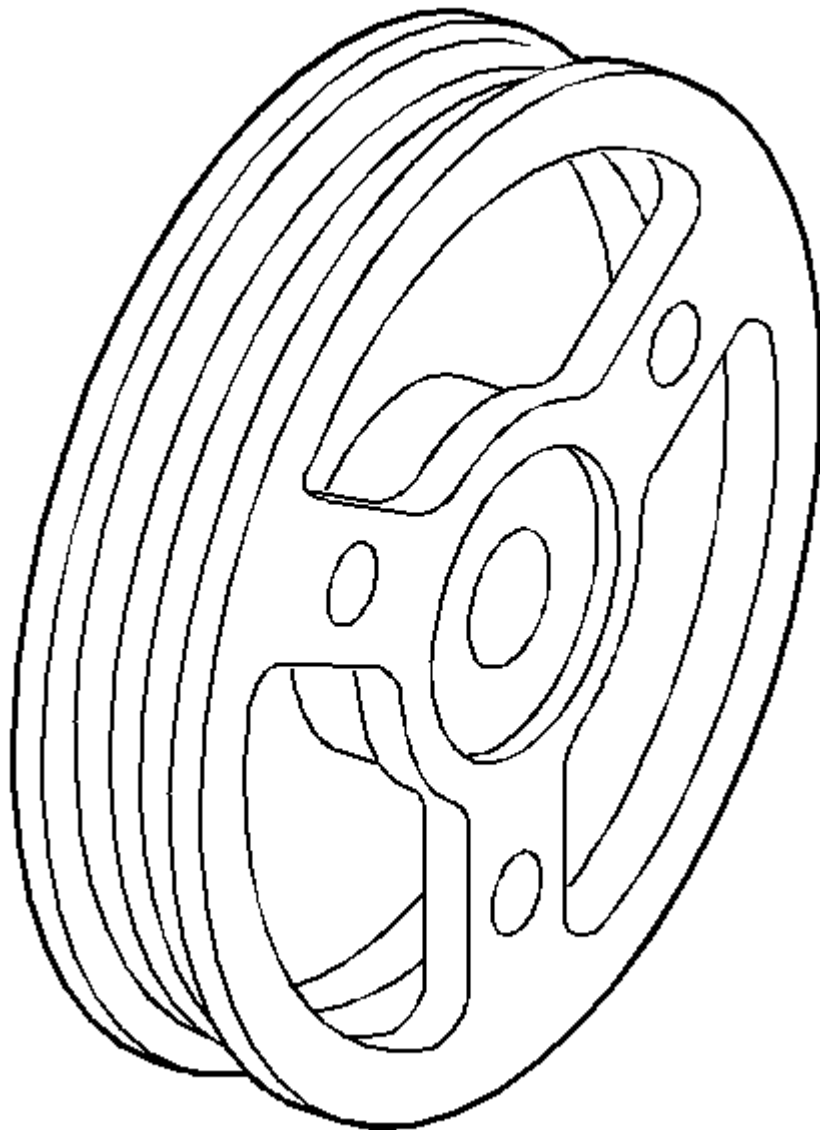


Fig. 343: Inspecting Crankshaft Balancer
Courtesy of GENERAL MOTORS CORP.

1. Clean the crankshaft balancer.
2. Clean the belt grooves of all dirt or debris with a wire brush.

CAUTION: Refer to SAFETY GLASSES CAUTION .

3. Dry the crankshaft balancer with compressed air.
4. Inspect the crankshaft balancer for the following:
 - Worn, grooved, or damaged hub seal surface

A crankshaft balancer hub seal surface with excessive scoring, grooves, rust or other damage must be replaced.

IMPORTANT: In order for the belt to track properly, the belt grooves should be free of all dirt or debris.

- Dirty or damaged belt grooves

The balancer belt grooves should be free of any nicks, gouges, or other damage that may not allow the belt to track properly.

Minor imperfections may be removed with a fine file.

- Worn, chunking or deteriorated rubber between the hub and pulley

ENGINE FLYWHEEL CLEANING AND INSPECTION

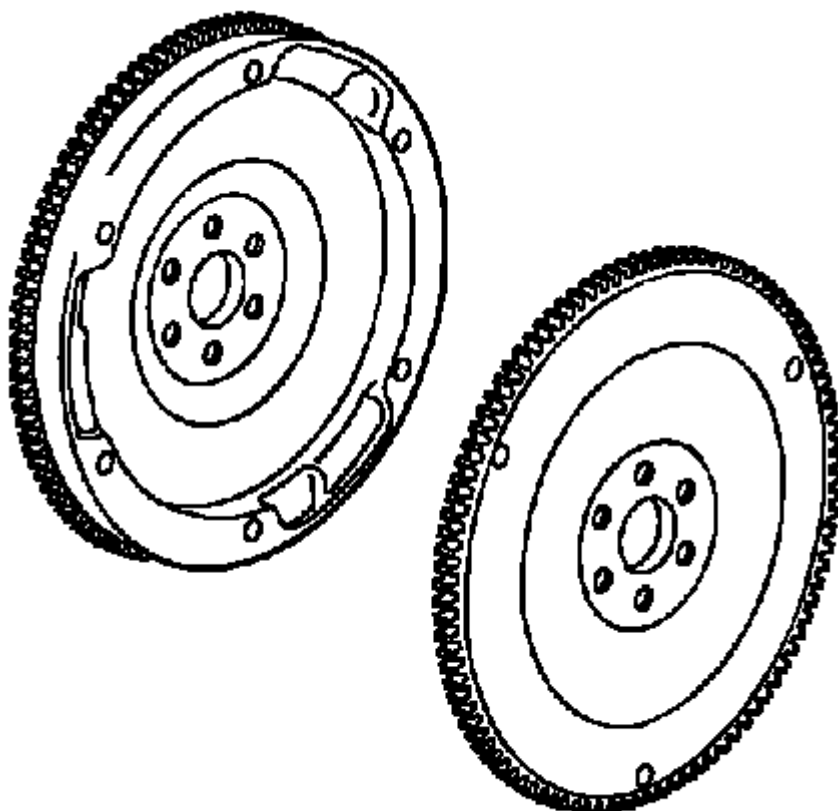


Fig. 344: Identifying Engine Flywheel
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: In order to maintain the proper component balance, contact surface taper, and heat transfer, manual transmission flywheels are **NOT** to be machined.

1. Clean the flywheel in solvent.

CAUTION: Refer to **SAFETY GLASSES CAUTION** .

2. Dry the flywheel with compressed air.

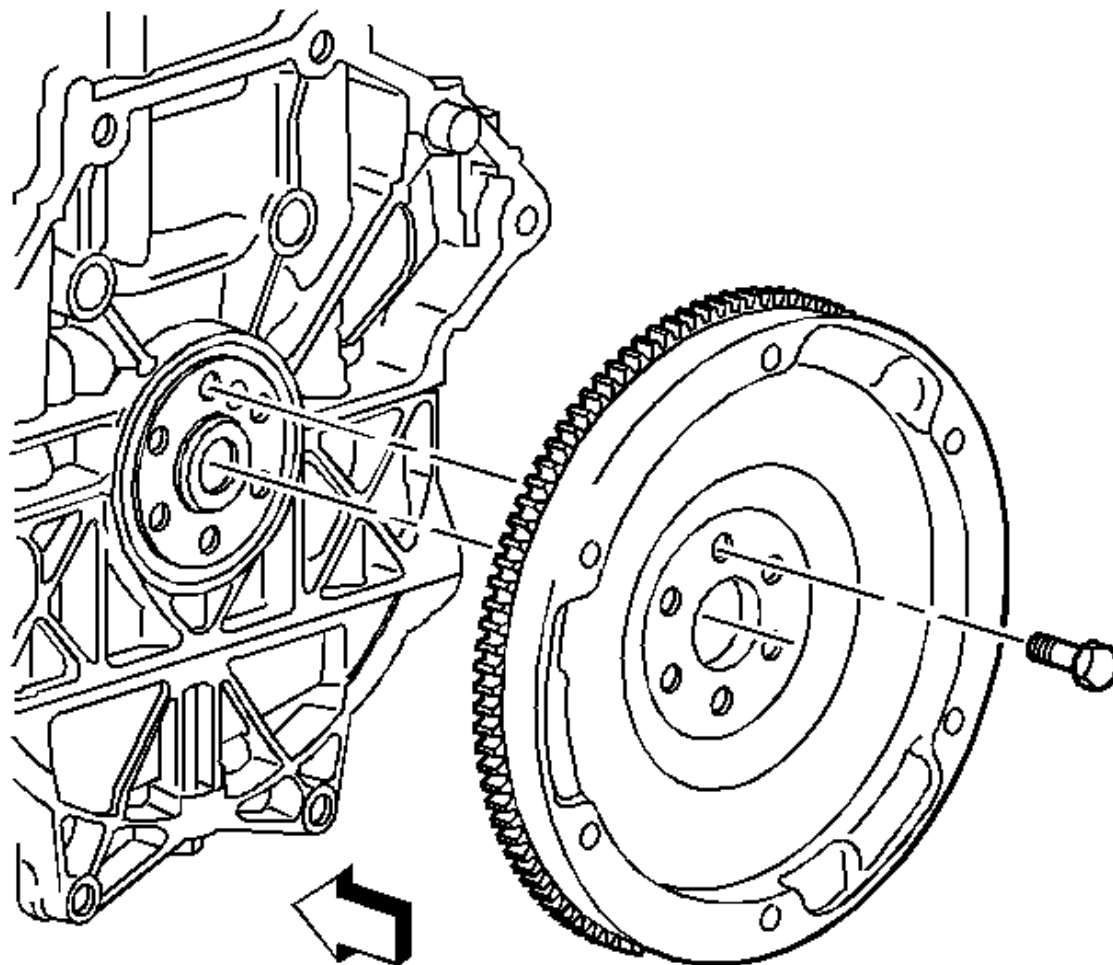


Fig. 345: Identifying Flywheel & Retaining Bolts
Courtesy of GENERAL MOTORS CORP.

3. Inspect the manual transmission flywheel for the following:
- Damaged ring gear teeth
 - Loose or improperly positioned ring gear

The ring gear has an interference fit onto the flywheel and should be positioned completely against the flange of the flywheel.

- A scored, grooved or damaged friction surface

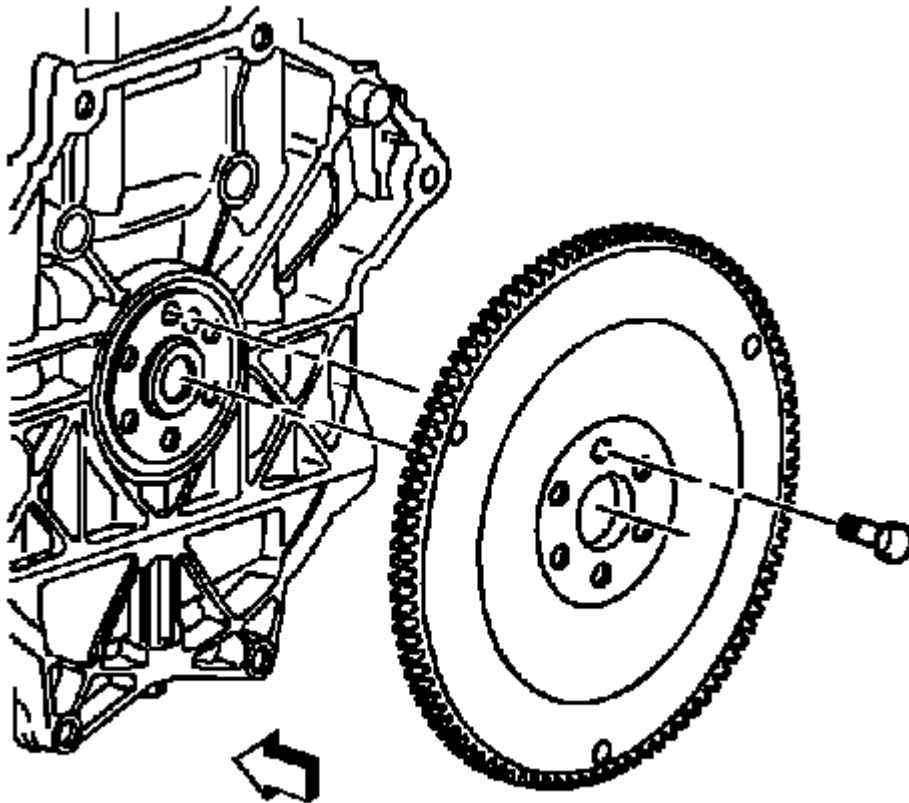


Fig. 346: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

4. Inspect the automatic transmission flywheel for the following:
 - Damaged ring gear teeth
 - Stress cracks around the flywheel-to-crankshaft bolt hole locations
 - Weight saving holes

CRANKSHAFT AND BEARING CLEANING AND INSPECTION

Tools Required

J 7872 Magnetic Base Dial Indicator Set

Procedure

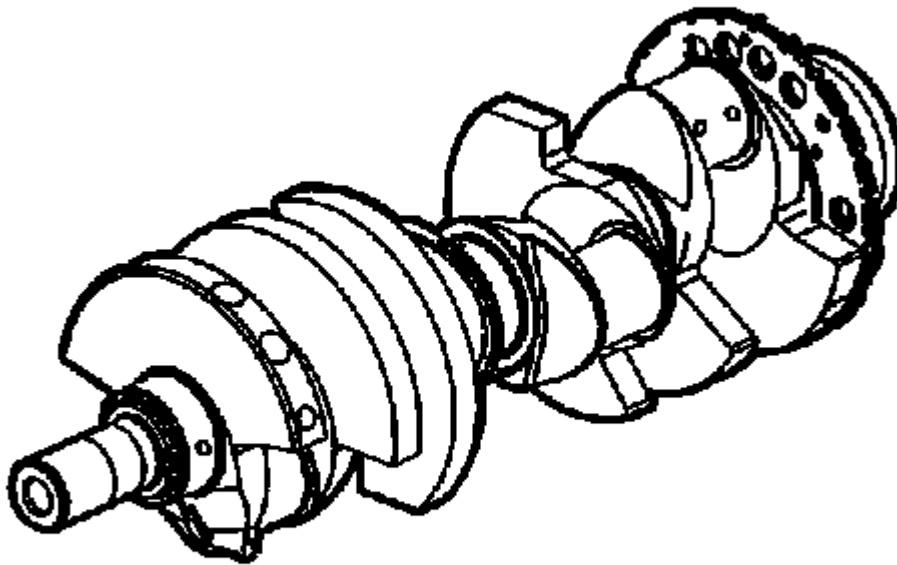


Fig. 347: View Of Crankshaft
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Use care when handling the crankshaft. Avoid damage to the bearing surfaces or the lobes of the crankshaft position reluctor ring. Damage to the teeth of the crankshaft position reluctor ring may affect on-board diagnostic (OBD) II system performance.

1. Clean the crankshaft with solvent.
2. Thoroughly clean all oil passages and inspect for restrictions or burrs.

CAUTION: Refer to Safety Glasses Caution .

3. Dry the crankshaft with compressed air.

IMPORTANT: Reluctor ring teeth should not have imperfections on the rising or falling edges.
Imperfections of the reluctor ring teeth may effect OBD II system

performance.

4. Perform a visual inspection of the crankshaft for damage.

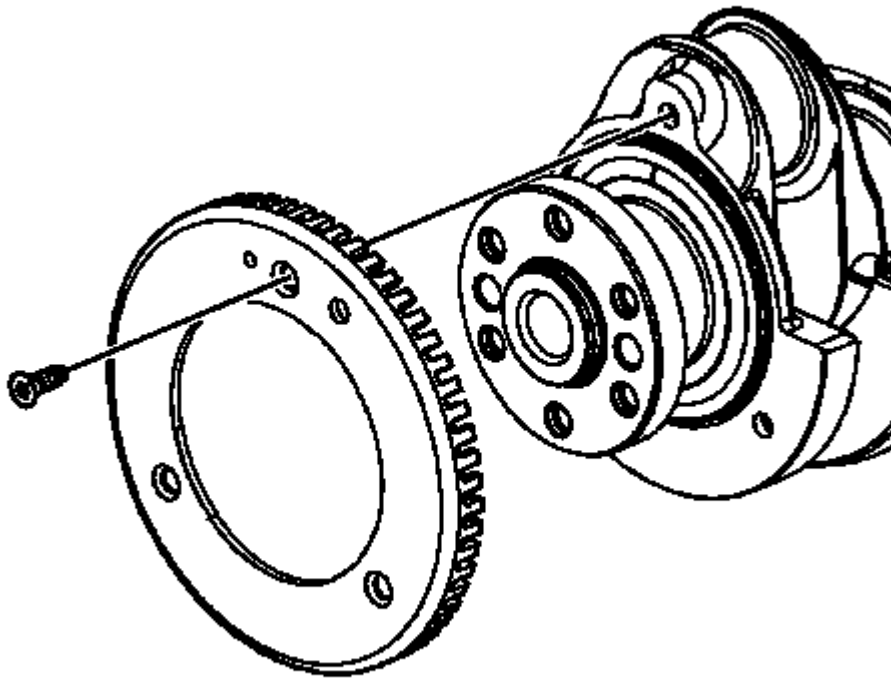


Fig. 348: View Of Crankshaft Position Reluctor Ring
Courtesy of GENERAL MOTORS CORP.

5. The crankshaft position reluctor ring may be replaced if damaged.

Tighten: Tighten the crankshaft position reluctor ring bolts to 15 N.m (11 lb ft).

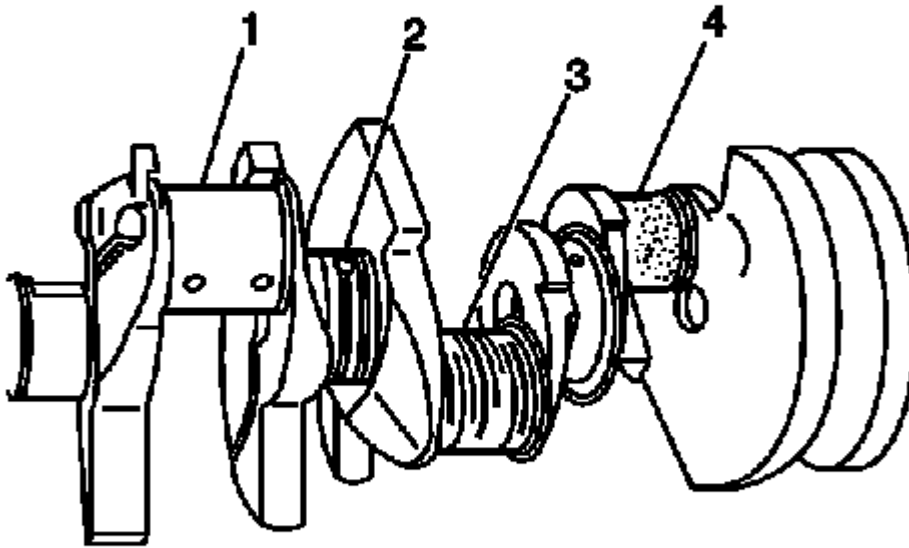


Fig. 349: Identifying Different Crankshaft Journal Wear Patterns
Courtesy of GENERAL MOTORS CORP.

6. Inspect the crankshaft journals for wear (1). The journals should be smooth, with no signs of scoring, wear, or damage.
7. Inspect the crankshaft journals for grooves or scoring (2).
8. Inspect the crankshaft journals for scratches or wear (3).
9. Inspect the crankshaft journals for pitting or imbedded bearing material (4).

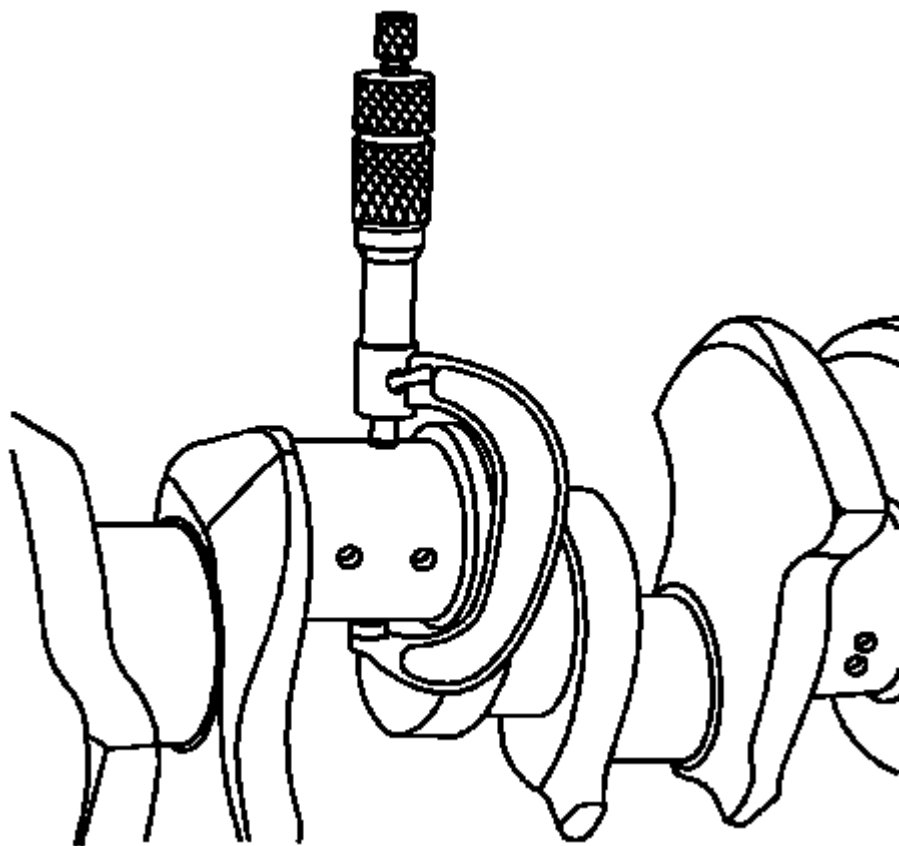


Fig. 350: Measuring Crankshaft Journals
Courtesy of GENERAL MOTORS CORP.

10. Measure the crankshaft journals for out-of-round.
11. Measure the crankshaft journals for taper.

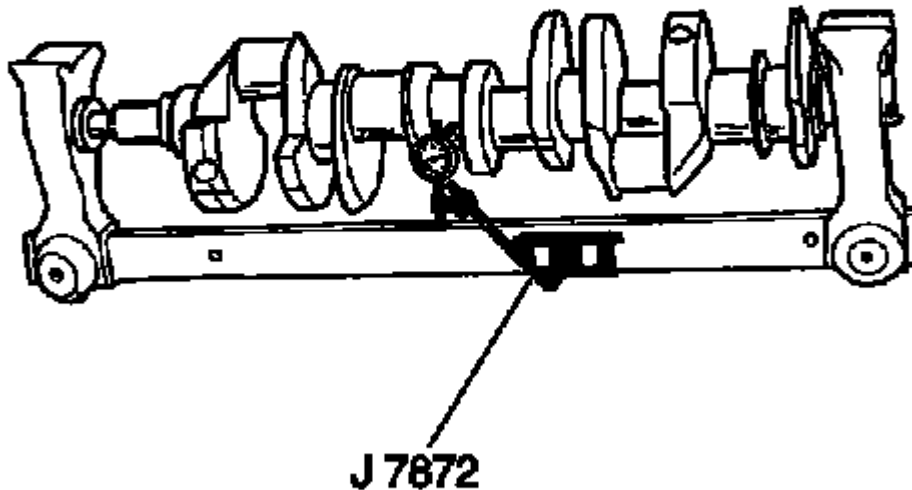


Fig. 351: Measuring Crankshaft Runout
Courtesy of GENERAL MOTORS CORP.

12. Measure the crankshaft runout.

Using wooden V-blocks, support the crankshaft on the front and rear journals.

13. Use the **J 7872** in order to measure the crankshaft runout at the front and rear intermediate journals.
14. Use the **J 7872** in order to measure the runout of the crankshaft rear flange.
15. Replace the crankshaft if the measurements are not within specifications.

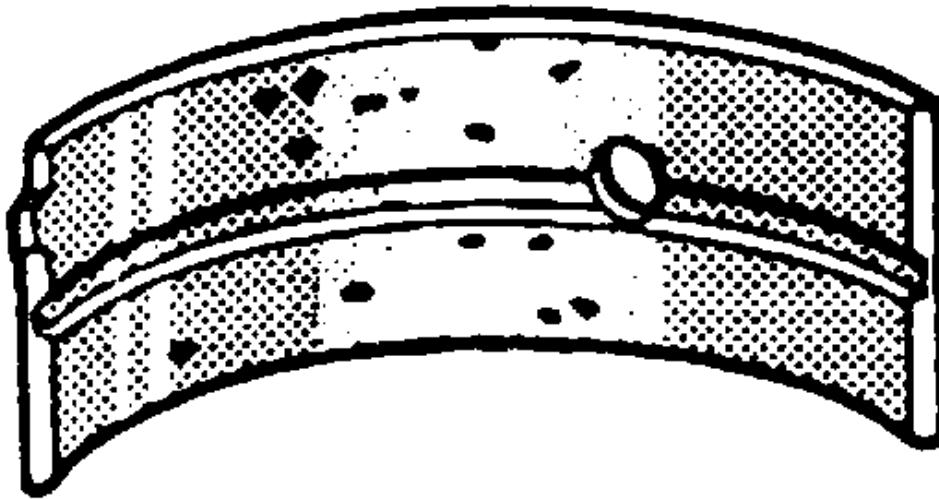


Fig. 352: Identifying Crankshaft Bearing Craters Or Pockets
Courtesy of GENERAL MOTORS CORP.

16. Inspect crankshaft bearings for craters or pockets. Flattened sections on the bearing halves also indicate fatigue.

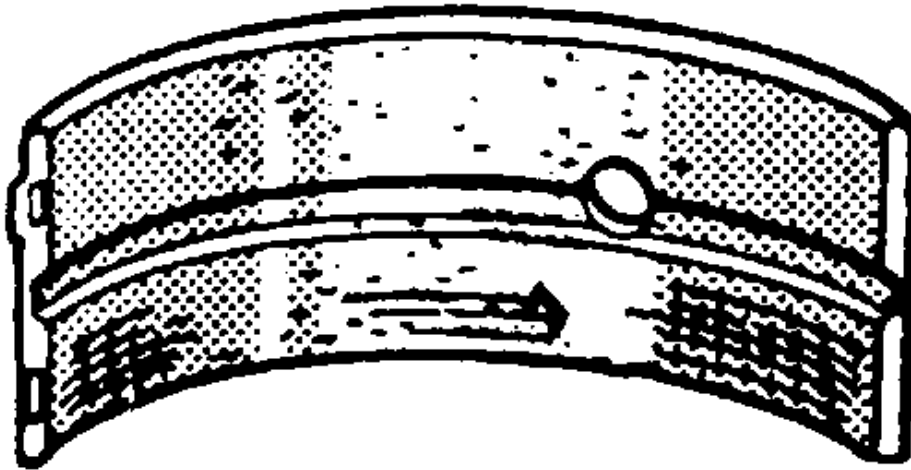


Fig. 353: Identifying Connecting Rod Bearing Scoring Or Discoloration
Courtesy of GENERAL MOTORS CORP.

17. Inspect the crankshaft bearings for excessive scoring or discoloration.
18. Inspect the crankshaft bearings for dirt or debris imbedded into the bearing material.

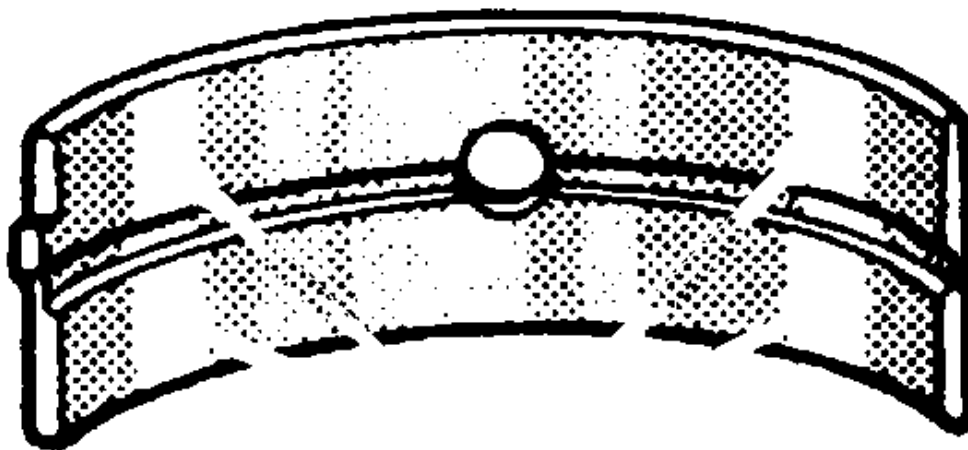


Fig. 354: Crankshaft Bearing Polished Sections (Improper Seating)
Courtesy of GENERAL MOTORS CORP.

19. Inspect the crankshaft bearings for improper seating indicated by bright, polished sections of the bearing.
If the lower half of the bearing is worn or damaged, both upper and lower halves should be replaced.
Generally, if the lower half is suitable for use, the upper half should also be suitable for use.

PISTON AND CONNECTING ROD DISASSEMBLE

Tools Required

EN-46745 Piston Pin Retainer Remover and Installer

Disassembly Procedure



Fig. 355: Exploded View Of Piston Rings
Courtesy of GENERAL MOTORS CORP.

CAUTION: Handle the piston carefully. Worn piston rings are sharp and may cause bodily injury.

1. Disassemble the piston rings. Use a suitable tool to expand the rings. The piston rings must not be reused.

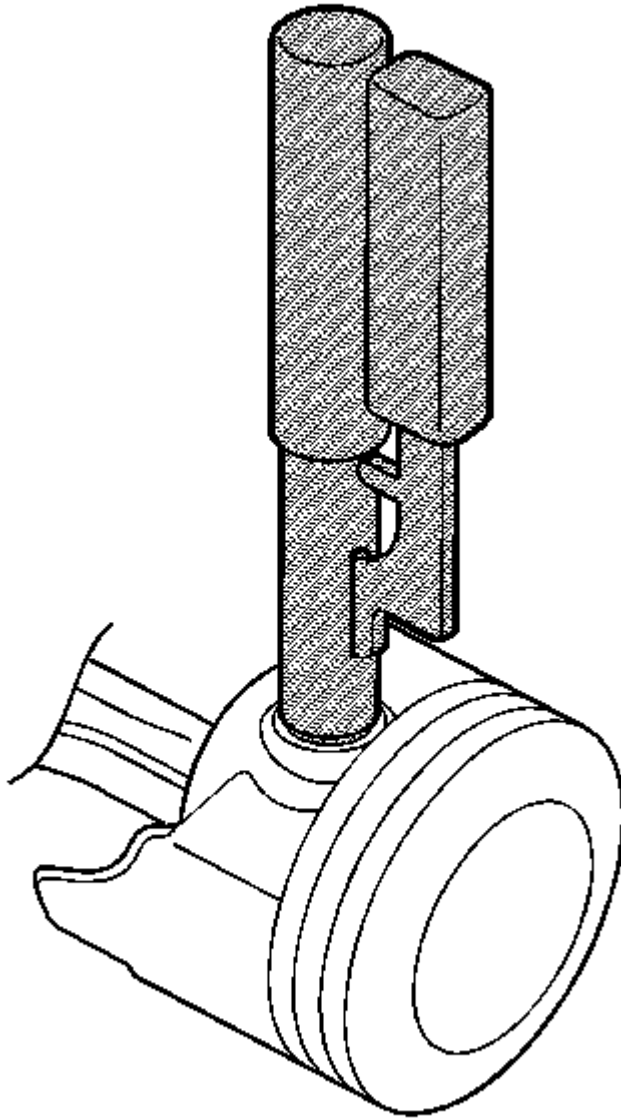


Fig. 356: Identifying Piston Pin Retainers
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Two retainers hold the piston pins in place. No special tools are required to remove the piston pins. Ensure that the piston pin is not damaged. Do not reuse the retainers.

2. Remove the piston pin retainers using the EN-46745 .

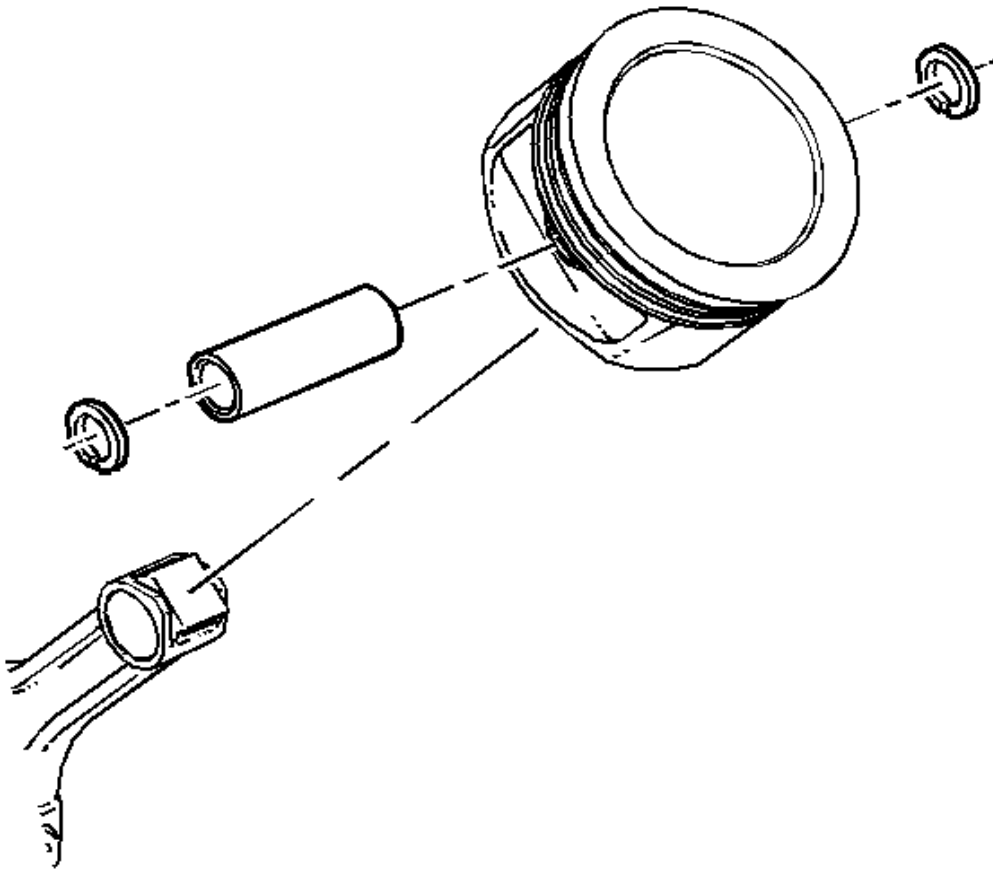


Fig. 357: View Of Piston Pin, Piston, Clips & Connecting Rod
Courtesy of GENERAL MOTORS CORP.

3. Remove the piston pin.

PISTON, CONNECTING ROD, AND BEARING CLEANING AND INSPECTION

Connecting Rod Measurement

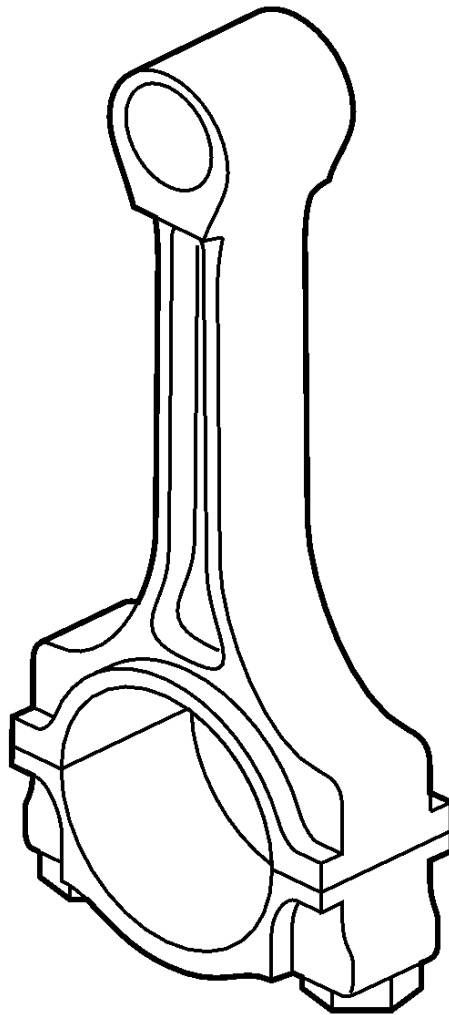


Fig. 358: View Of Connecting Rod
Courtesy of GENERAL MOTORS CORP.

1. Clean the connecting rods in solvent and dry with compressed air.
2. Inspect the connecting rods for the following:
 - Signs of being twisted, bent, nicked, or cracked
 - Scratches or abrasion on the rod bearing seating surface
3. If the connecting rod bores contain minor scratches or abrasions, clean the bores in a circular direction with a light emery paper. DO NOT scrape the rod or rod cap.
4. If the beam of the rod is scratched or has other damage replace the connecting rod.
5. Measure the piston pin to connecting rod bore using the following procedure:
 1. Using an outside micrometer, take two measurements of the piston pin in the area of the connecting rod contact.
 2. Using an inside micrometer, measure the connecting rod piston pin bore.
 3. Subtract the piston pin diameter from the piston pin bore diameter.

4. The clearance should not be more than 0.021 mm (0.0008 in).
6. If there is excessive clearance, replace the piston pin.
7. If there is still excessive clearance, replace the connecting rod.

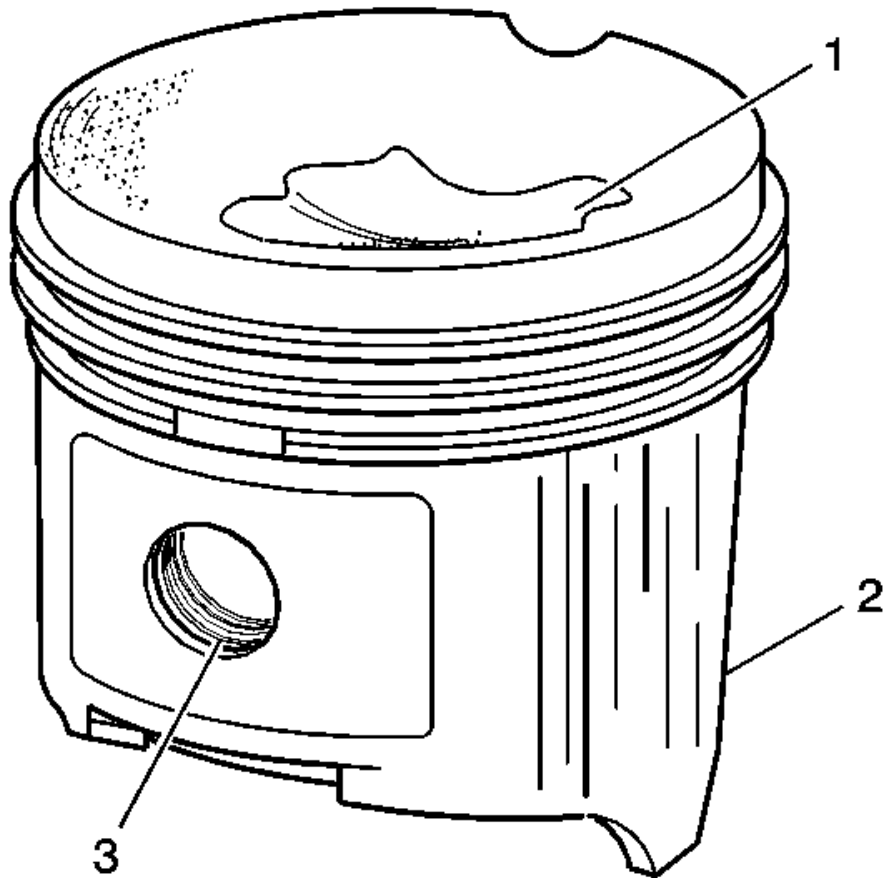
Piston Measurement

Fig. 359: Identifying Piston Damage Inspection Areas
Courtesy of GENERAL MOTORS CORP.

1. Clean the piston skirts and the pins with a cleaning solvent. DO NOT wire brush any part of the piston.
2. Clean the piston ring grooves with a groove cleaner. Make sure oil ring holes and slots are clean.
3. Inspect the pistons for the following conditions:
 - Cracked ring lands, skirts, or pin bosses
 - Ring grooves for nicks, burrs that may cause binding
 - Warped or worn ring lands
 - Eroded areas at the top of the piston (1)

- Scuffed or damaged skirts (2)
 - Worn piston pin bores (3)
4. Replace pistons that show any signs or damage or excessive wear.
 5. Measure the piston pin bore to piston pin clearances using the following procedure:
 1. Piston pin bores and pins must be free of varnish or scuffing.
 2. Use an outside micrometer to measure the piston pin in the piston contact areas.
 3. Using an inside micrometer, measure the piston pin bore.
 4. Subtract the measurement of the piston pin bore from the piston pin. The clearance should be within 0.002-0.012 mm (0.00007-0.00047 in).
 5. If the clearance is excessive, determine which component is out of specification.

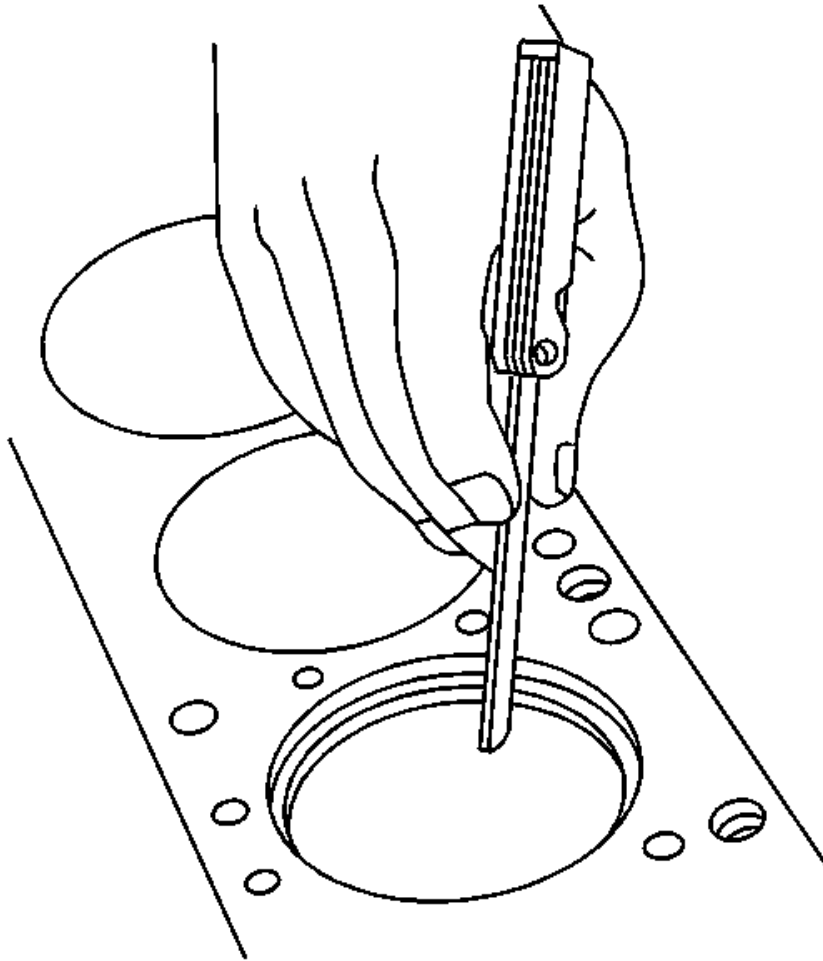


Fig. 360: Measuring Piston Ring End Gap
Courtesy of GENERAL MOTORS CORP.

6. Measure the piston ring end gap using the following procedure:

1. Place the piston ring in the area of the bore where the piston ring will travel (approximately 25 mm or 1 inch down from the deck surface). Be sure the ring is square with the cylinder bore by positioning the ring with the piston head.
2. Measure the end gap of the piston ring with feeler gages. Compare the measurements with those provided below:
 - The top compression ring end gap should be 0.20-0.40 mm (0.0060-0.015 in).
 - The second compression ring end gap should be 0.35-0.55 mm (0.0137-0.0216 in).
 - The oil ring end gap should be 0.25-0.76 mm (0.0098-0.029 in).
3. If the clearance exceeds the provided specifications, the piston rings must be replaced.
4. Repeat the procedure for all the piston rings.

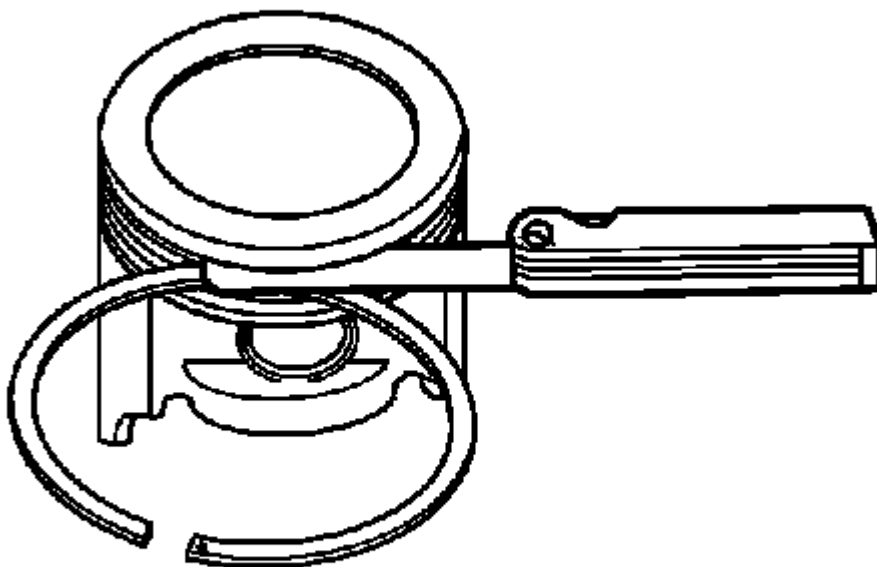


Fig. 361: Measuring Piston Ring Side Clearance
Courtesy of GENERAL MOTORS CORP.

7. Measure the piston ring side clearance using the following procedure:
 1. Roll the piston ring entirely around the piston ring groove. If any binding is caused by a distorted piston ring, replace the ring.
 2. With the piston ring on the piston, use feeler gages to check clearance at multiple locations.

3. The clearance between the surface of the top piston ring and the ring land should be no greater than 0.075 mm (0.0030 in).
4. If the clearance is greater than specifications, replace the piston ring.
5. If the new ring does not reduce the top ring side clearance to 0.075 mm (0.0030 in) or less, install a new piston.
8. The top compression ring may be installed with either side up. There is a locating dimple on the 2nd compression ring near the end for identification of the top side. Install the 2nd compression ring with the dimple facing up.
9. The clearance between the surface of the second piston ring and the ring land should be no greater than 0.069 mm (0.0026 in).
10. If the new ring does not reduce the clearance to 0.069 mm (0.0026 in) or less, install a new piston.

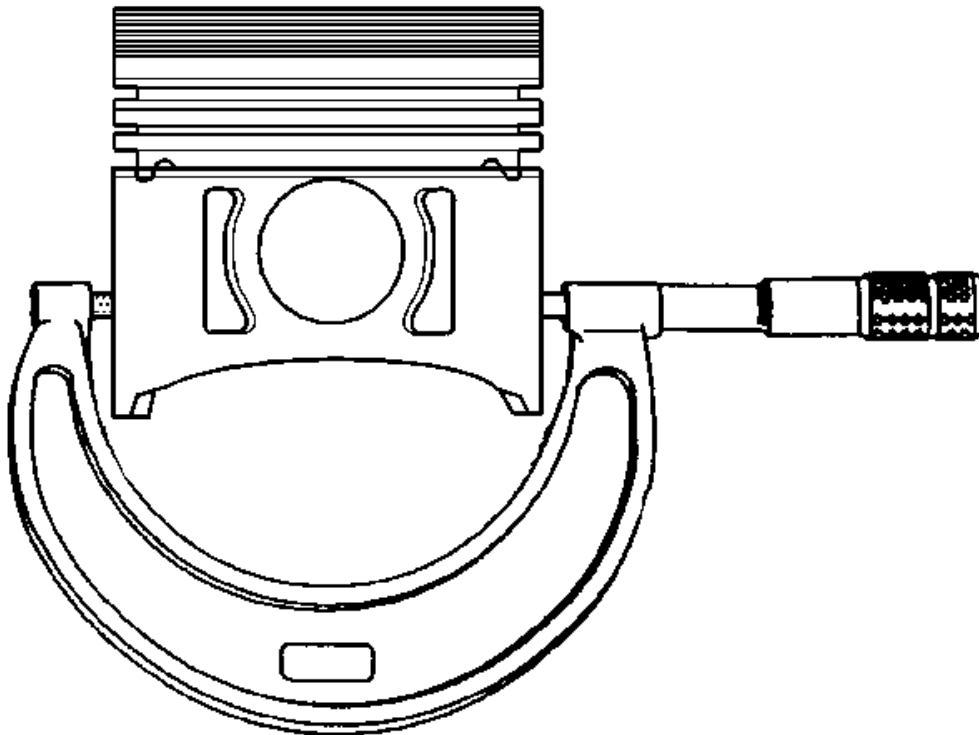


Fig. 362: Measuring Piston Diameter
Courtesy of GENERAL MOTORS CORP.

11. Measure piston width using the following procedure:

1. Using an outside micrometer, measure the width of the piston 14.5 mm (0.570 in) above the bottom of the piston skirt at the thrust surface perpendicular to the centerline of the piston pin.
 2. Compare the measurement of the piston to its original cylinder by subtracting the piston width from the cylinder diameter.
 3. The proper clearance specification for the piston is 0.010-0.041 mm (0.0006-0.0016 in).
12. If the clearance obtained through measurement is greater than these specifications and the cylinder bores are within specification, replace the piston.

Piston Selection

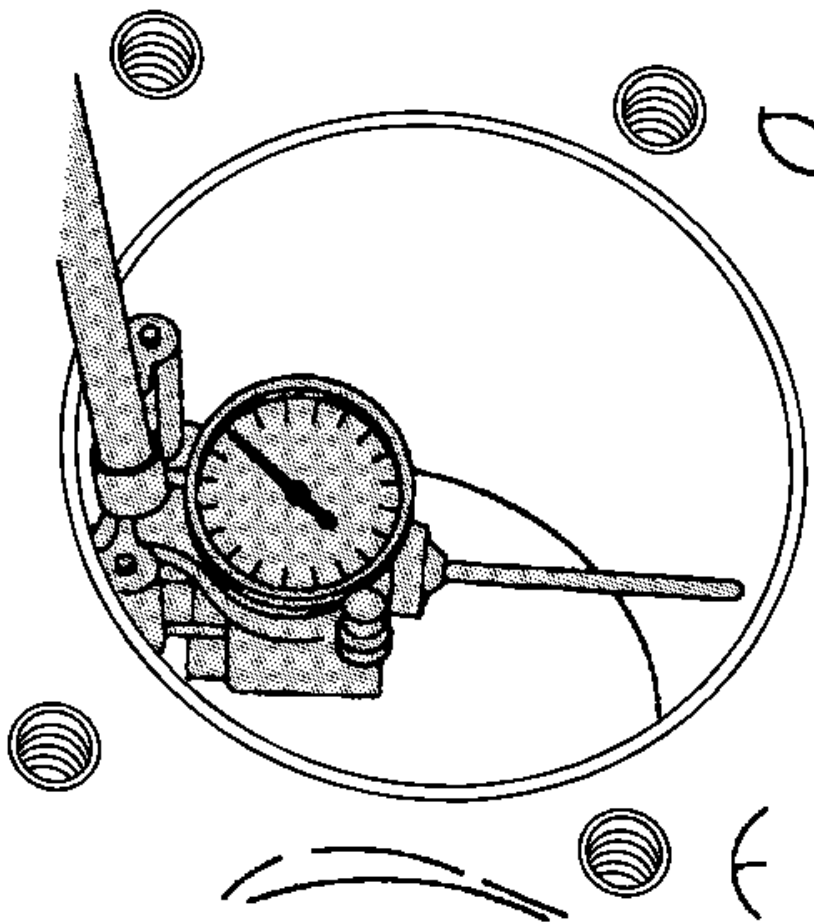


Fig. 363: Measuring Cylinder Bore
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Measurements of all components should be taken with the components at normal room temperature.

For proper piston fit, the engine block cylinder bores must not have excessive wear or taper.

A used piston and pin set may be reinstalled if, after cleaning and

inspection, they are within specifications.

1. Inspect the engine block cylinder bore. Refer to **Engine Block Cleaning and Inspection**.
2. Inspect the piston and the piston pin. Refer to **Piston, Connecting Rod, and Bearing Cleaning and Inspection**.
3. Use a bore gauge and measure the cylinder bore diameter. Measure at a point 64 mm (2.5 in) from the top of the cylinder bore.

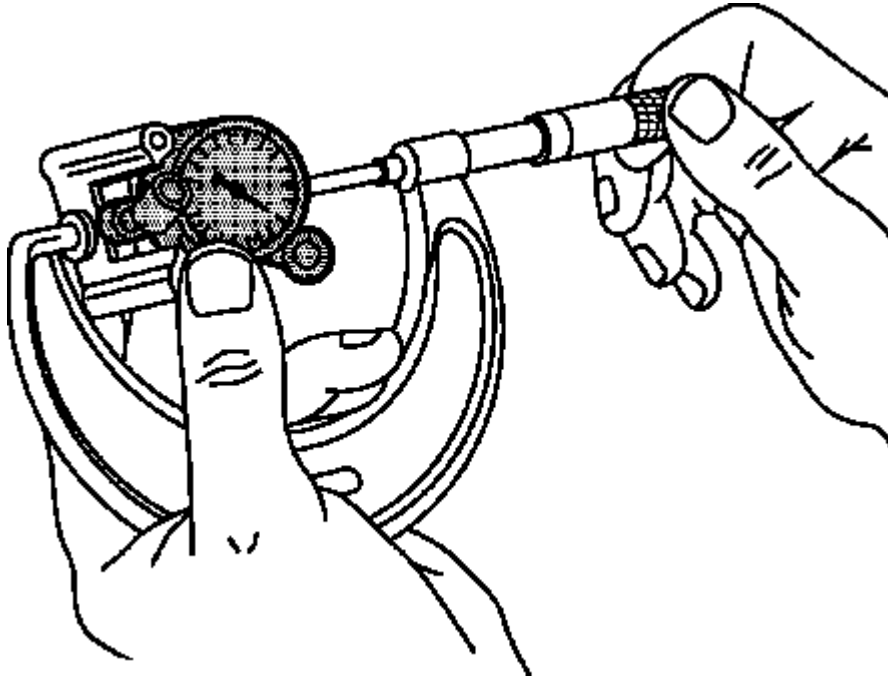


Fig. 364: Measuring Bore Gauge With Micrometer
Courtesy of GENERAL MOTORS CORP.

4. Measure the bore gauge with a micrometer and record the reading.

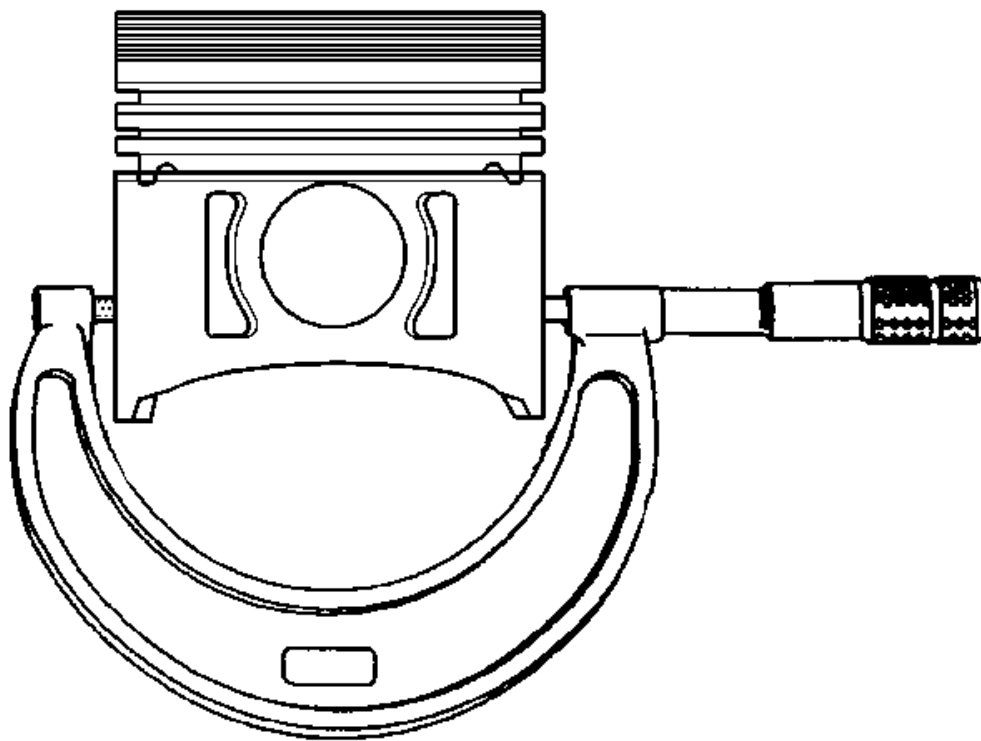


Fig. 365: Measuring Piston Diameter
Courtesy of GENERAL MOTORS CORP.

5. With a micrometer or caliper at a right angle to the piston, measure the piston 14 mm (0.570 in) from the bottom of the skirt.
6. Subtract the piston diameter from the cylinder bore diameter in order to determine piston-to-bore clearance.
7. For proper piston-to-bore clearance. Refer to **Engine Mechanical Specifications**.
8. If the proper clearance cannot be obtained, select another piston and measure for the clearances.
9. If the proper fit cannot be obtained, hone the cylinder bore or replace the cylinder block.
10. When the piston-to-cylinder bore clearance is within specifications, mark the top of the piston using a permanent marker for installation to the proper cylinder. Refer to **Separating Parts** .

PISTON AND CONNECTING ROD ASSEMBLE

Special Tools

EN-46745 Piston Pin Retainer Remover and Installer

assembly Procedure

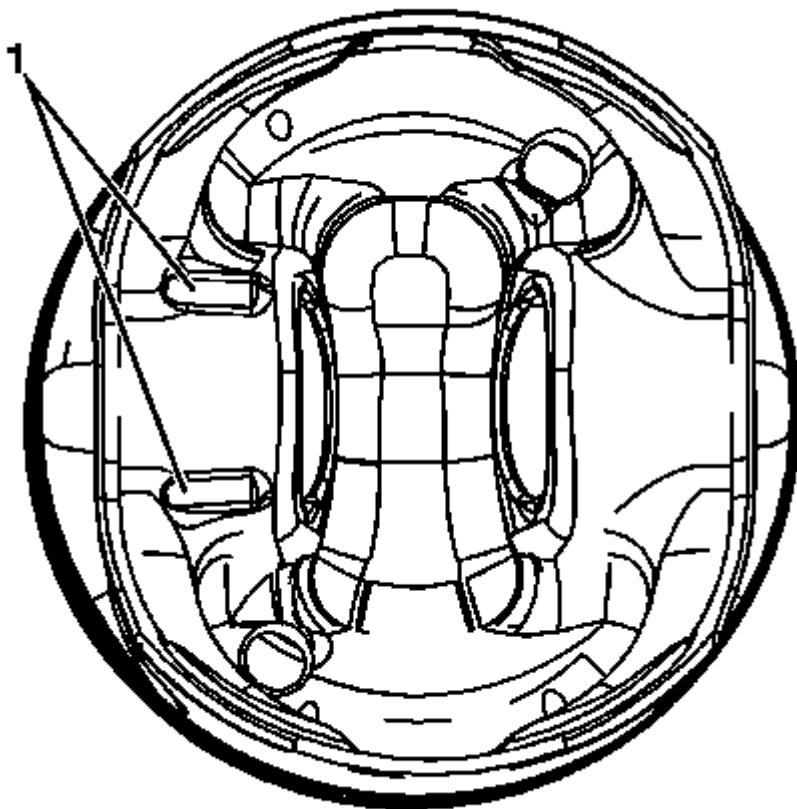


Fig. 366: Locating "Cast Boss" On Underside of Piston
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Install the piston onto the connecting rod with the arrow on top of the piston toward the front oriented toward the front of the engine.

IMPORTANT: The cast boss (1) can be in either or both locations depending on displacement.

1. The cast boss (1), on the underside of the piston, must go to the rear of the block.

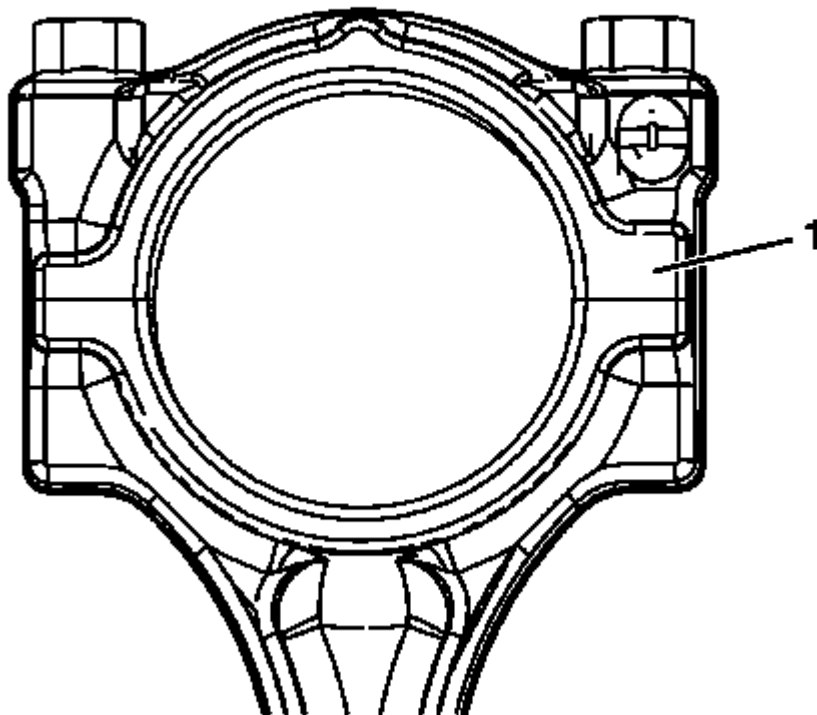


Fig. 367: Identifying Cast Mark
Courtesy of GENERAL MOTORS CORP.

2. The larger feature (1), at the split line located on one side of the connecting rod, must go to the front of the block.

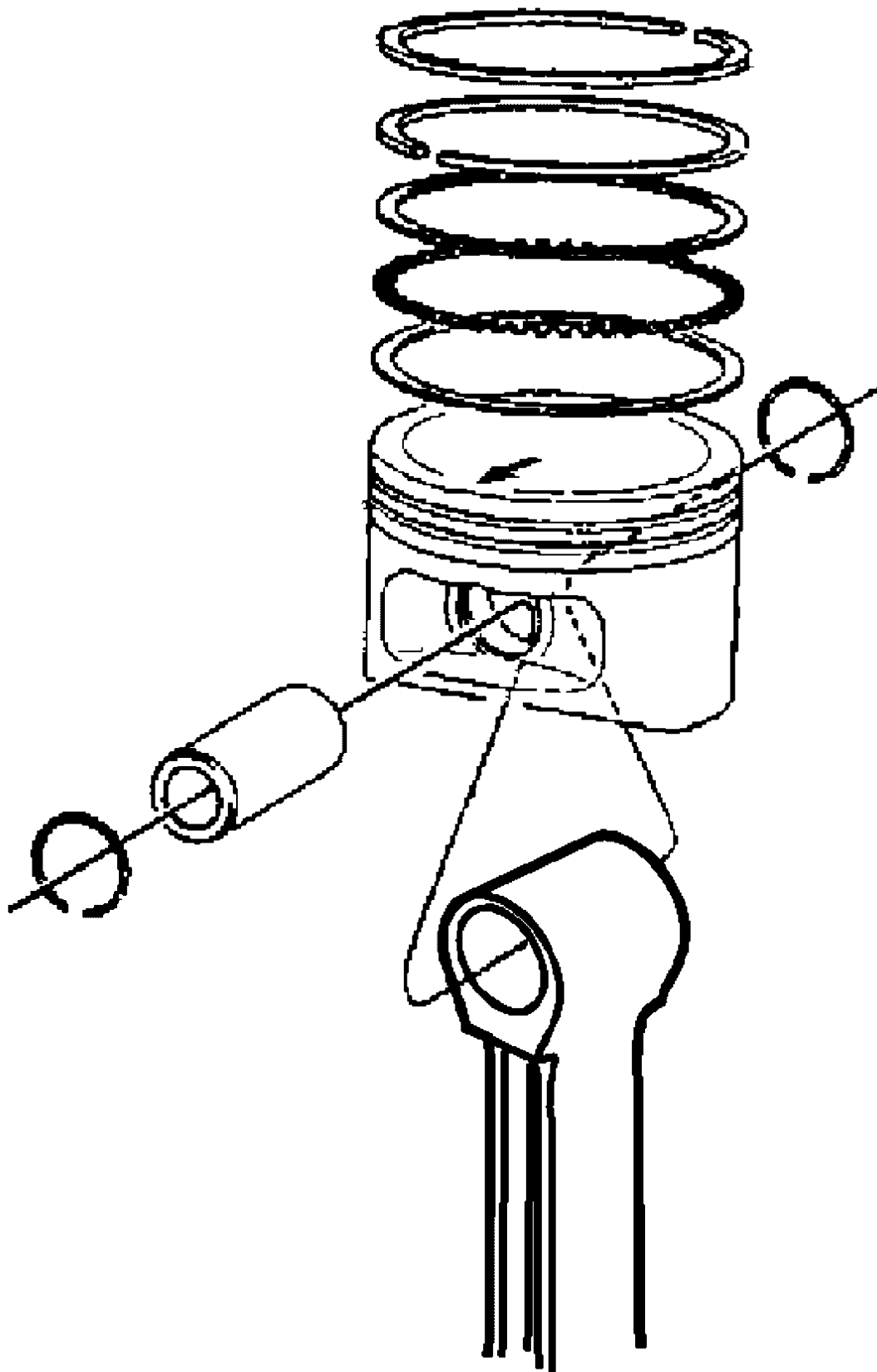


Fig. 368: Assembling Connecting Rod & Piston
Courtesy of GENERAL MOTORS CORP.

3. Assemble the connecting rod and the piston.

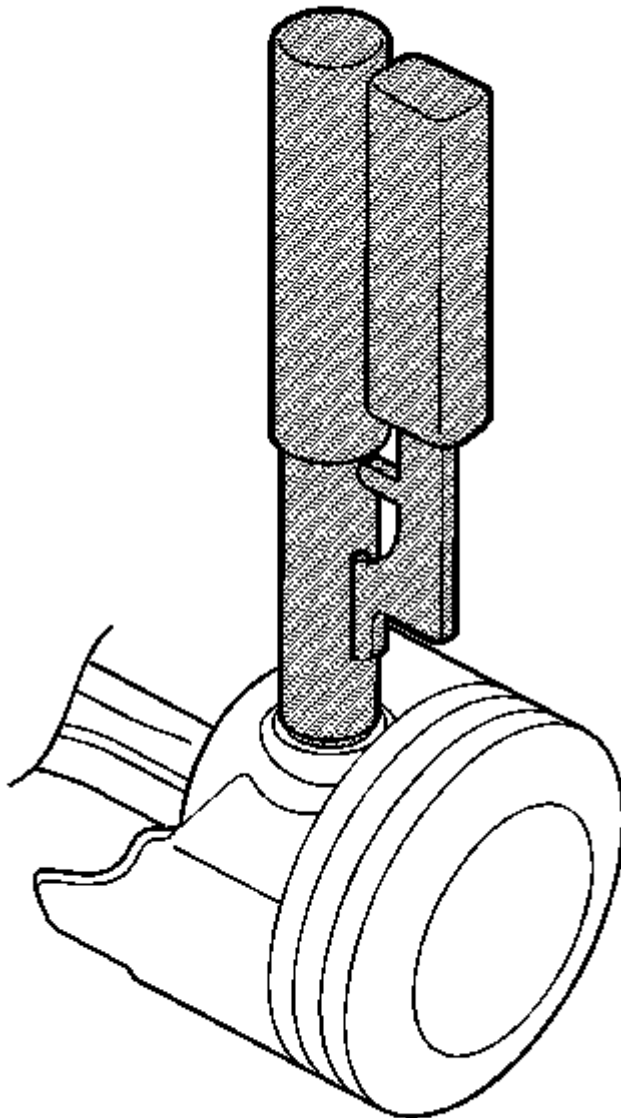


Fig. 369: Identifying Piston Pin Retainers
Courtesy of GENERAL MOTORS CORP.

NOTE: Install the piston pin retainers correctly in the retaining groove during assembly in order to avoid engine damage.

4. Use the following procedure to assemble the piston pin and the retainer:
 1. Coat the piston pin with oil.
 2. Install one side of one piston pin retainer into the retaining groove using **EN-46745** . Rotate the retainer until it is fully seated in the groove.
 3. Install the connecting rod and the piston pin.

Push the piston pin until it bottoms in the previously installed retainer.

4. Install the second piston pin retainer, using **EN-46745** .
5. Ensure that the piston moves freely.

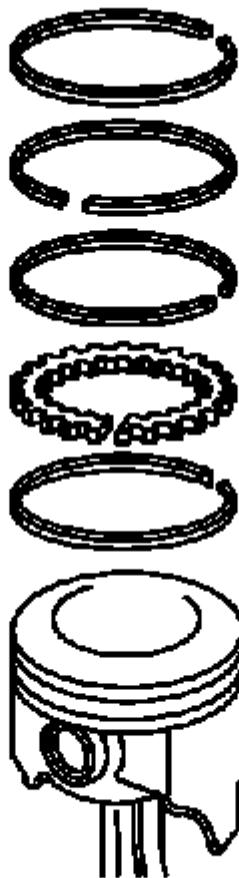


Fig. 370: Exploded View Of Piston Rings
Courtesy of GENERAL MOTORS CORP.

NOTE: Use a piston ring expander to install the piston rings. The rings may be damaged if expanded more than necessary.

5. Install the following components of the oil control ring assembly (bottom ring):
 1. The expander
 2. The lower oil control ring
 3. The upper control ring
6. Install the lower compression ring (second ring). Place the manufacturer's mark facing up.
7. Install the upper compression ring (top ring).

CAMSHAFT CLEANING AND INSPECTION

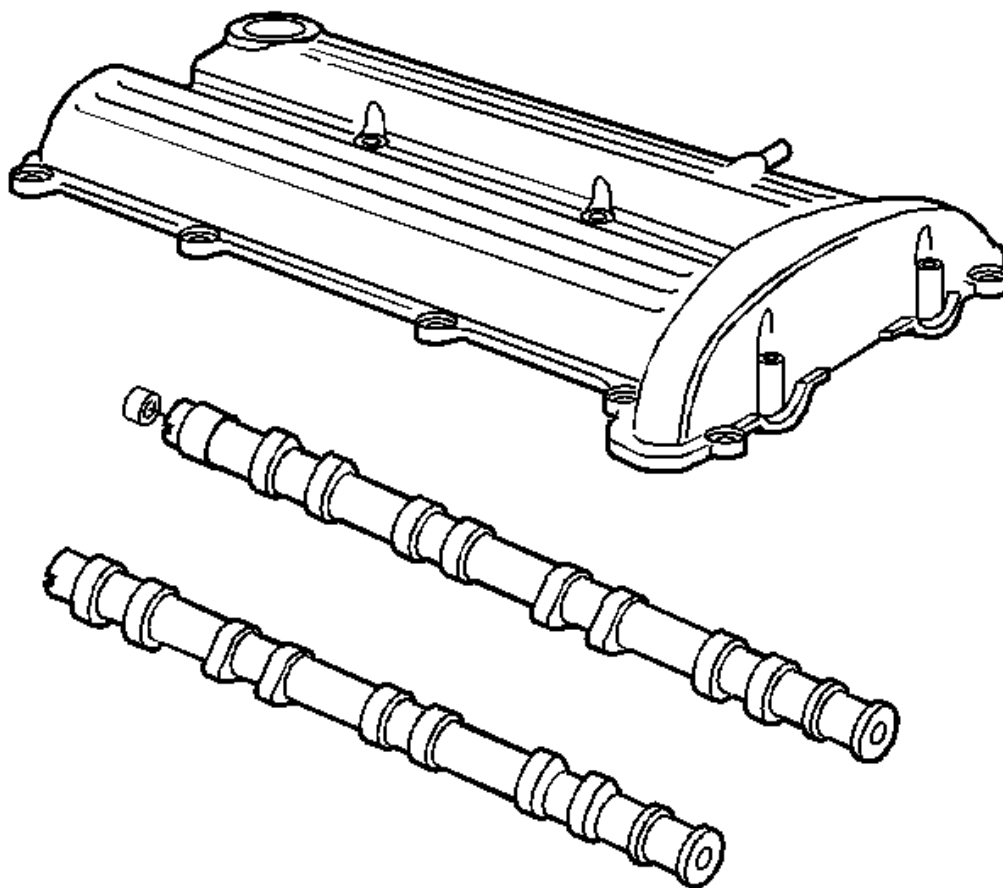


Fig. 371: View Of Camshaft Cover & Journals
Courtesy of GENERAL MOTORS CORP.

- Inspect the camshaft journals and lobes for wear or scoring.
- Inspect the camshaft sprocket alignment notch for damage.

- Inspect the camshaft cover for damage or loose oil control baffles.
- Clean the camshaft cover.
- Wash the camshaft in solvent.
- Oil the camshaft.
- Inspect the camshaft cover for cracks or other signs of damage.

CAMSHAFT TIMING CHAIN AND SPROCKET CLEANING AND INSPECTION

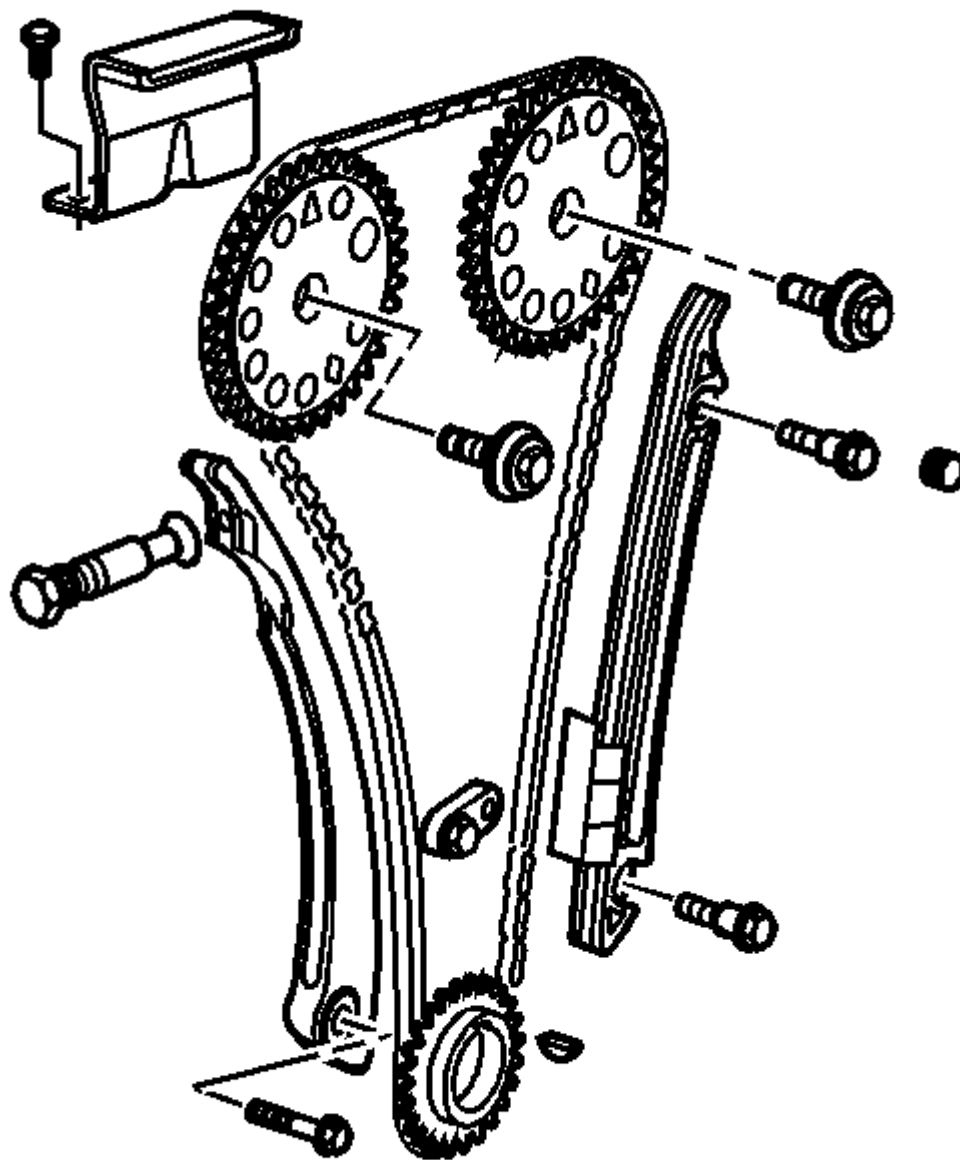


Fig. 372: Inspecting Timing Chain & Sprockets
Courtesy of GENERAL MOTORS CORP.

1. Inspect the timing chain guides for cracking or wear.
2. Replace the timing chain guides if wear exceeds 1.12 mm (0.045 in) depth on the chain guide surface.
3. Inspect the timing chain tensioner shoe for wear.

4. Replace the timing chain tensioner shoe if wear exceeds 1.12 mm (0.045 in) depth on the chain guide surface.
5. Inspect the timing chain and sprockets for wear.
6. Inspect the camshaft sprocket faces for signs of movement.
7. Inspect the camshaft sprocket teeth and chain for signs of excessive wear, chipping, or seizure of the timing chain links.
8. Inspect the oil nozzle body for collapse or cracks at the bolt boss. Discard and replace the oil nozzle body if it is damaged.
9. Remove the old oil from the timing chain tensioner.
10. Inspect the timing chain tensioner for the scoring or free movement.
11. Inspect the timing chain washer and O-ring for damage. If damaged, replace the timing chain tensioner.

BALANCE SHAFT CLEANING AND INSPECTION

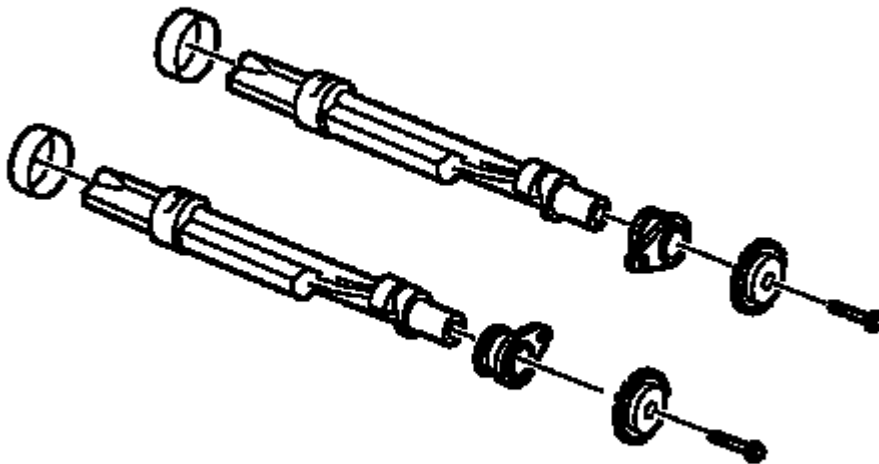


Fig. 373: Identifying Balance Shafts
Courtesy of GENERAL MOTORS CORP.

1. Clean the balance shafts in solvent.
2. Remove the balance shaft front bearing carriers from the balance shafts.
3. Inspect the bearing surfaces on the balance shafts for scoring or unusual wear.

4. Inspect the balance shaft drive sprockets for wear, damage, or missing teeth. When installing balance shaft drive sprockets tighten to 55 N.m (41 lb ft).
5. Measure the rear bearing journals on the balance shafts, the journals should be 36.723-36.743 mm (1.4458-1.4466 in) in diameter.
6. Measure the front bearing journals on the balance shafts, the front bearing journals should be 20.020-20.000 mm (0.7881-0.7874 in) in diameter.
7. When the balance shafts have been installed in the engine block, check for smooth rotation, sticking, binding, or roughness.

WATER PUMP AND BALANCE SHAFT CHAIN AND SPROCKET CLEANING AND INSPECTION

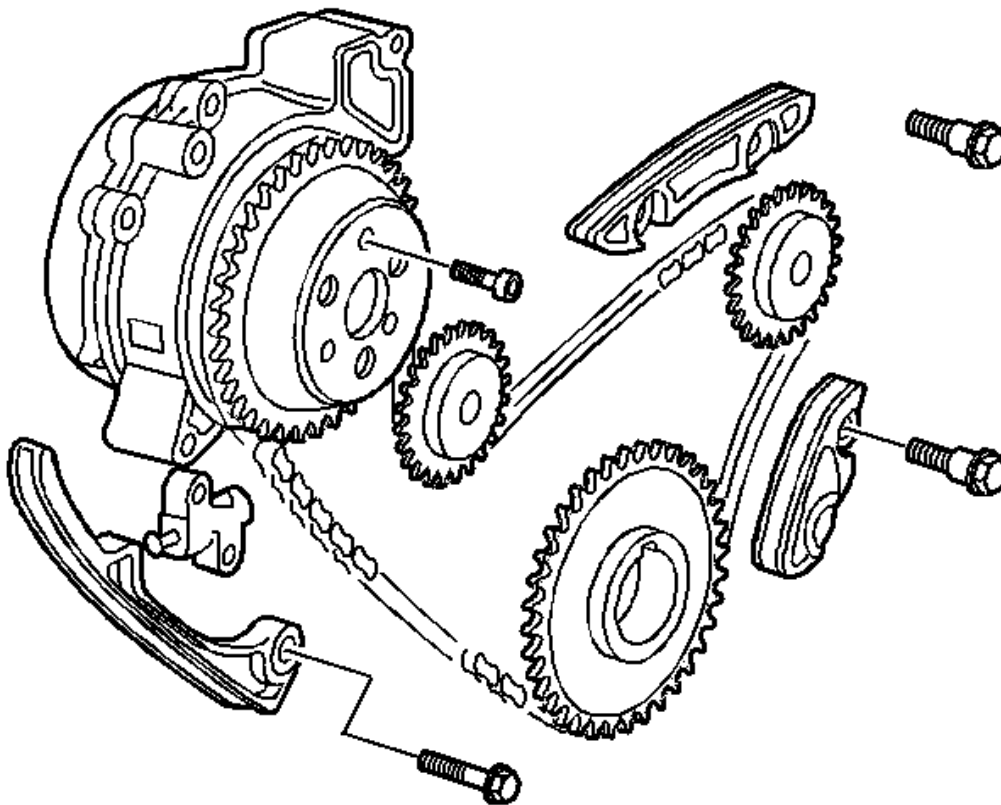


Fig. 374: Inspecting Balance Shaft Drive Chain & Sprockets
Courtesy of GENERAL MOTORS CORP.

1. Inspect the balance shaft drive chain guides for cracking or wear.
2. Replace the balance shaft drive chain guides if wear exceeds 1.12 mm (0.045 in) depth on the chain guide surface.

3. Inspect the balance shaft drive chain tensioner guide shoe for wear.

Replace the balance shaft drive chain tensioner guide shoe if wear exceeds 1.12 mm (0.045 in) depth on the chain guide surface.

4. Inspect the balance shaft drive chain and sprockets for wear.
5. Inspect the crankshaft sprocket faces for signs of movement.
6. Inspect the alignment notch in the balance shaft for cracking or damage.
7. Inspect the water pump, crankshaft, and balance shaft sprocket teeth and chain for signs of excessive wear, chipping, or seizure of the balance shaft drive chain links.
8. Inspect the timing chain tensioner for damage or wear.

CYLINDER HEAD DISASSEMBLE

Tools Required

- **J 8062** Valve Spring Compressor
- **J 36017** Valve Seal Remover
- **J 43963** Valve Spring Compressor (off car)

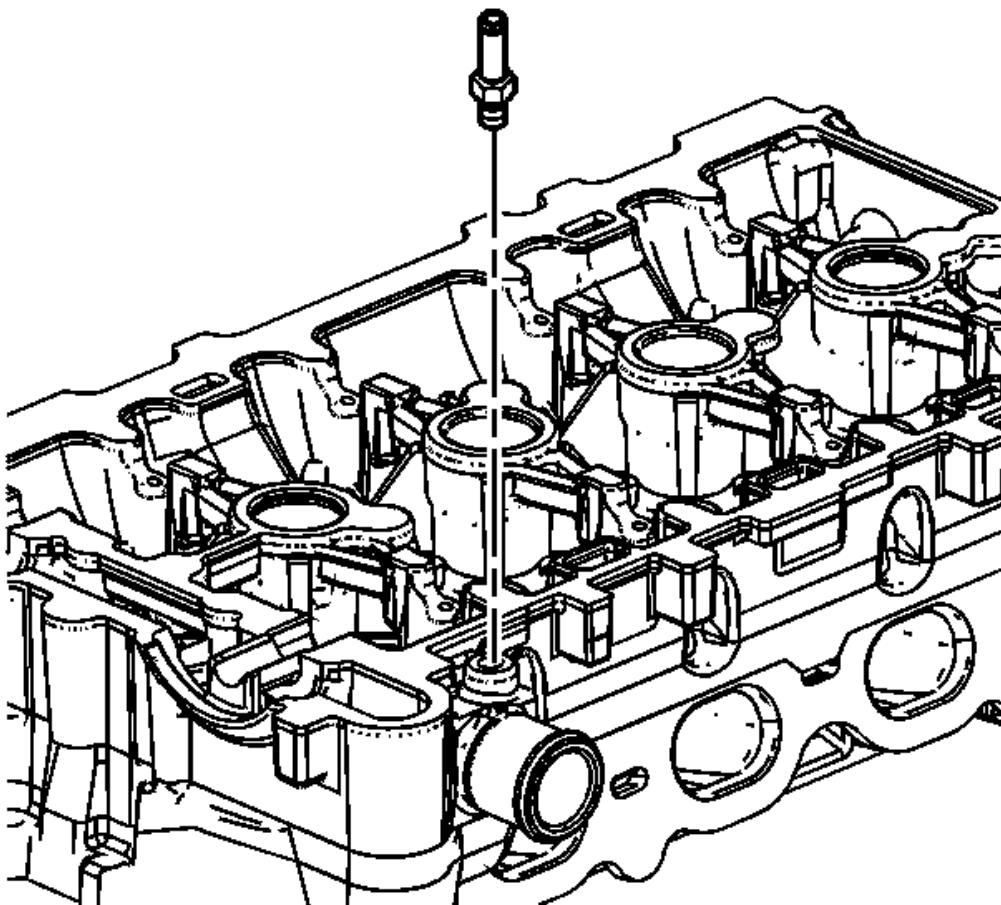


Fig. 375: Identifying Cylinder Head Air Bleed Tube
Courtesy of GENERAL MOTORS CORP.

1. Remove the coolant air bleed hose fitting.

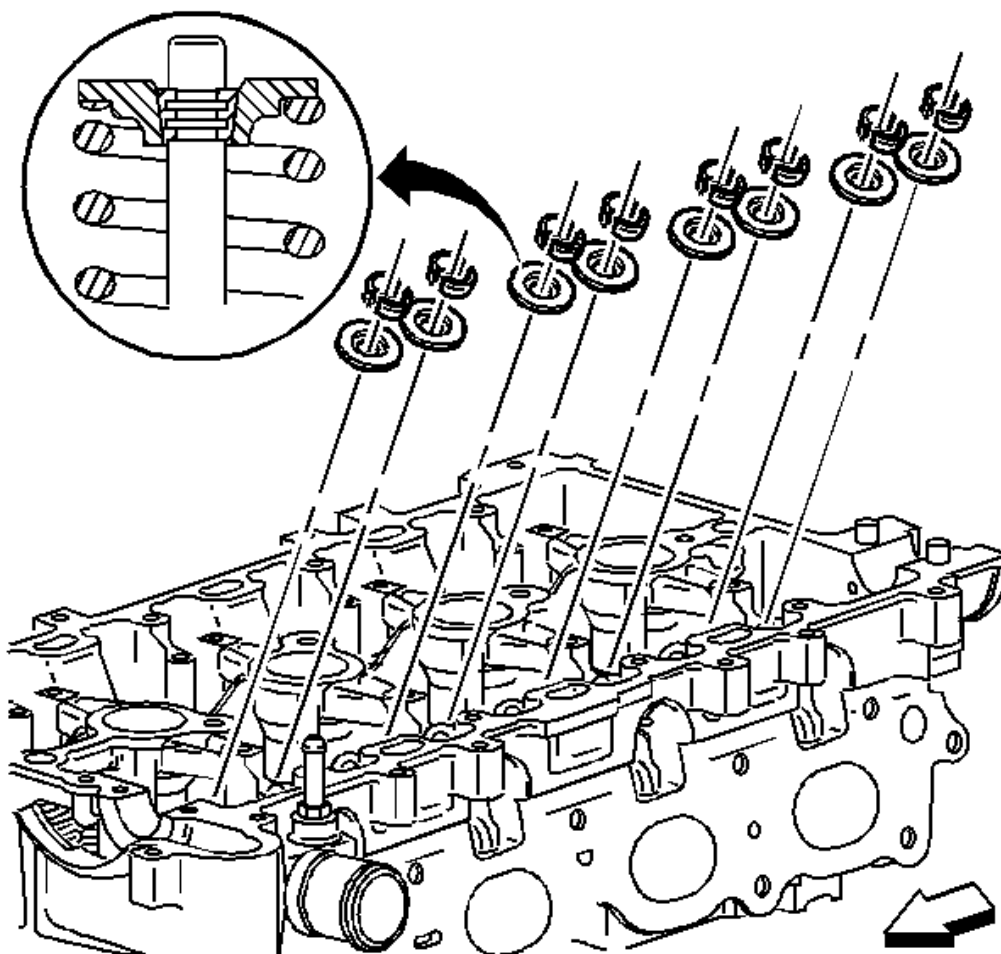


Fig. 376: Identifying Valve Spring Retainers

Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Ensure that the valve train components are kept together and identified in order for proper re-installation in their original position.

2. Using the **J 8062** and the **J 43963** , compress the valve spring.
3. Remove the valve keys.
4. Slowly release the **J 8062** and the **J 43963** from the valve spring assembly.
5. Remove the retainer.

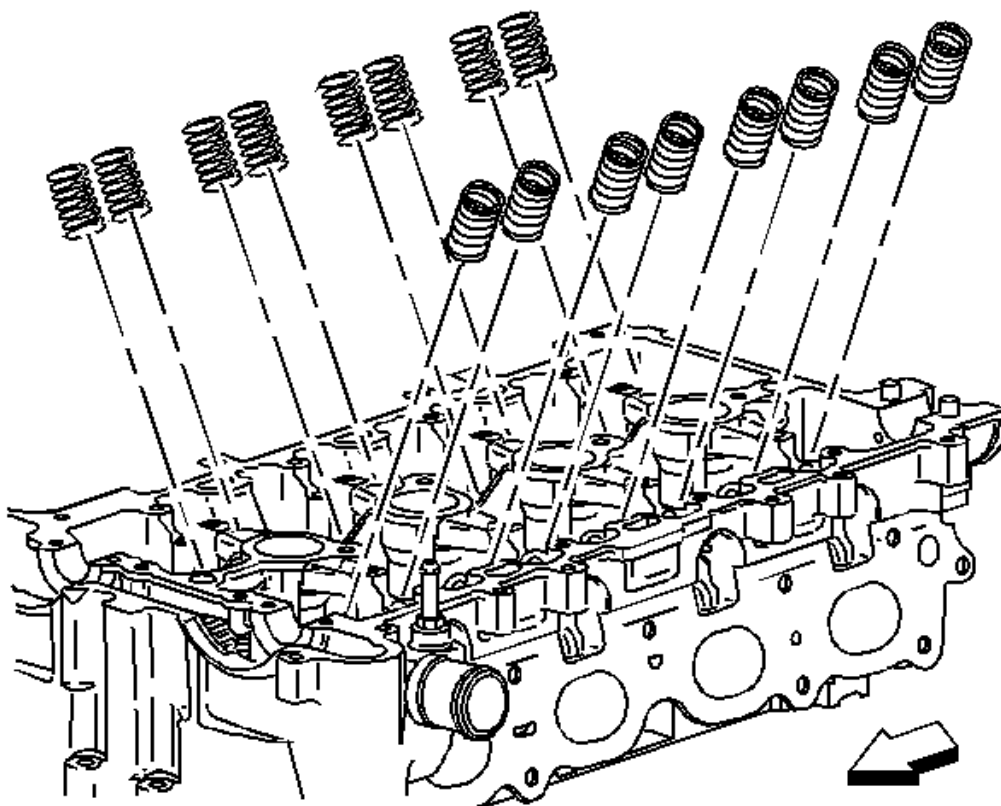


Fig. 377: View Of Valve Springs
Courtesy of GENERAL MOTORS CORP.

6. Remove the spring.

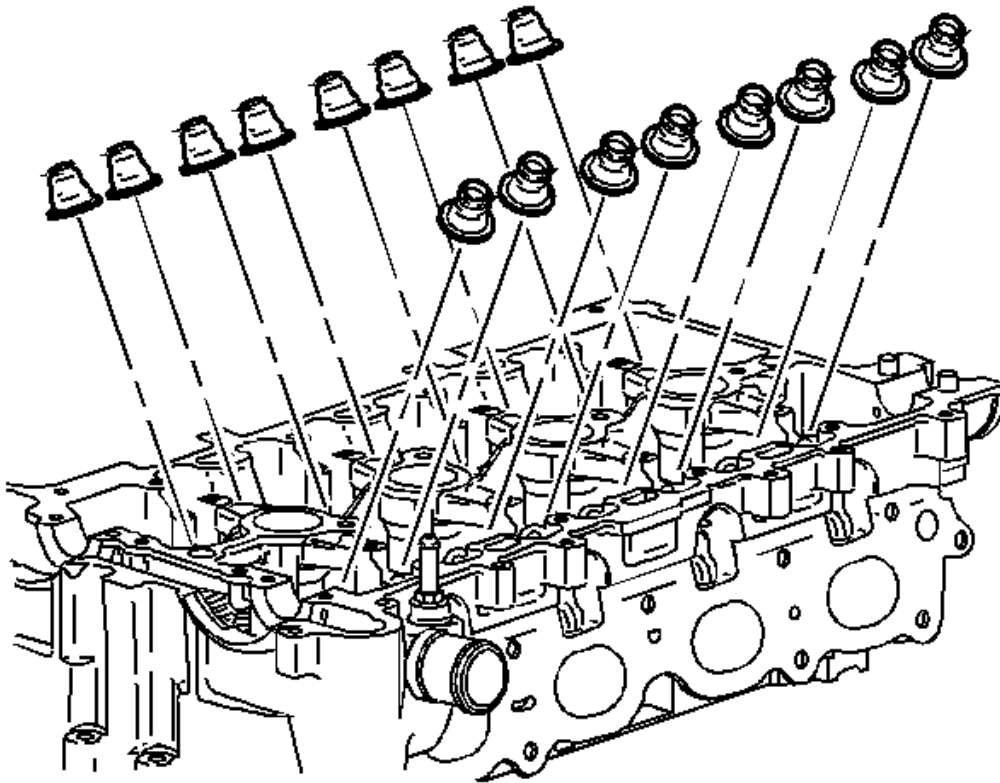


Fig. 378: View Of Valve Seals

Courtesy of GENERAL MOTORS CORP.

NOTE: Do not damage the valve guide. Remove any burrs that have formed at the key groove by chamfering the valve stem with an oil stone or a file.

7. Remove the valve seal. Use the **J 36017** . Do not reuse.

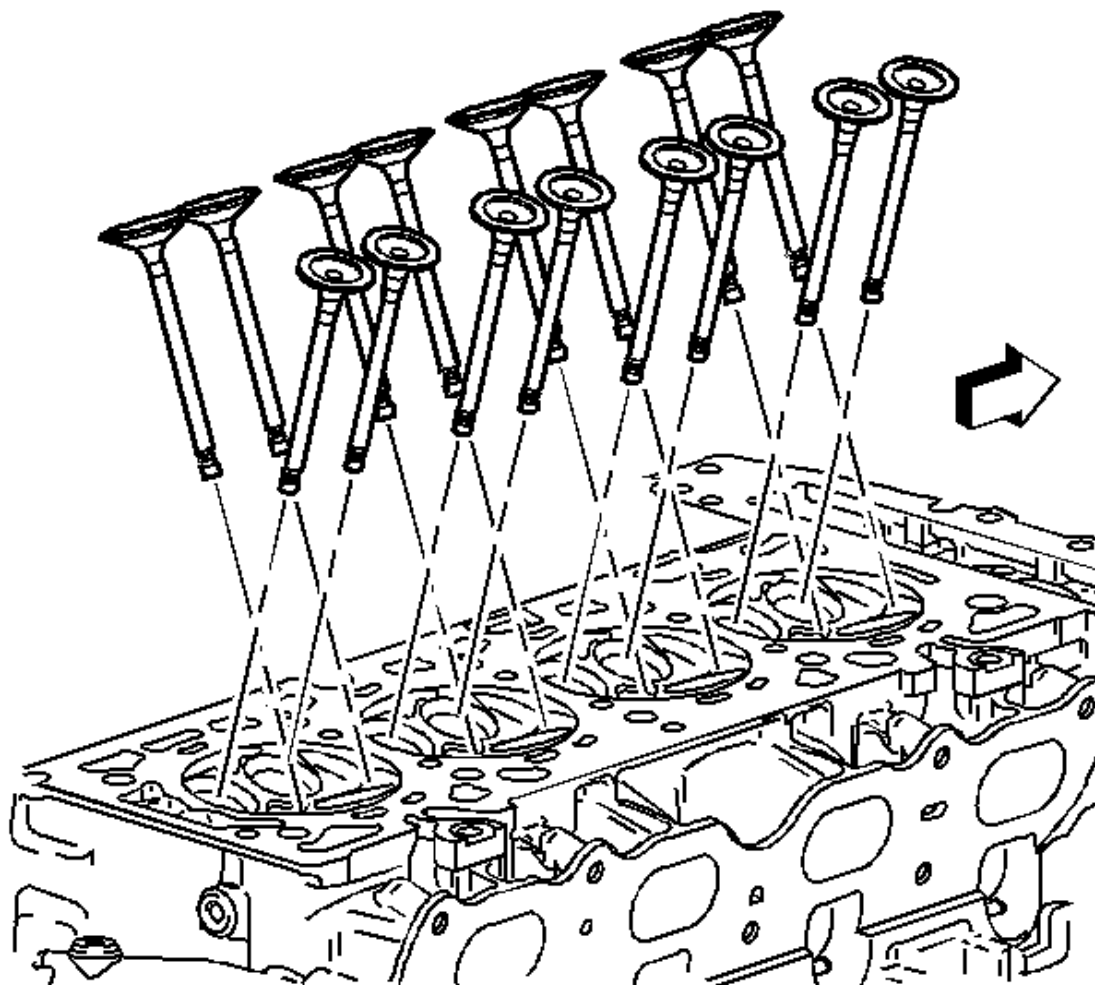


Fig. 379: Identifying Engine Valves

Courtesy of GENERAL MOTORS CORP.

8. Remove the valve.
9. Remove the remaining valves.

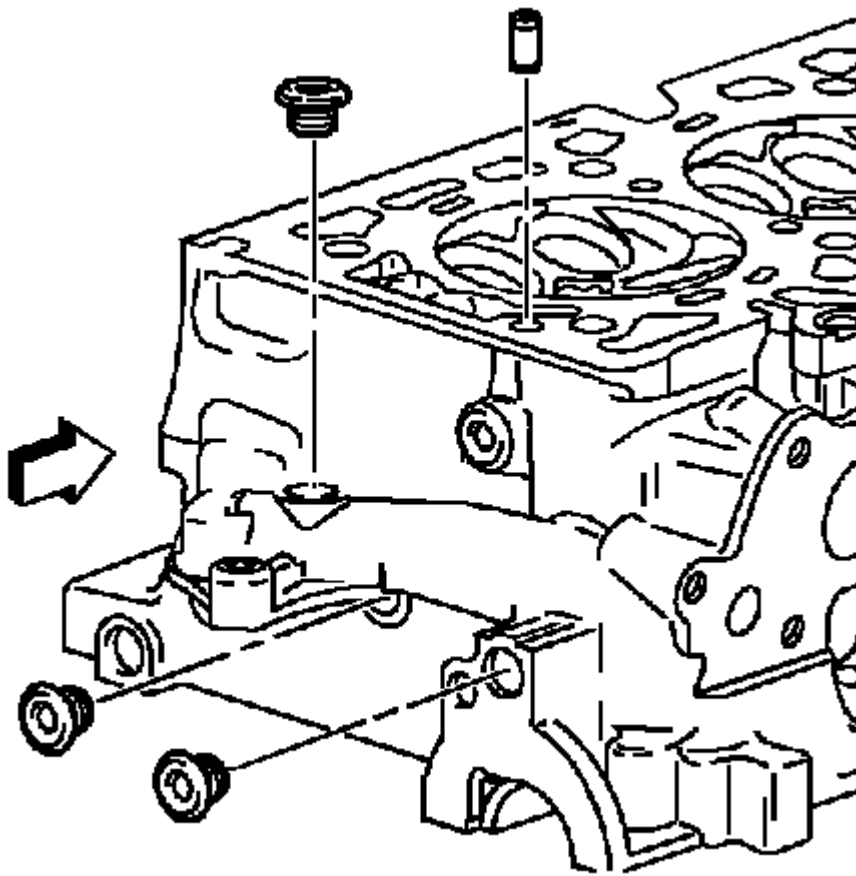


Fig. 380: View Of Cylinder Head Plugs
Courtesy of GENERAL MOTORS CORP.

10. Remove the cylinder head plugs.

CYLINDER HEAD CLEANING AND INSPECTION

Valve Cleaning and Inspection

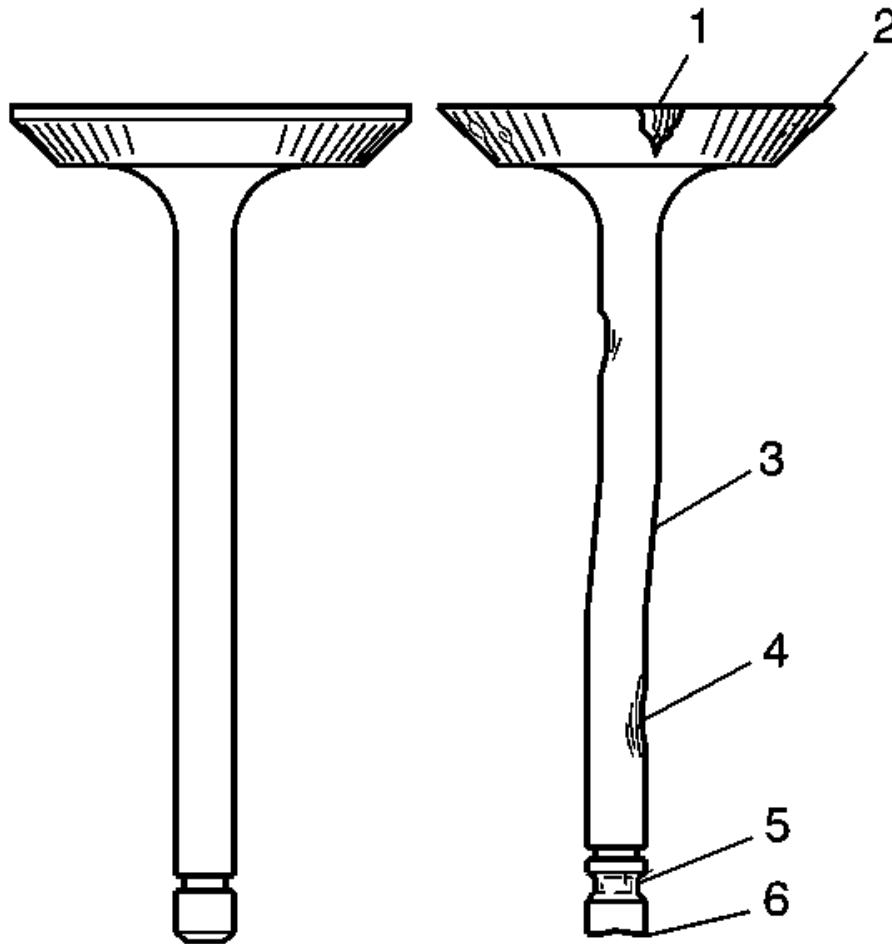


Fig. 381: Identifying Inspection Points For Valves Damage
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not scratch the valve stem with the wire brush.

1. Clean the valves of carbon, oil and varnish. Carbon can be removed with a wire brush. Varnish can be removed by soaking in Parts Immersion Solvent GM P/N 12345368 (Canadian P/N 10953514) or equivalent.
2. Clean the valve guides.
3. Inspect the valve stem for wear (4).
4. Inspect the valve key groove for chipping or wear (5). Replace the valve if chipped or worn.
5. Inspect the valve face for burning or cracking (1). If pieces are broken off, inspect the corresponding piston and cylinder head area for damage.
6. Inspect the valve stem for burrs and scratches. Burrs and minor scratches may be removed with an oil stone.
7. Inspect the valve stem for straightness and the valve head for bending or distortion (3) using V blocks.

Bent or distorted valves must be replaced.

8. Clean the deposits from the valve face. Inspect the valve face for grooving.
9. Replace the valve if the face is grooved. Valve faces cannot be machined. If worn, or damaged, the valves must be replaced.
10. The valves may be lightly lapped to the valve seats.

Cylinder Head and Gasket Surface Cleaning and Inspection

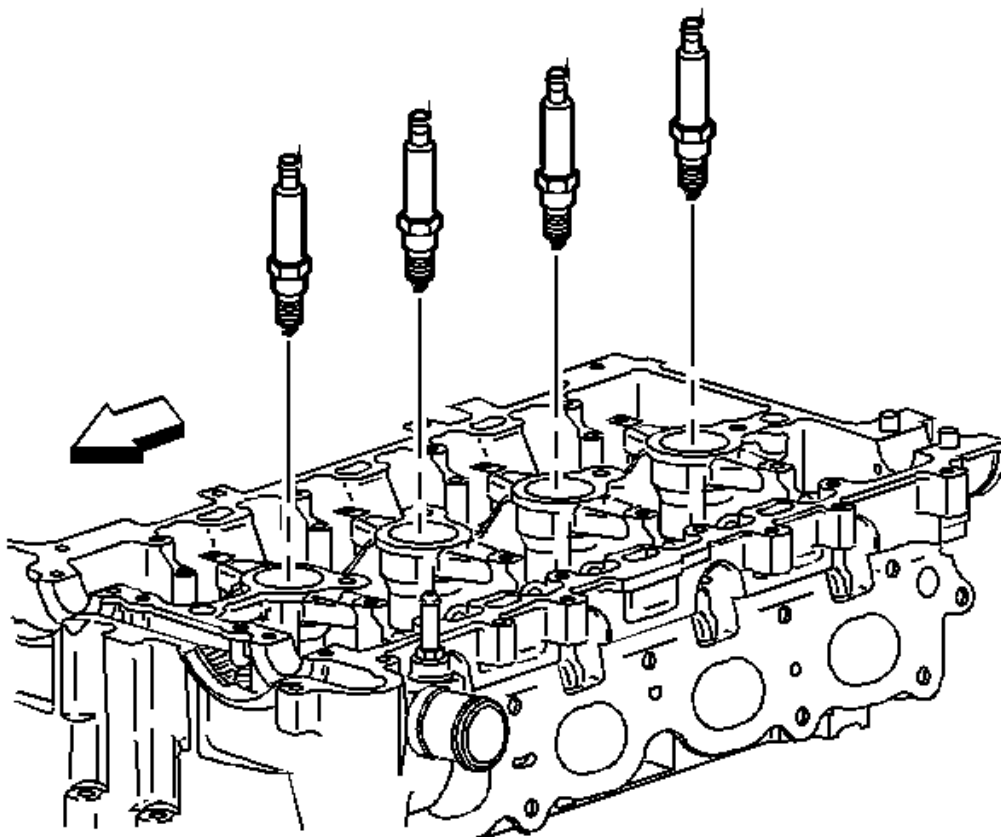


Fig. 382: View Of Spark Plugs
Courtesy of GENERAL MOTORS CORP.

1. Remove the spark plugs.
2. Inspect the cylinder head gasket and mating surfaces for leaks, corrosion and blow-by. If the gasket has failed, use the following faults to determine the cause:
 1. Improper installation
 2. Loose or warped cylinder head

3. Missing, off location or not fully seated dowel pins
4. Corrosion in the seal area around the coolant passages
5. Chips or debris in the cylinder head bolt holes
6. Bolt holes in the cylinder block not drilled or tapped deep enough

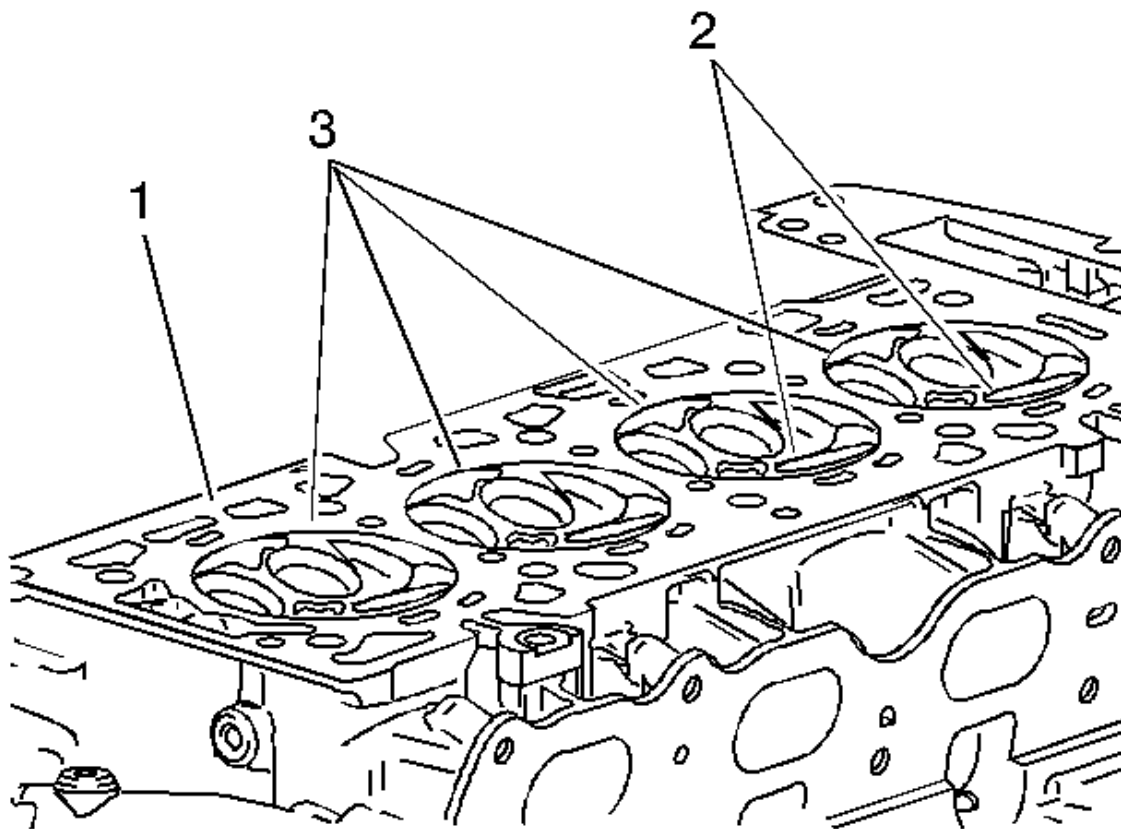


Fig. 383: Cylinder Head Inspection Areas
Courtesy of GENERAL MOTORS CORP.

3. Inspect the cylinder head gasket surface.
 - Cylinder head may be reused if corrosion is found only outside a 4 mm (0.375 in) band around each combustion chamber (1).
 - Replace the cylinder head if the area between the valve seats is cracked (2).
 - Replace the cylinder head if corrosion has been found inside a 4 mm (0.375 in) band around each combustion chamber (3).

4. Clean the cylinder head bolts.

IMPORTANT: Do not use a wire brush on any gasket sealing surface.

5. Clean the cylinder head. Remove all varnish, soot and carbon to the bare metal.
6. Clean the valve guides.
7. Clean the threaded holes. Use a nylon bristle brush.
8. Clean the remains of the sealer from the plug holes.
9. Inspect the cylinder head bolts for damaged threads or stretching and damaged heads caused by improper use of tools.
10. Replace all suspect bolts.
11. Inspect the cylinder head for cracks. Check between the valve seats and in the exhaust ports.

IMPORTANT: Do not attempt to weld the cylinder head, replace it.

12. Inspect the cylinder head deck for corrosion, sand inclusions and blow holes.

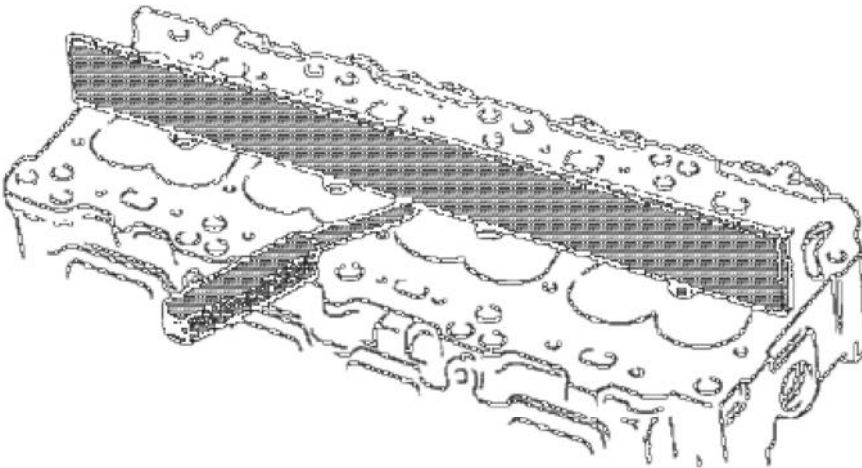


Fig. 384: Inspecting Cylinder Head Surfaces For Flatness
Courtesy of GENERAL MOTORS CORP.

13. Inspect the cylinder head deck surface for flatness. Refer to **Engine Mechanical Specifications**. If the cylinder head is out of specification, replace it. Do not machine the cylinder head.
14. Inspect all the threaded holes for damage. Threads may be reconditioned with thread inserts.
15. Inspect the sealing surfaces.

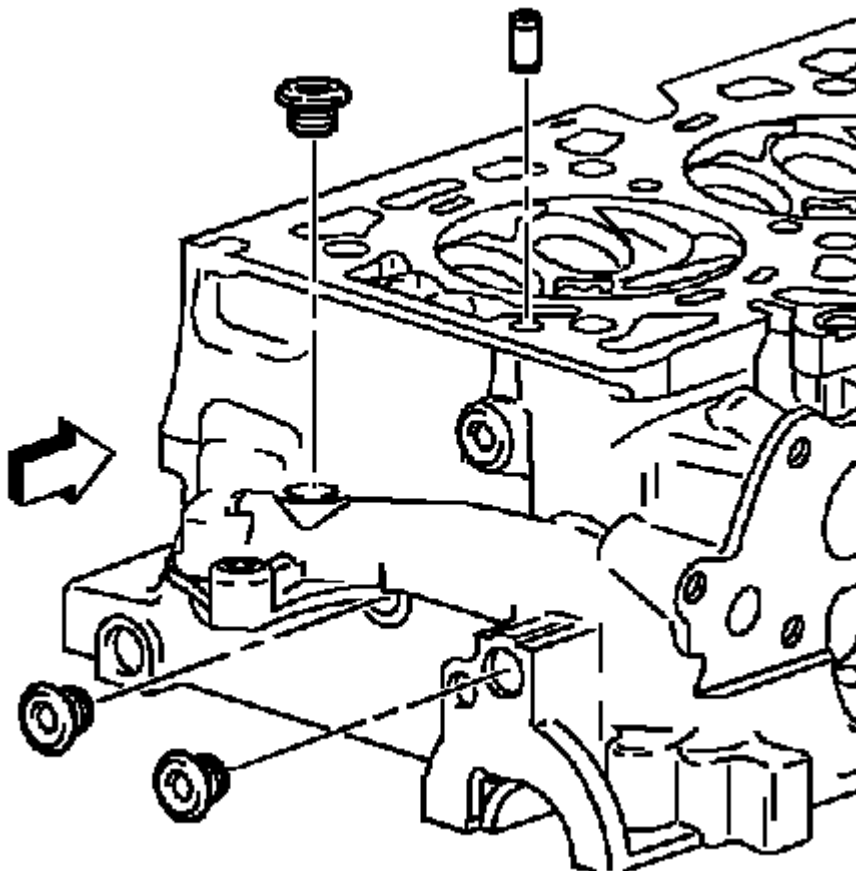


Fig. 385: View Of Cylinder Head Plugs
Courtesy of GENERAL MOTORS CORP.

16. Inspect the cylinder head plugs.

CYLINDER HEAD ASSEMBLE

Tools Required

- **J 8062** Valve Spring Compressor
- **J 9666** Valve Spring Tester
- **J 43963** Valve Spring Compressor (off car)

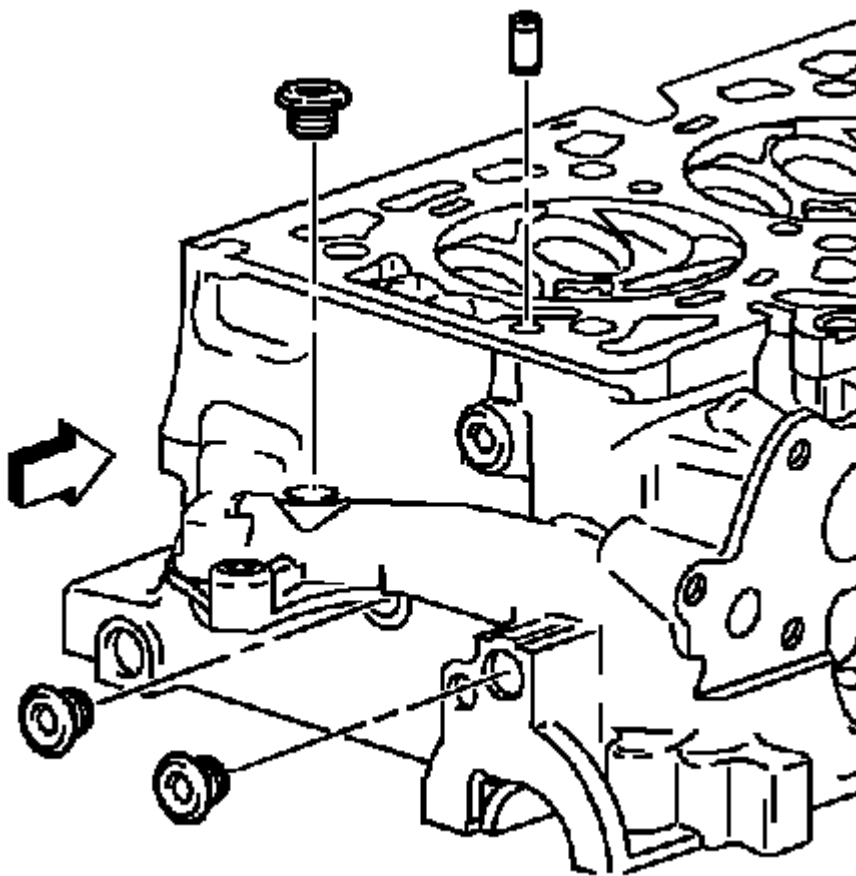


Fig. 386: View Of Cylinder Head Plugs
Courtesy of GENERAL MOTORS CORP.

NOTE: In order to avoid damage, install the spark plugs after the cylinder head has been installed on the engine.

1. Install NEW cylinder head plugs. Coat the plugs with sealer GM P/N 12345382 (Canadian P/N 10953489) or equivalent.
2. Inspect the valve springs for the following conditions:
 - Expanded height
 - Unparallel spring ends
 - Spring tension using **J 9666**
 - Any distorted springs should be replaced

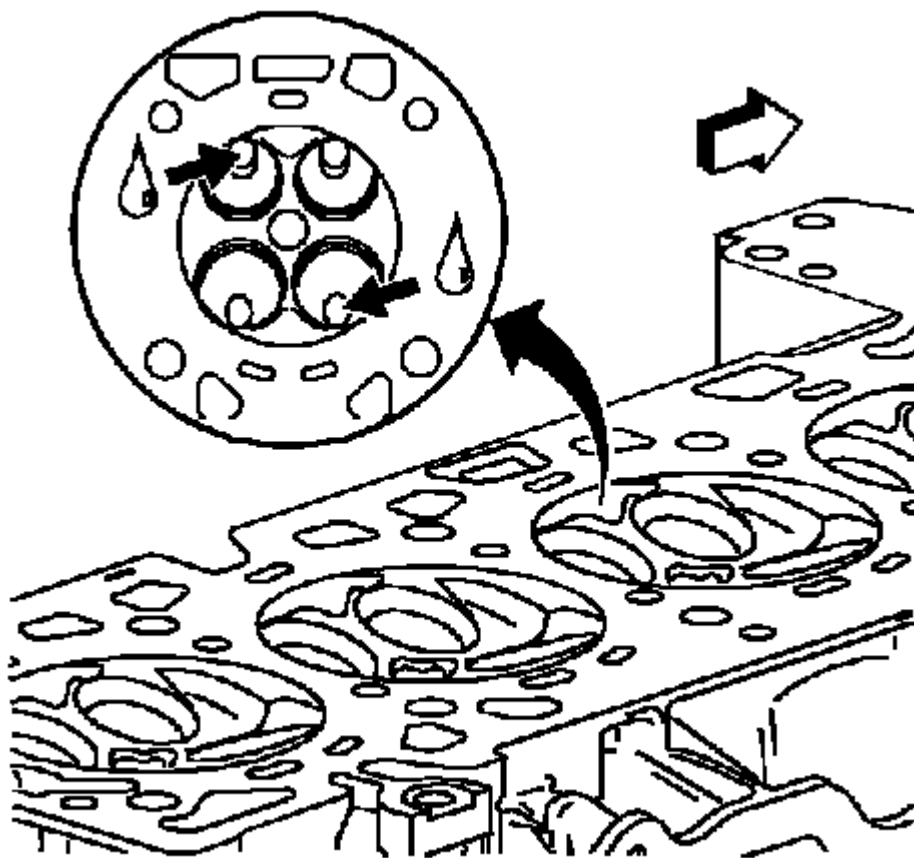


Fig. 387: Applying Prussian Blue To Valve Seat & Face
Courtesy of GENERAL MOTORS CORP.

3. Assemble the valves.
4. Use the following steps to measure valve runout:
 1. Apply a dab of Prussian blue on the entire valve face. Seat the valve but do not rotate it. The Prussian blue traces transferred to the valve seat are an indication of concentricity of the valve seat.
 2. Clean all traces of Prussian blue.
 3. Apply a dab of Prussian blue on the valve seat and repeat the check. The traces of Prussian blue transferred to the valve face indicates valve face concentricity.

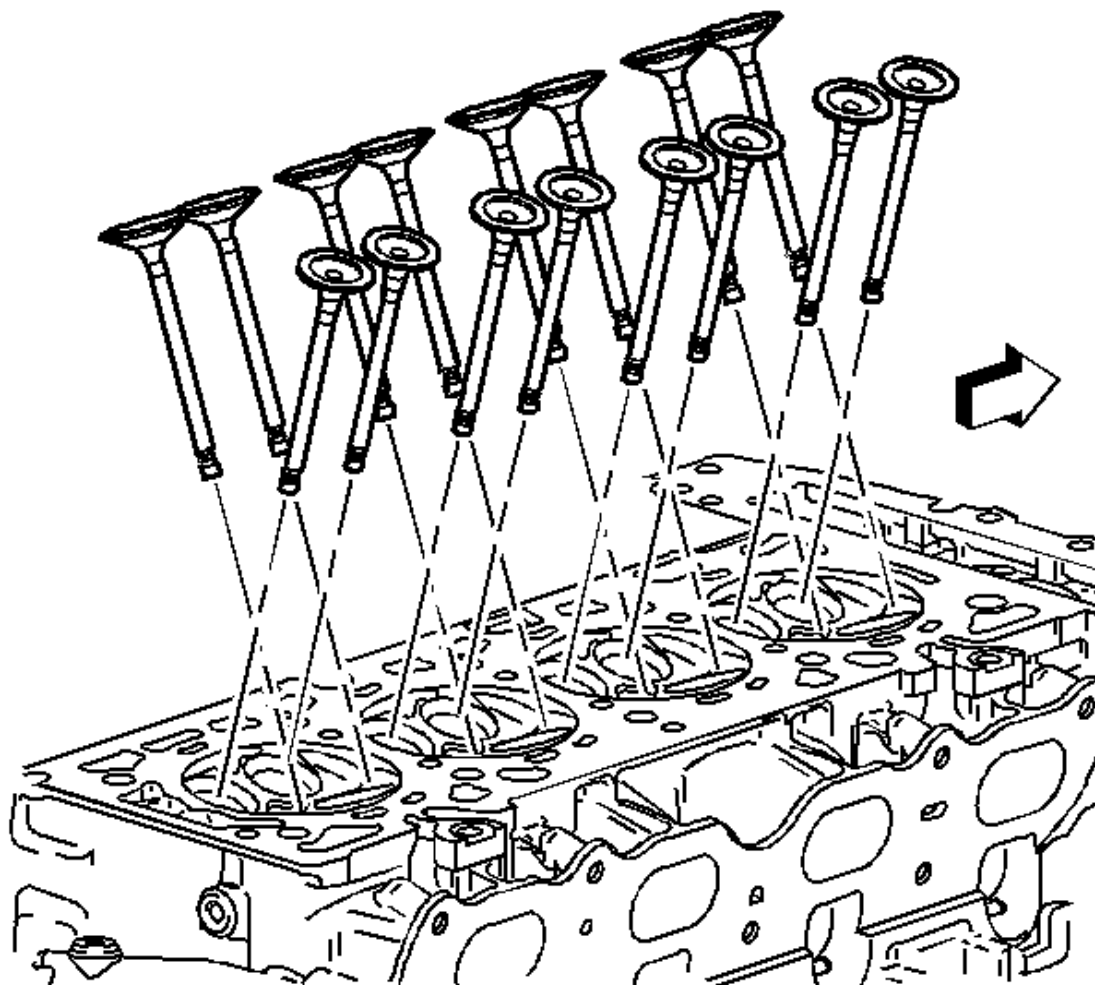


Fig. 388: Identifying Engine Valves
Courtesy of GENERAL MOTORS CORP.

5. Replace the valves, if required.

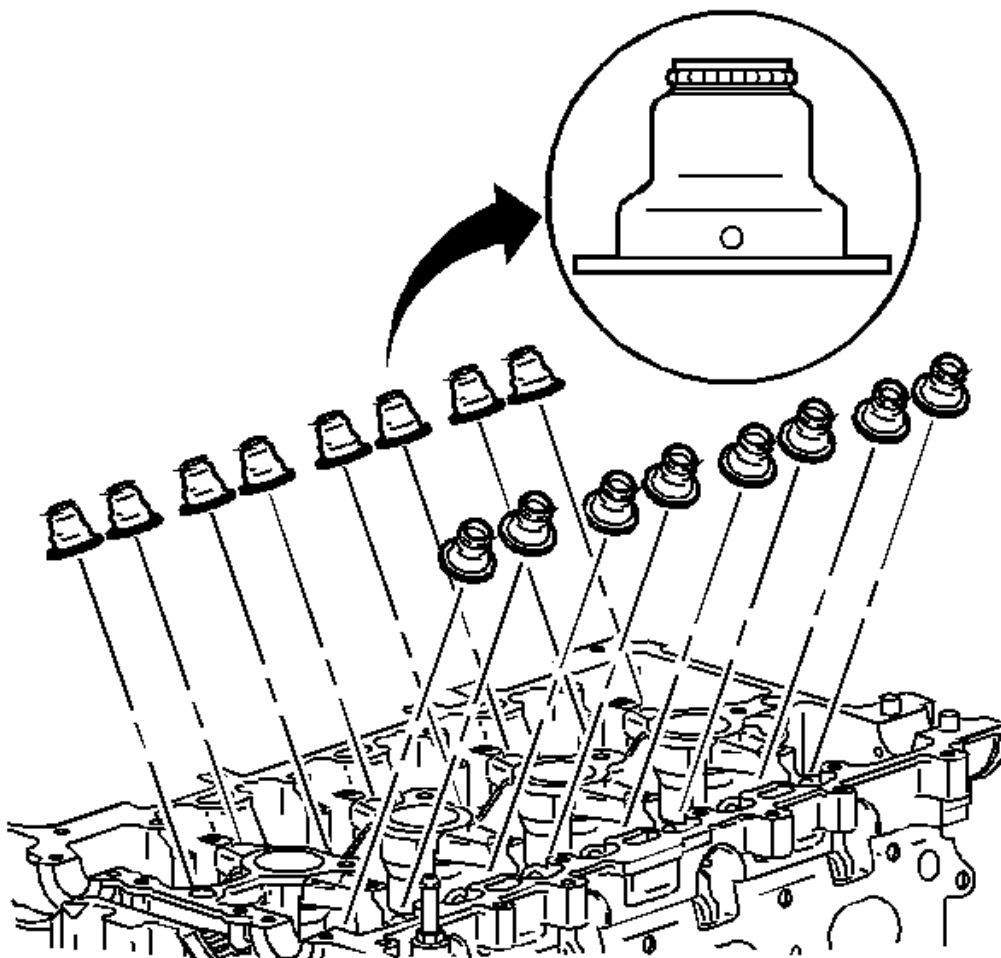


Fig. 389: Installing Valve Seals

Courtesy of GENERAL MOTORS CORP.

6. Install the new valve seals. Fully seat the seals on the valve guides.

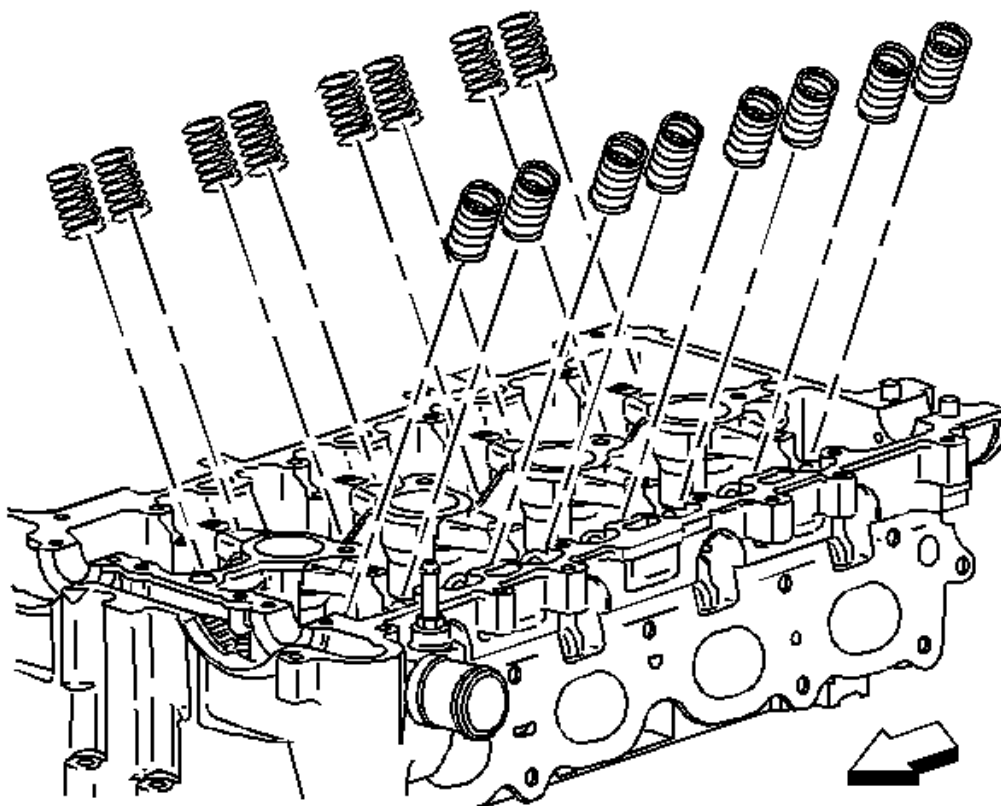


Fig. 390: View Of Valve Springs
Courtesy of GENERAL MOTORS CORP.

7. Install the spring.

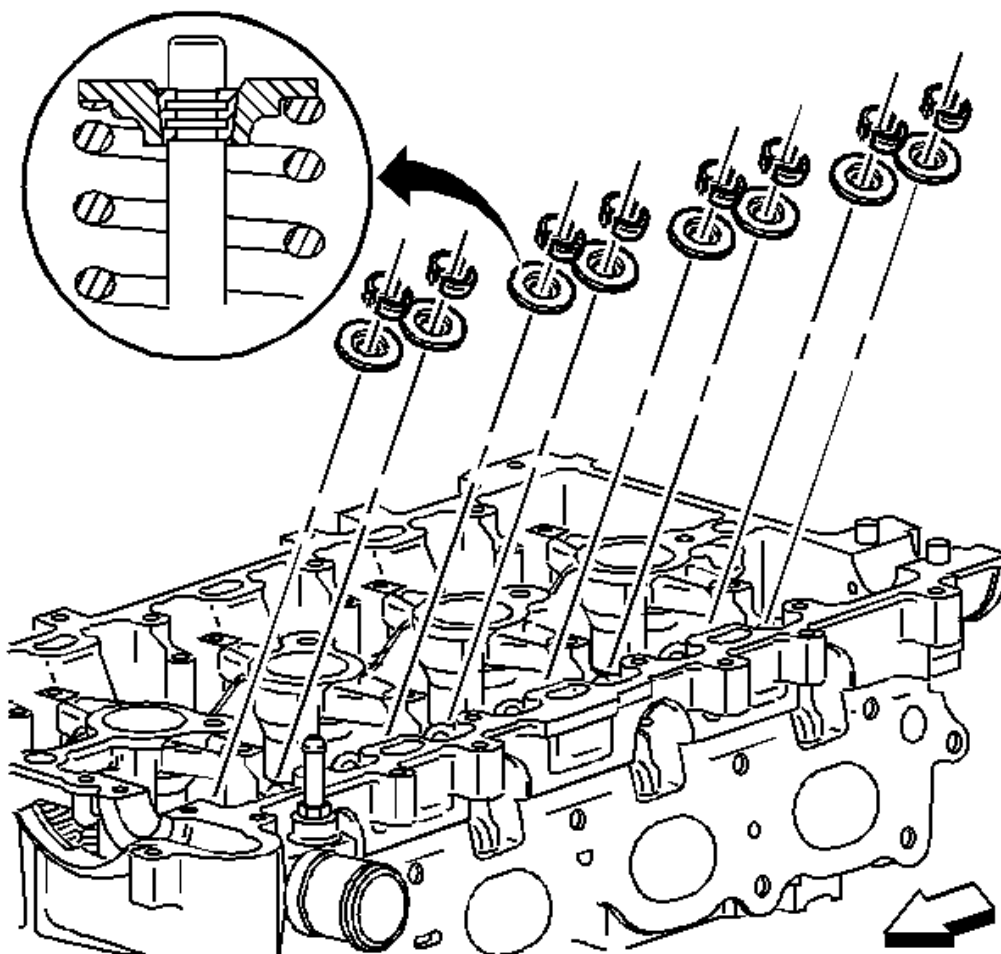


Fig. 391: Identifying Valve Spring Retainers

Courtesy of GENERAL MOTORS CORP.

8. Install the retainer.
9. Using the **J 8062** and the **J 43963** , compress the valve spring.
10. Install the valve keys.
11. Slowly release the **J 8062** and the **J 43963** from the valve/spring assembly.
12. Inspect for proper valve key seating.
13. Install the remaining valves, springs, and other components.

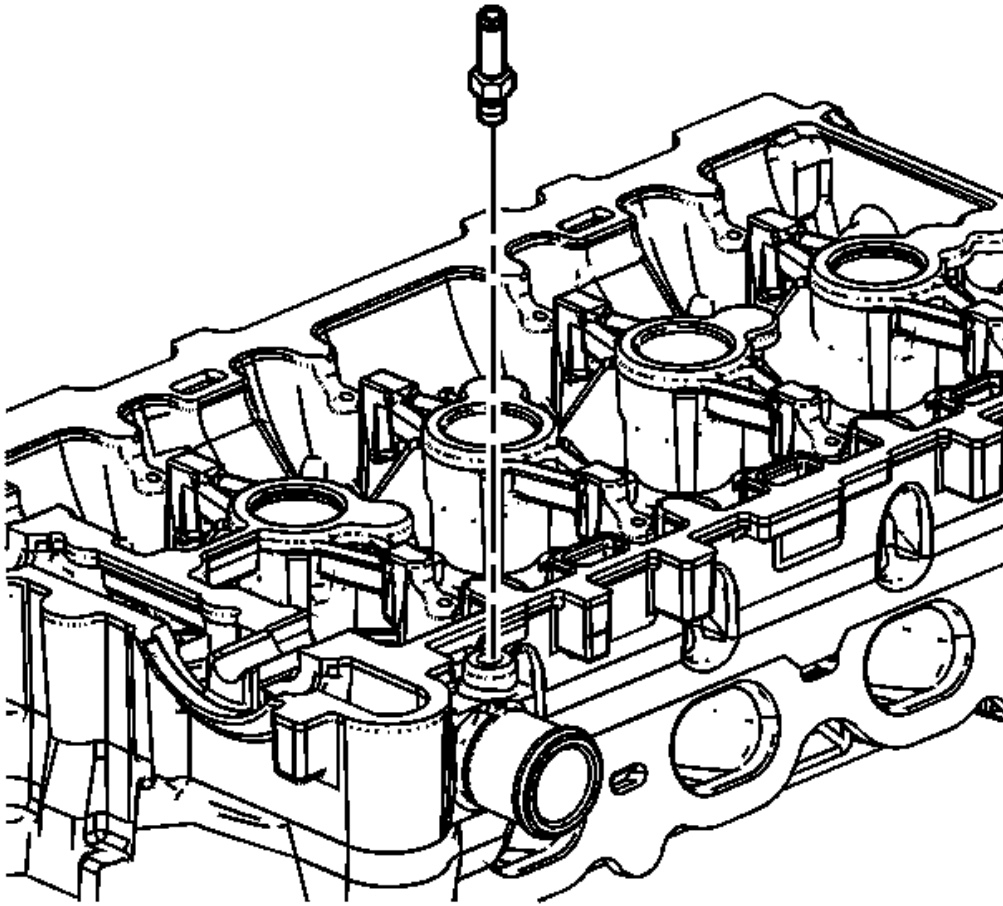


Fig. 392: Identifying Cylinder Head Air Bleed Tube
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

14. Install the cylinder head air bleed tube.

Tighten: Tighten the tube to 15 N.m (133 lb in).

OIL PUMP DISASSEMBLE

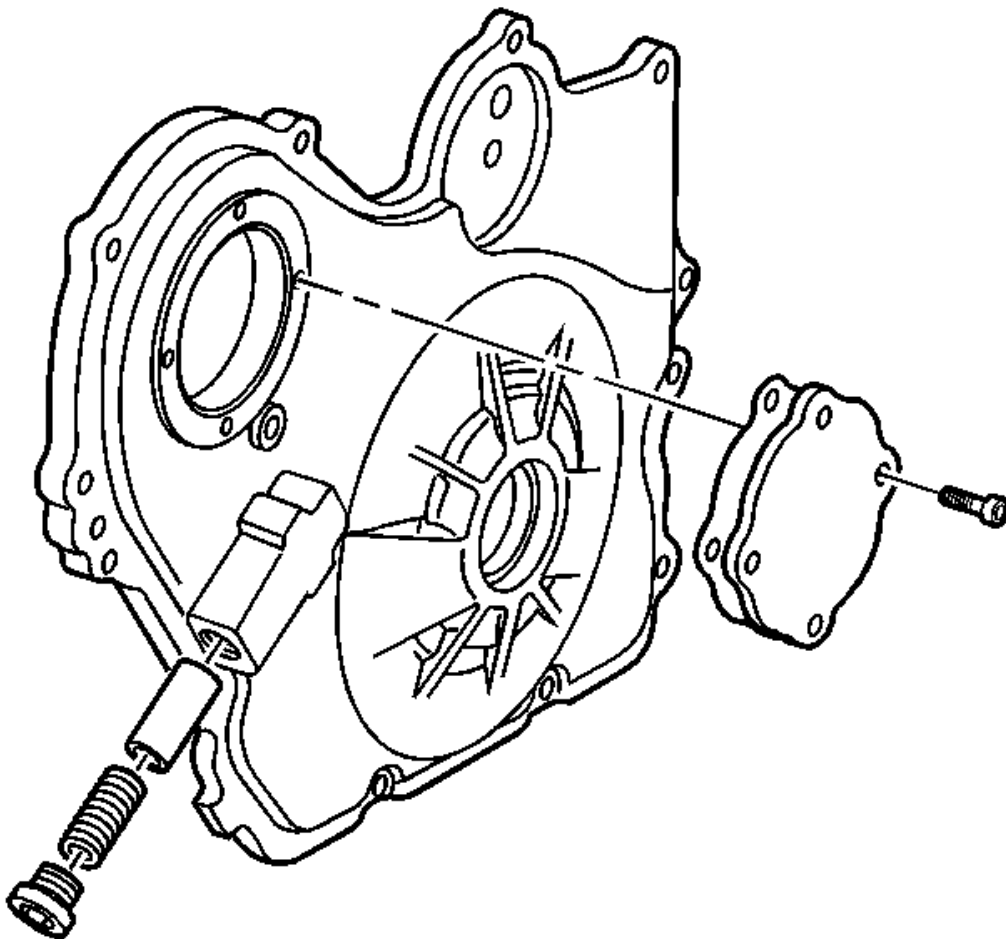


Fig. 393: View Of Pressure Relief Valve
Courtesy of GENERAL MOTORS CORP.

1. Disassemble the pressure relief valve.

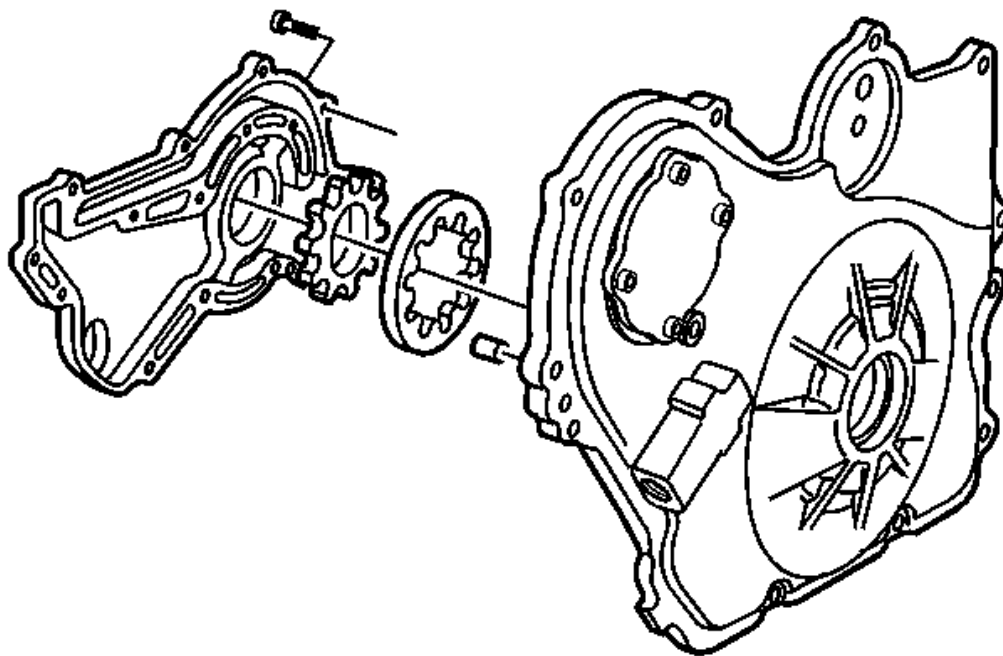


Fig. 394: Exploded View Of Oil Pump Assembly
Courtesy of GENERAL MOTORS CORP.

2. Remove the oil pump gerotor cover and bolts.
3. Clean all of the parts in cleaning solvent. Remove varnish, sludge and dirt.
4. Inspect the oil pump for wear and scoring. Insure that all components are within specifications. Refer to **Engine Mechanical Specifications**.

Replace the front cover and oil pump assembly if it is out of specification or damaged.

OIL PUMP ASSEMBLE

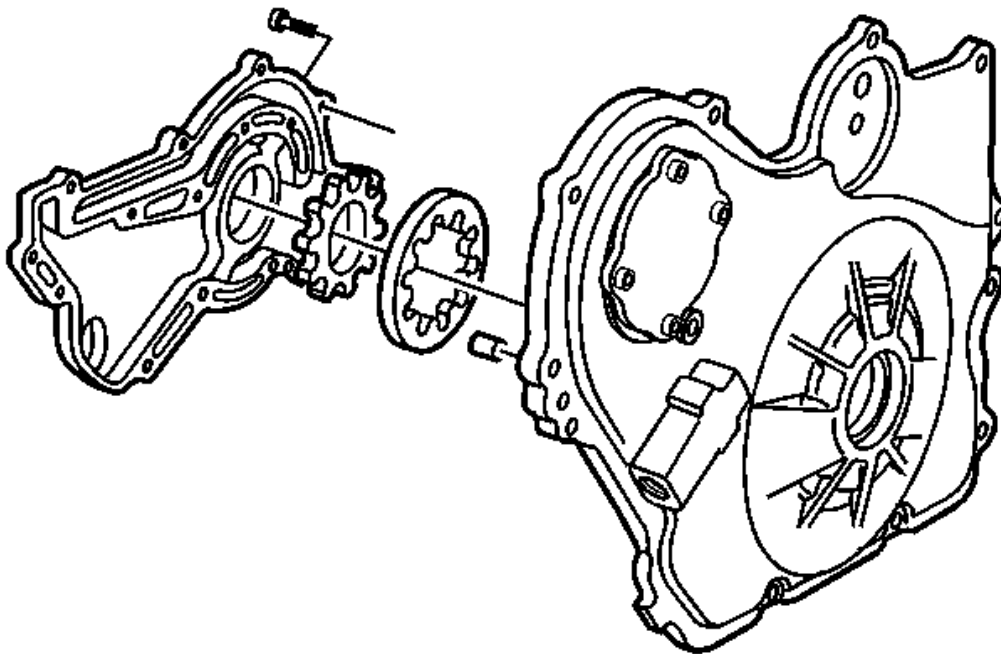


Fig. 395: Exploded View Of Oil Pump Assembly
Courtesy of GENERAL MOTORS CORP.

1. Lubricate all oil pump parts with engine oil.
2. Install the inner gear into the outer gear.

IMPORTANT: If gears are improperly installed in the front cover, the gerotor cover will not bolt on.

3. Install the gears together into the front cover with the hub of the center gear facing the front cover.

NOTE: Refer to Fastener Notice .

4. Install the oil pump gerotor cover and bolts.

Tighten: Tighten the oil pump gerotor bolts to 6 N.m (53 lb in).

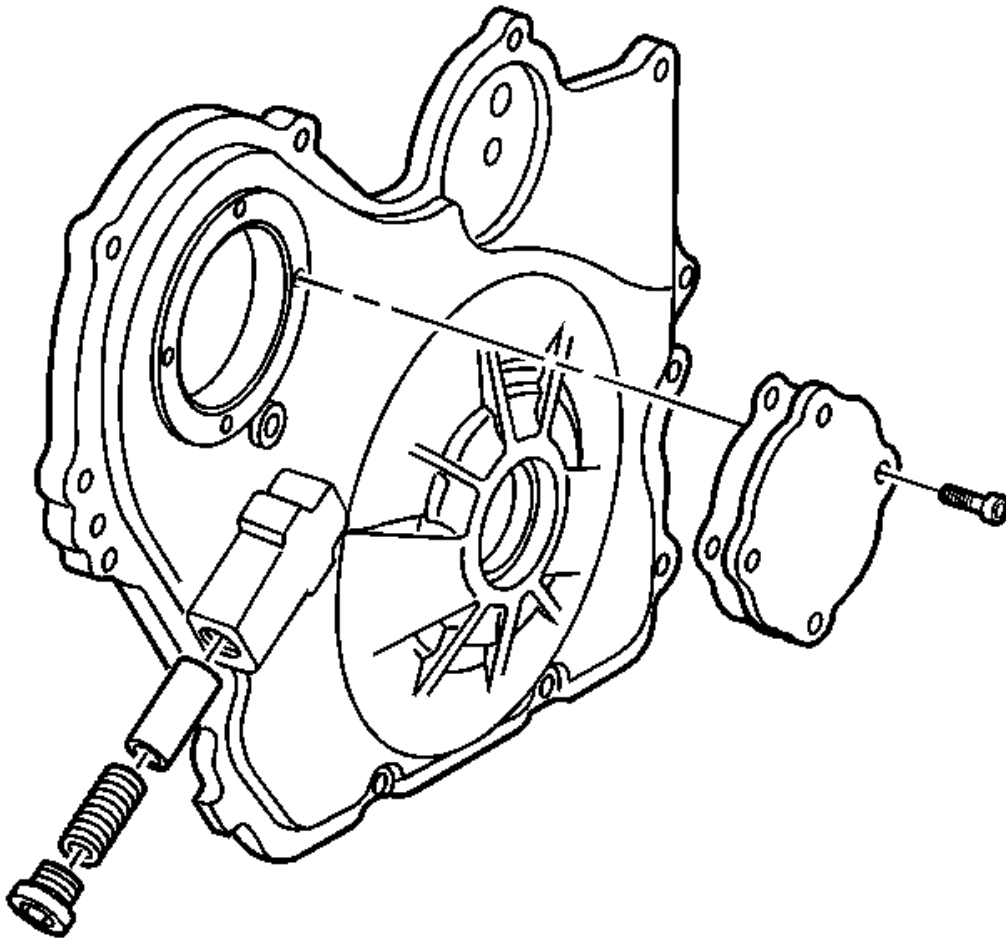


Fig. 396: View Of Pressure Relief Valve
Courtesy of GENERAL MOTORS CORP.

5. Install the pressure relief valve piston.
6. Install the pressure relief valve spring.

Tighten: Tighten the pressure relief valve plug to 40 N.m (30 lb ft).

INTAKE MANIFOLD CLEANING AND INSPECTION

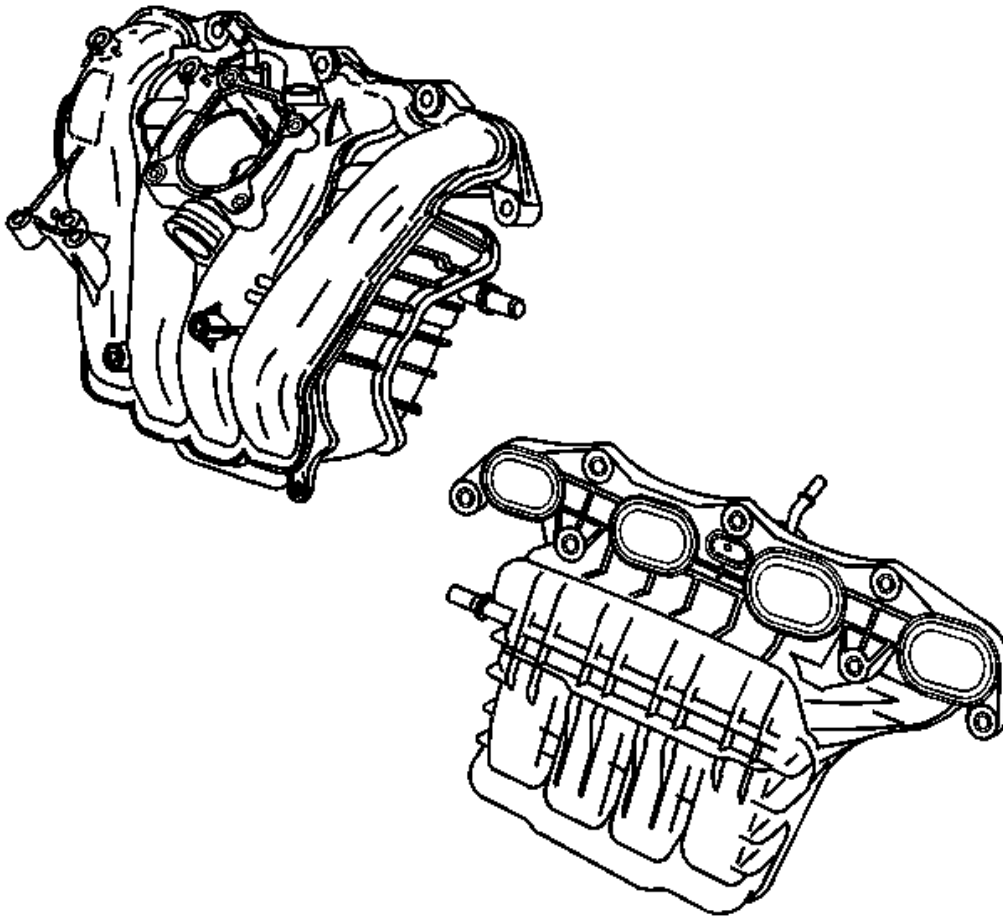


Fig. 397: Inspecting Intake Manifold
Courtesy of GENERAL MOTORS CORP.

1. Clean the intake manifold mating surfaces.
2. Inspect the intake manifold for damage.
3. Inspect the intake manifold for cracks near metallic inserts.
4. Inspect the crankcase ventilation passages in the intake manifold face for blockage.

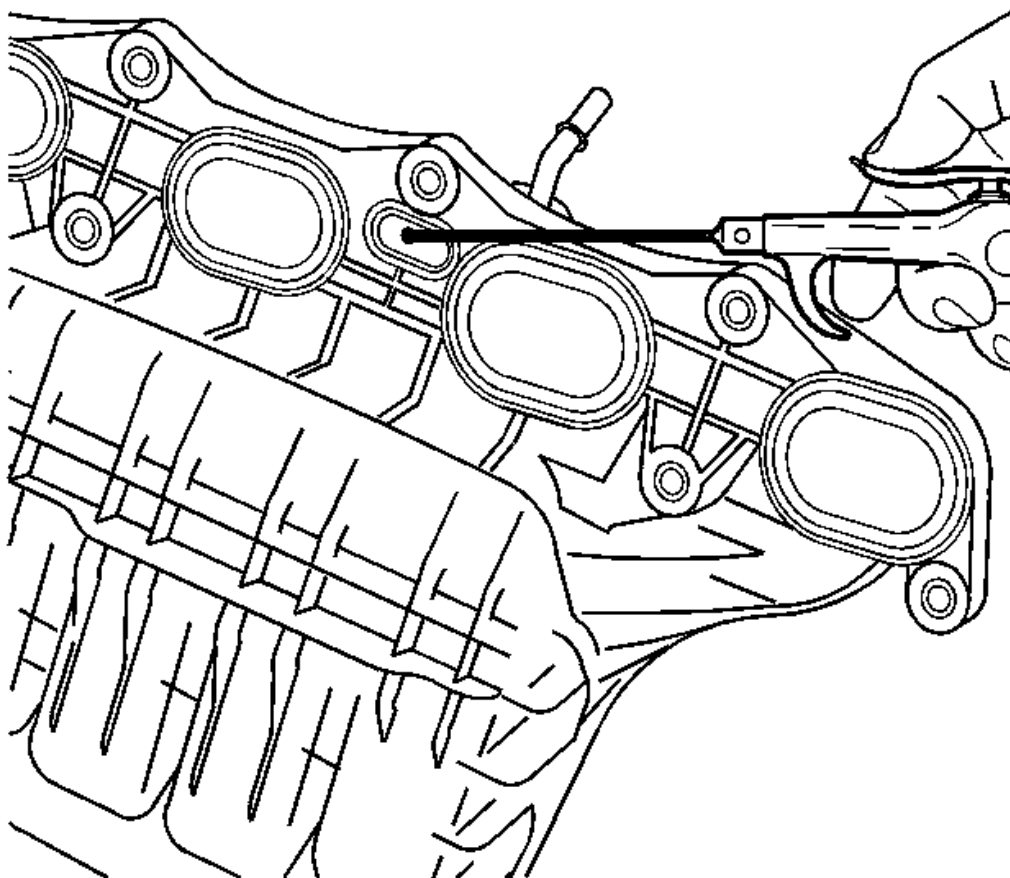


Fig. 398: Cleaning Crankcase Ventilation Passages
Courtesy of GENERAL MOTORS CORP.

CAUTION: Refer to SAFETY GLASSES CAUTION .

5. Clean the crankcase ventilation passages with compressed air if necessary. Use a maximum of 172 kPa (25 psi) of air pressure.
6. Replace the intake manifold as necessary.

EXHAUST MANIFOLD CLEANING AND INSPECTION

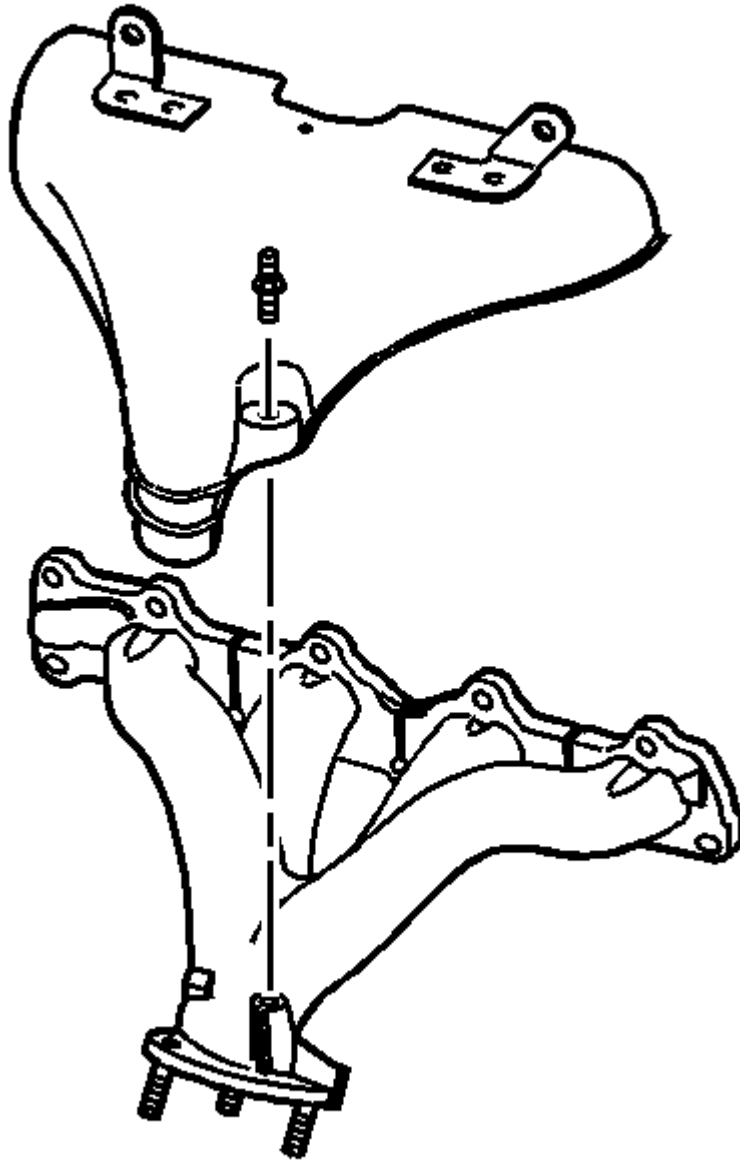


Fig. 399: Inspecting Exhaust Manifold Components
Courtesy of GENERAL MOTORS CORP.

IMPORTANT:

- Do not reuse the exhaust manifold-to-cylinder head gaskets. Upon installation of the exhaust manifold, install a **NEW** gasket. An improperly installed gasket or leaking exhaust system may effect

On-Board Diagnostics (OBD) II system performance.

- **Remove the oxygen sensor prior to cleaning the manifold, do not submerge the oxygen sensor in cleaning solvent.**

1. Remove the oxygen sensor from the manifold.
2. Clean the exhaust manifold in solvent.

CAUTION: Refer to SAFETY GLASSES CAUTION .

3. Dry the exhaust manifold with compressed air.
4. Inspect the heat shield for damage.

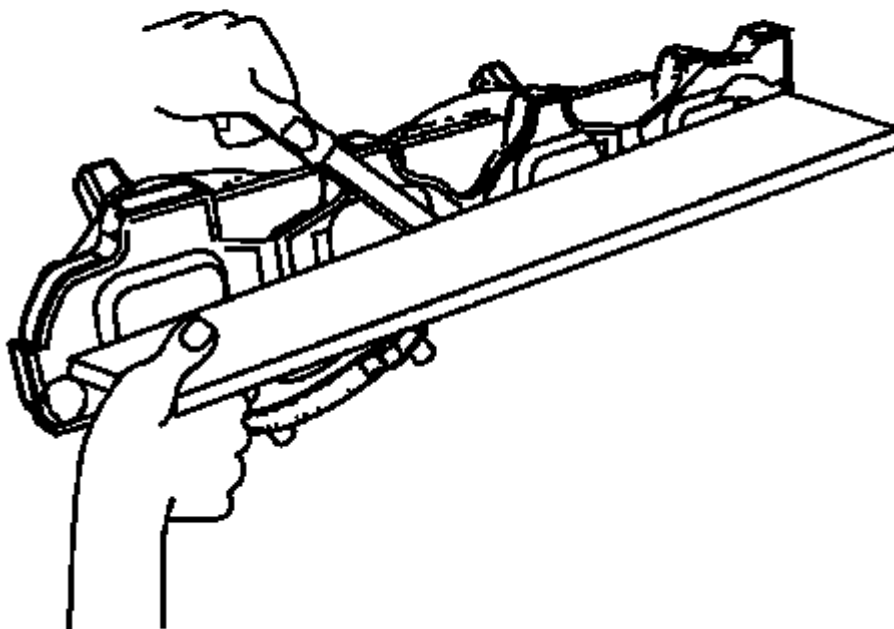
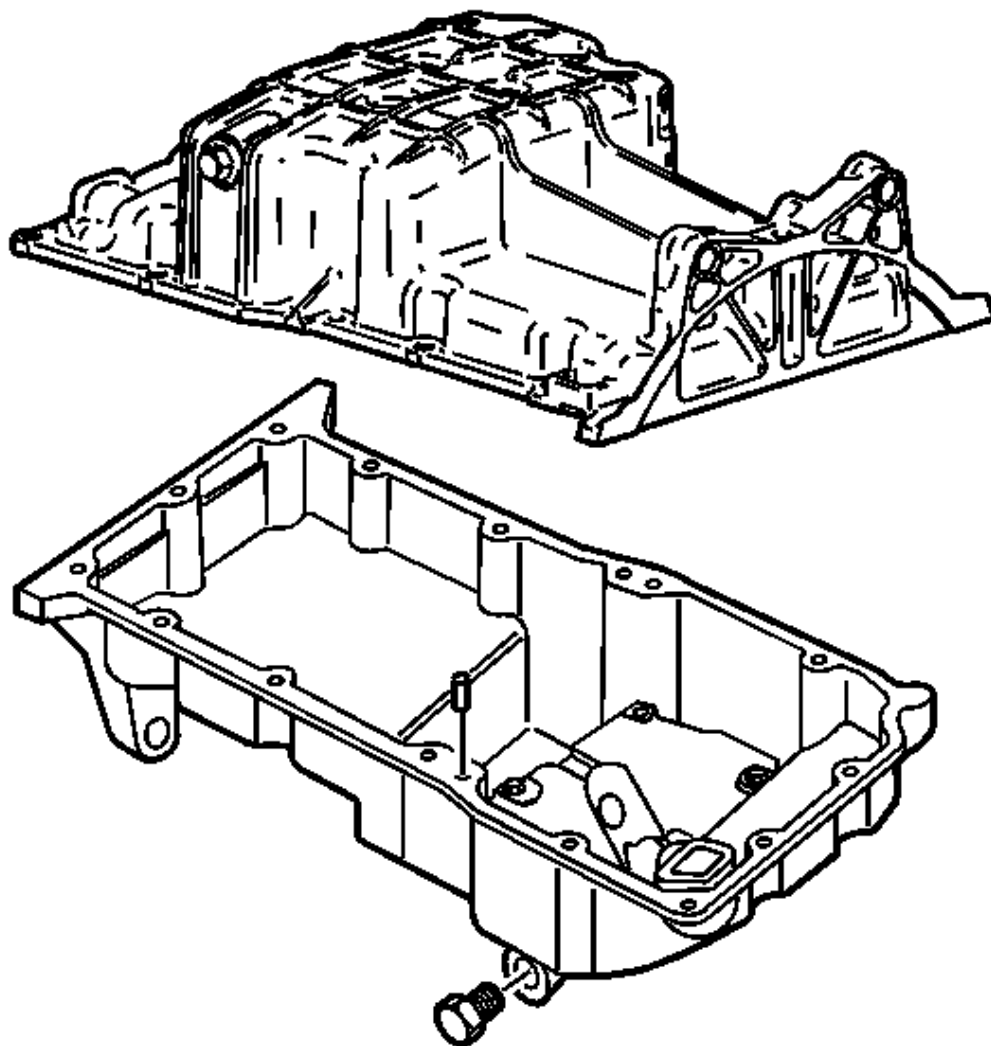


Fig. 400: Checking Exhaust Manifold Mounting Face For Warpage
Courtesy of GENERAL MOTORS CORP.

5. Use a straight edge and a feeler gage and measure the exhaust manifold mounting face for warpage.

An exhaust manifold face with warpage in excess of 0.25 mm (0.010 in) may cause an exhaust leak and may effect OBD II system performance. Exhaust manifolds not within specifications must be replaced.

OIL PAN CLEANING AND INSPECTION**Fig. 401: Inspecting Oil Pan****Courtesy of GENERAL MOTORS CORP.**

1. Clean the oil pan mating surface.
2. Clean the oil pan. Remove all the sludge and the oil deposits.
3. Inspect the threads for the engine oil drain plug.
4. Inspect the oil pan for cracking near the pan rail and the transmission mounting points.
5. Inspect the oil pan for cracking resulting from impact or flying road debris.

IMPORTANT: The oil pan baffle and pickup screen are not removable from the oil pan.

6. Inspect the oil pan baffle and pickup screen.
7. Repair or replace the oil pan as necessary.

THREAD REPAIR

Tools Required

J 42385-850 Thread Repair Kit

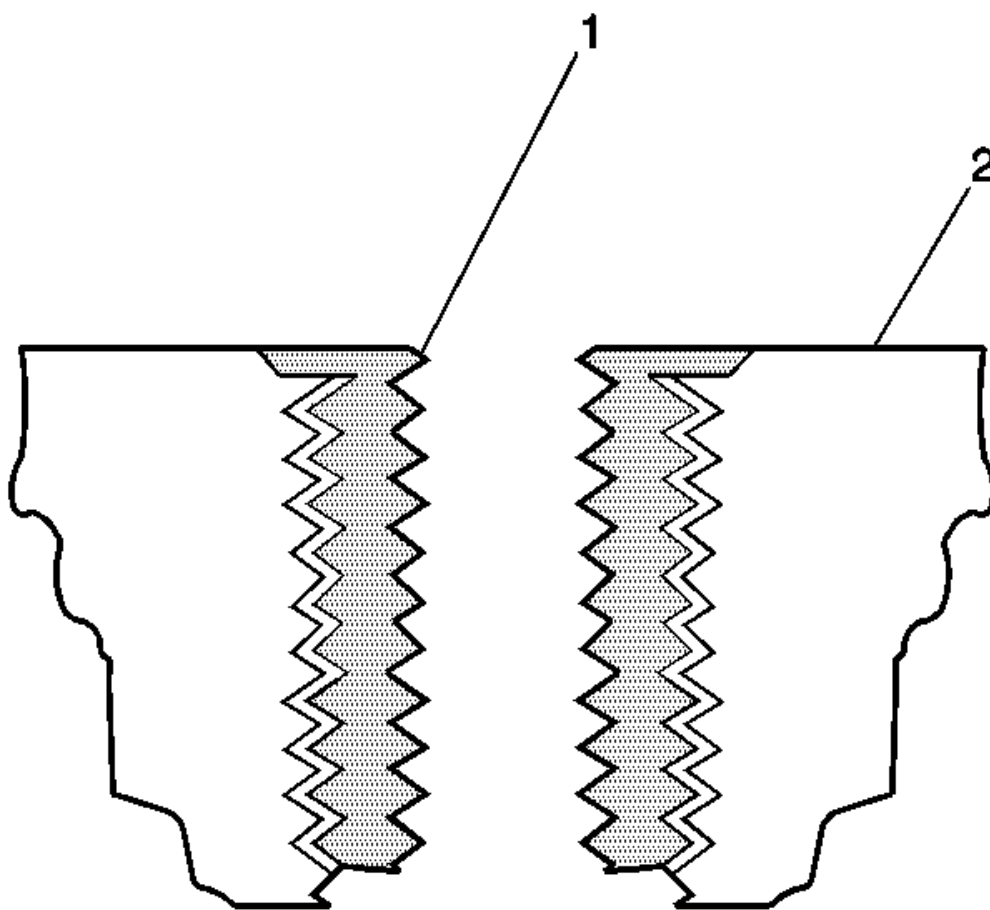


Fig. 402: View Of Bushing Type Insert & Base Material
Courtesy of GENERAL MOTORS CORP.

The thread repair process involves a solid, thin walled, self-locking, carbon steel, bushing type insert (1). During the bushing installation process, the driver tool expands the bottom external threads of the insert into the base material (2). This action mechanically locks the insert in place. Also, when installed to the proper depth,

the flange of the insert will be seated against the counterbore of the repaired hole.

General Thread Repair

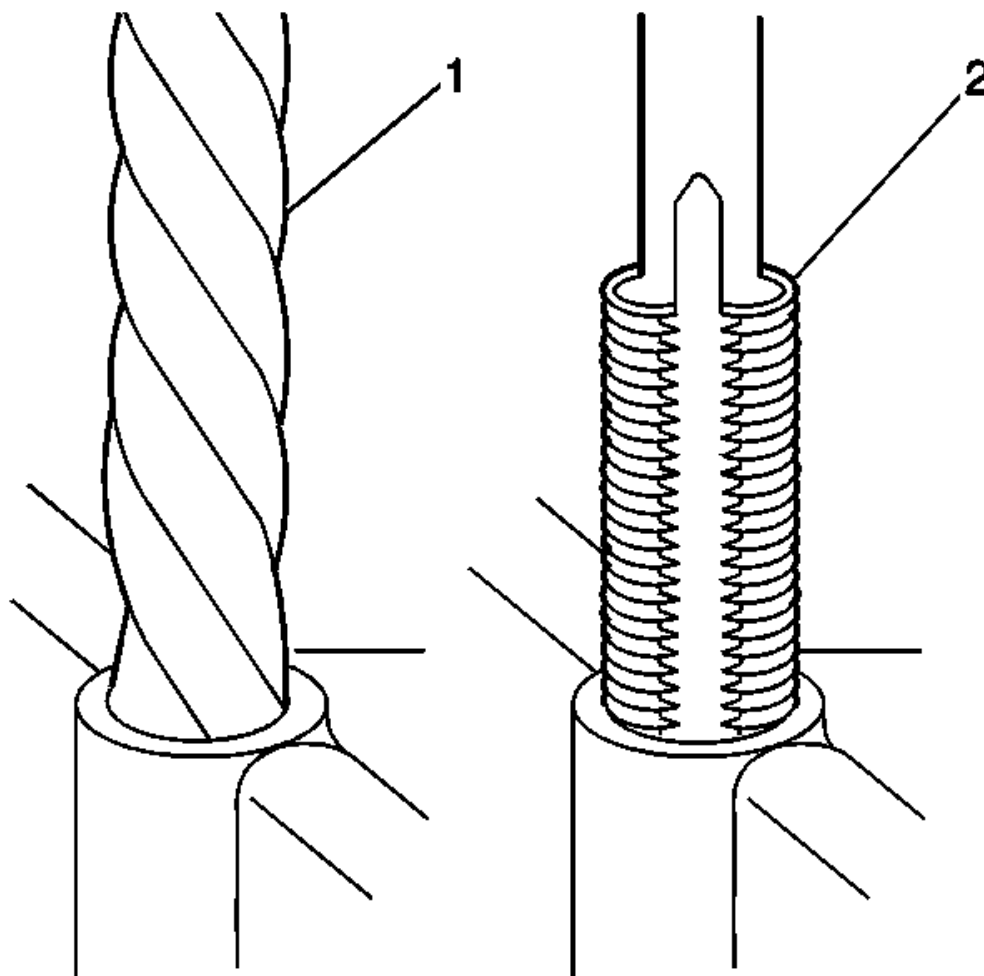


Fig. 403: Drilling & Tapping Threads
Courtesy of GENERAL MOTORS CORP.

CAUTION: Refer to SAFETY GLASSES CAUTION .

IMPORTANT: The use of a cutting type fluid GM P/N 1052864 (Canadian P/N 992881), WD 40®, or equivalent, is recommended when performing the drilling, counterboring, and tapping procedures.
Driver oil **MUST** be used on the installer driver tool.
The tool kits are designed for use with either a suitable tap wrench or drill motor.

1. Drill out the threads of the damaged hole (1).
 - M6 inserts require a minimum drill depth of 15 mm (0.59 in).
 - M8 inserts require a minimum drill depth of 20 mm (0.79 in).
 - M10 inserts require a minimum drill depth of 23.5 mm (0.93 in).
2. Using compressed air, clean out any chips.

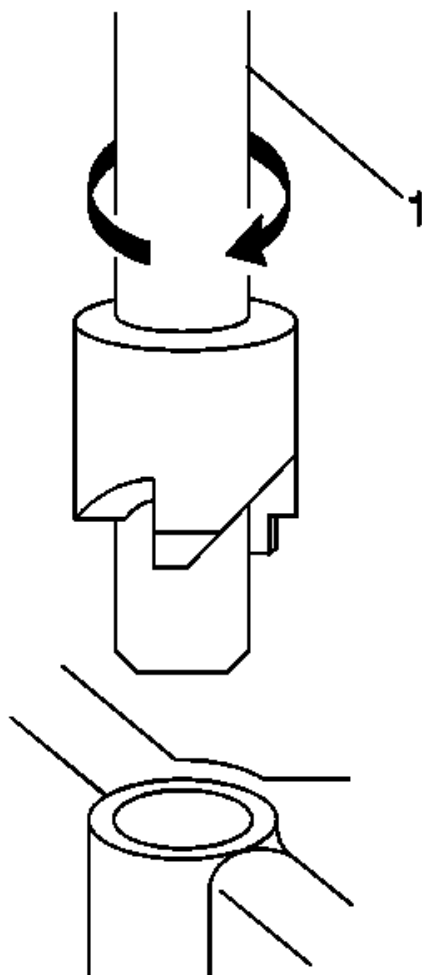


Fig. 404: View Of Counterbore Drill
Courtesy of GENERAL MOTORS CORP.

3. Counterbore the hole to the full depth permitted by the tool (1).
4. Using compressed air, clean out any chips.

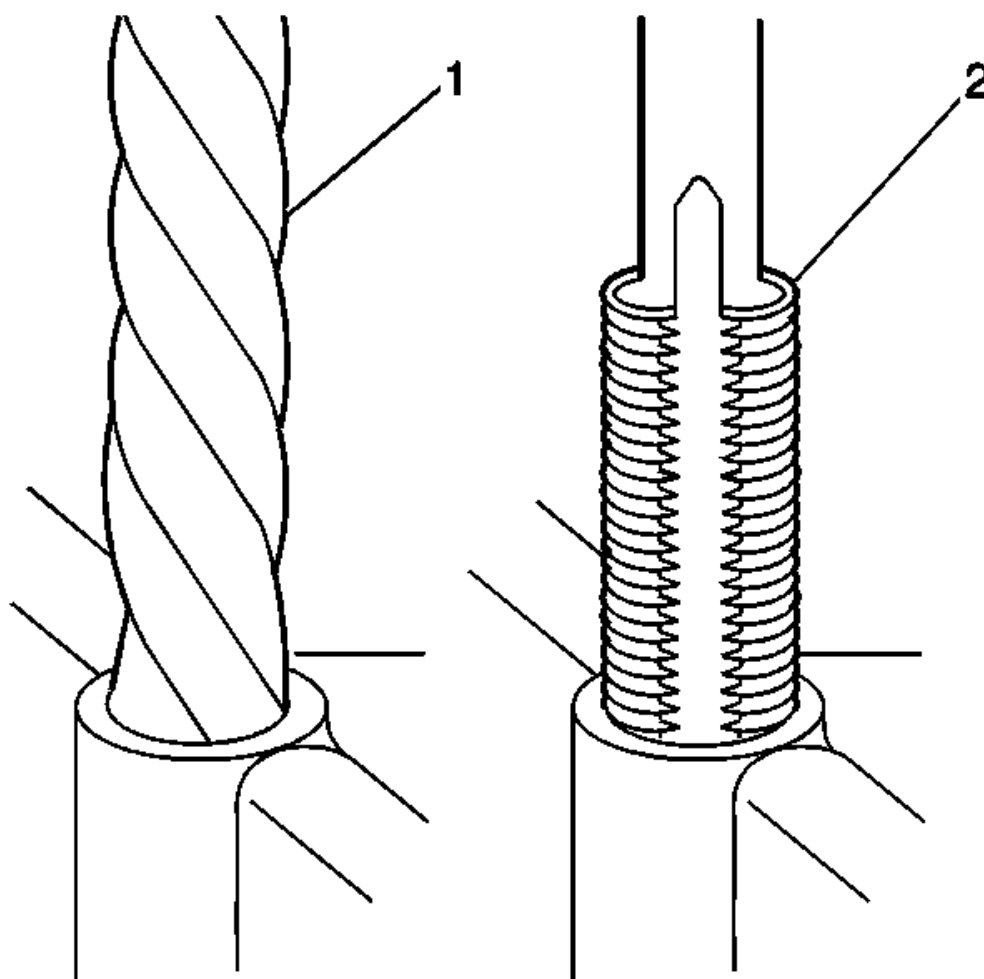


Fig. 405: Drilling & Tapping Threads
Courtesy of GENERAL MOTORS CORP.

5. Using a tap wrench (2), tap the threads of the drilled hole.
 - M6 inserts require a minimum tap depth of 15 mm (0.59 in).
 - M8 inserts require a minimum tap depth of 20 mm (0.79 in).
 - M10 inserts require a minimum tap depth of 23.5 mm (0.93 in).
6. Using compressed air, clean out any chips.
7. Spray cleaner GM P/N 12346139, GM P/N 12377981 (Canadian P/N 10953463) or equivalent, into the hole.
8. Using compressed air, clean any cutting oil and chips out of the hole.

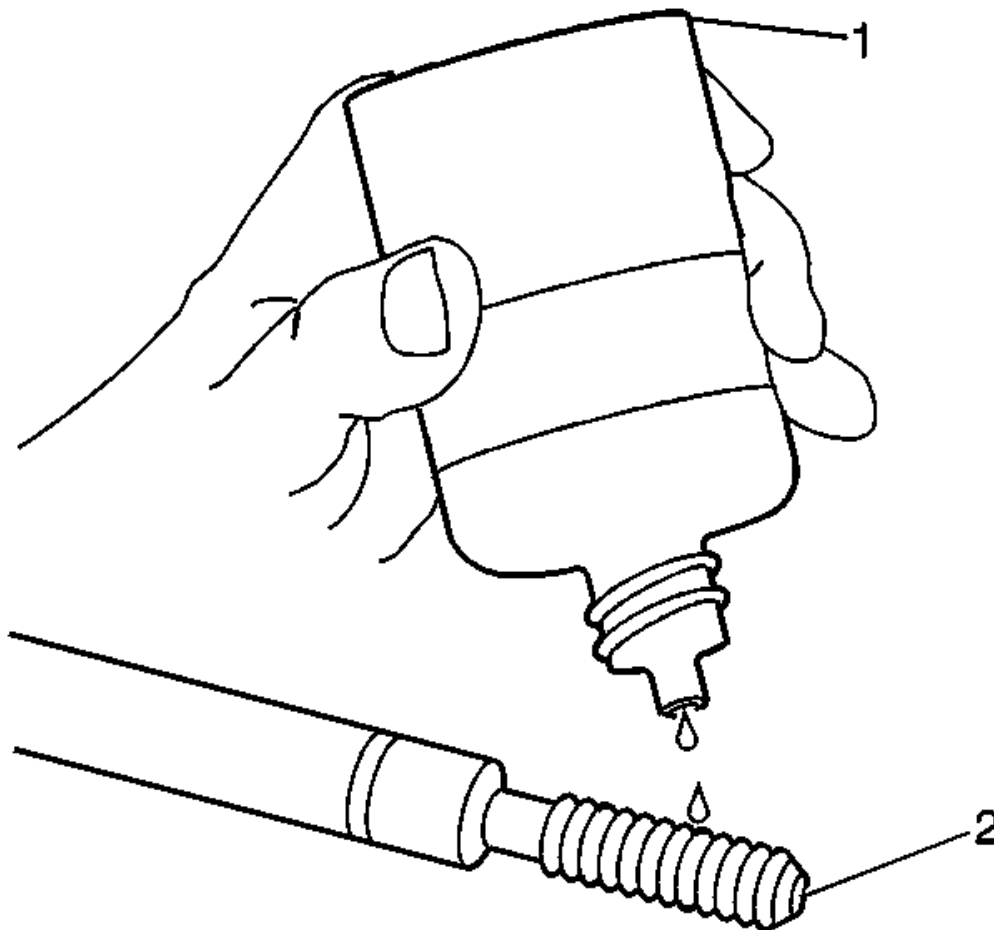


Fig. 406: Lubricating Installer Tool Using Driver Oil
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not allow oil or other foreign material to contact the outside diameter (OD) of the insert.

9. Lubricate the threads of the installer tool (2) with the driver oil (1).

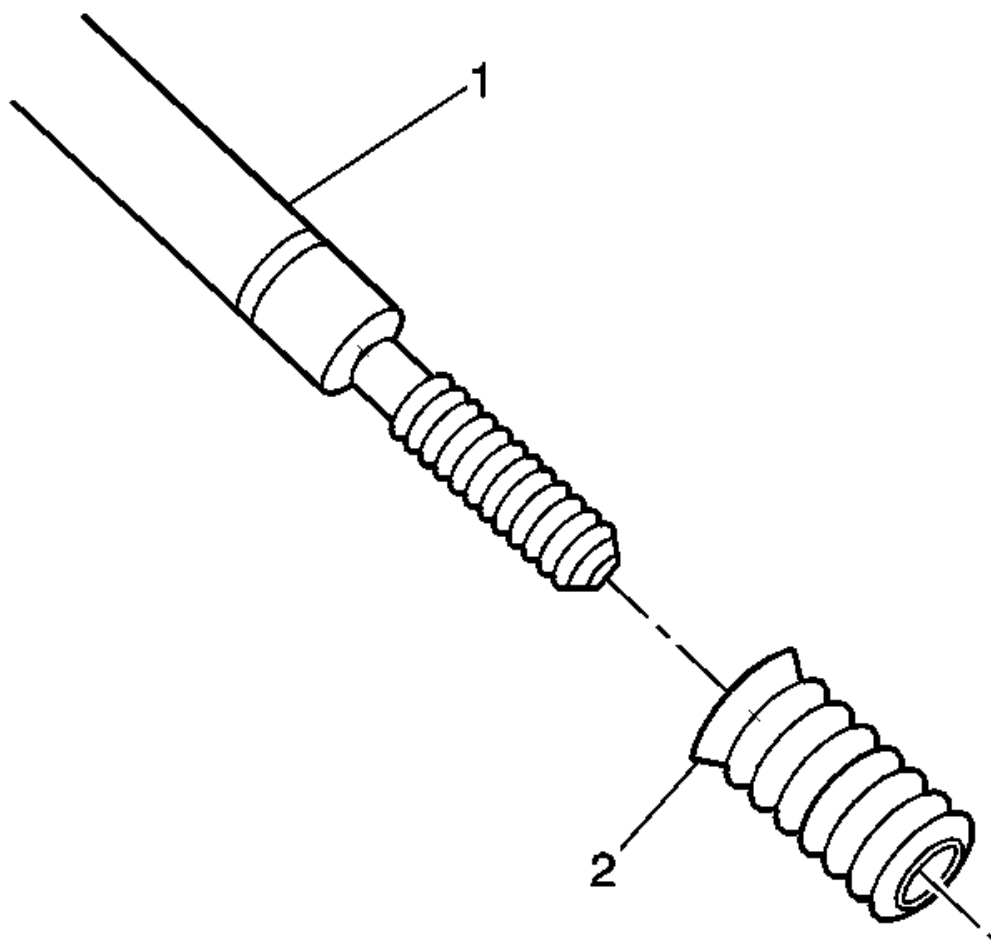


Fig. 407: View of Bushing Type Insert
Courtesy of GENERAL MOTORS CORP.

10. Install the insert (2) onto the driver tool (1).

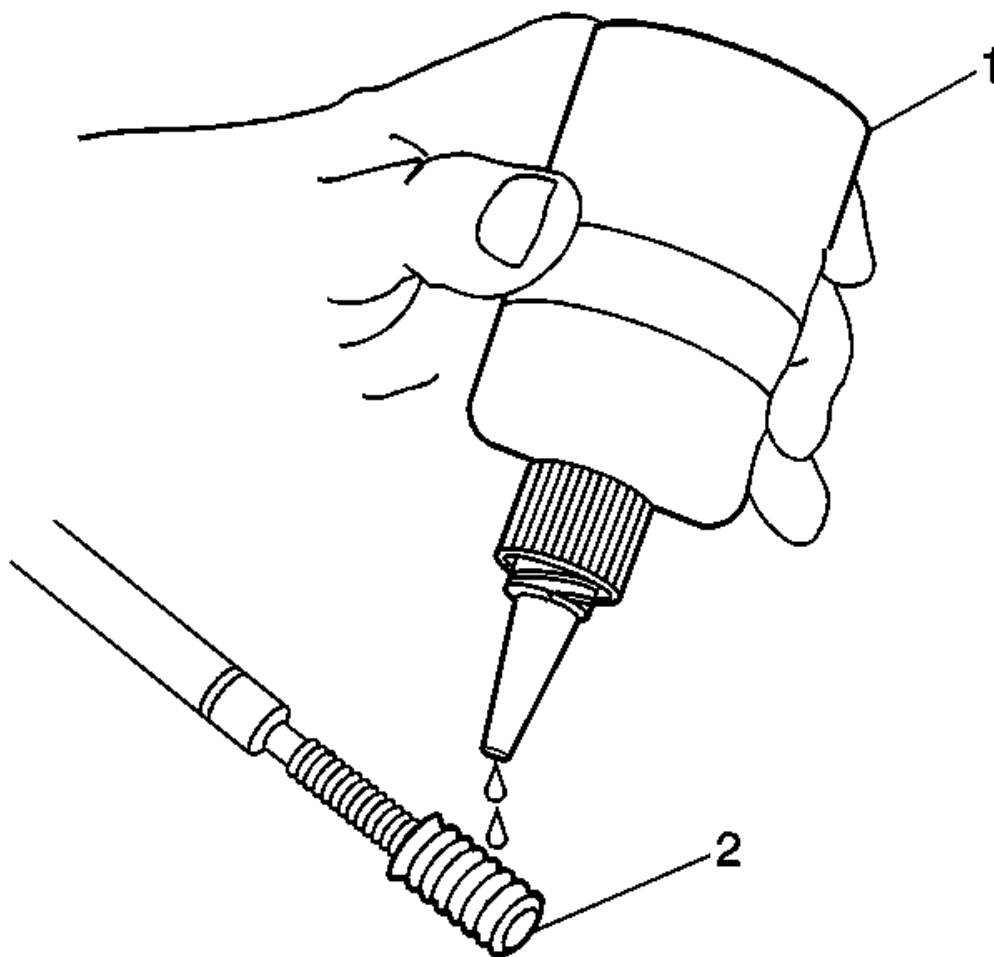


Fig. 408: Applying Threadlock To Insert
Courtesy of GENERAL MOTORS CORP.

11. Apply threadlock LOCTITE™ 277, J 42385-109 (1), or equivalent to the insert OD threads (2).

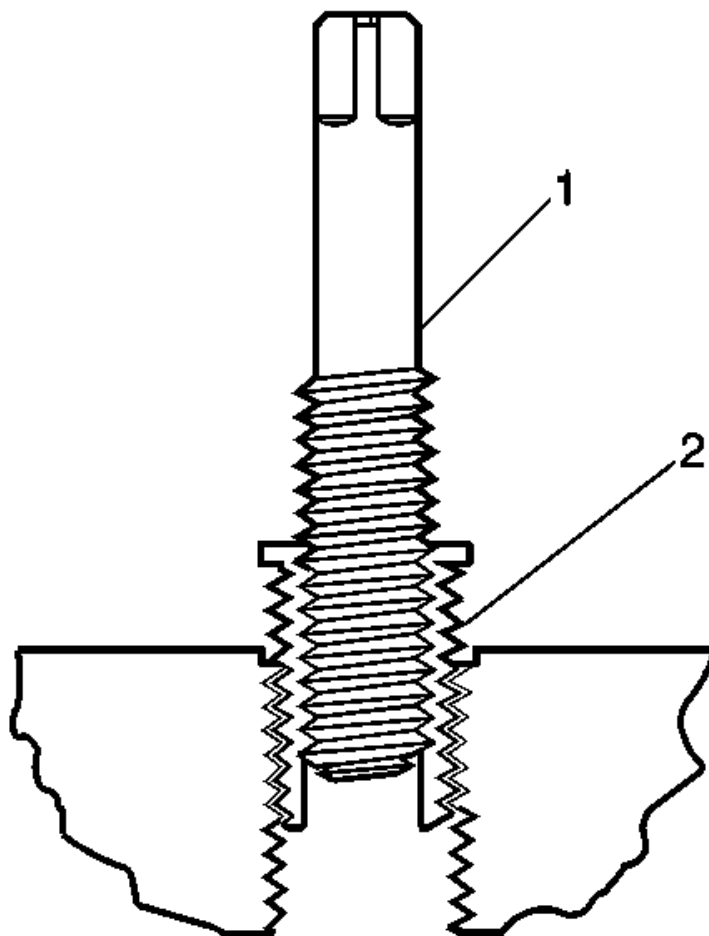


Fig. 409: Installing Insert Into Tapped Bolt Hole
Courtesy of GENERAL MOTORS CORP.

12. Install the insert (2) into the hole.

Install the insert until the flange of the insert contacts the counterbored surface. Continue to rotate the installer tool (1) through the insert.

The installer tool will tighten up before screwing completely through the insert. This is acceptable. You are forming the bottom threads of the insert and mechanically locking the insert to the base material threads.

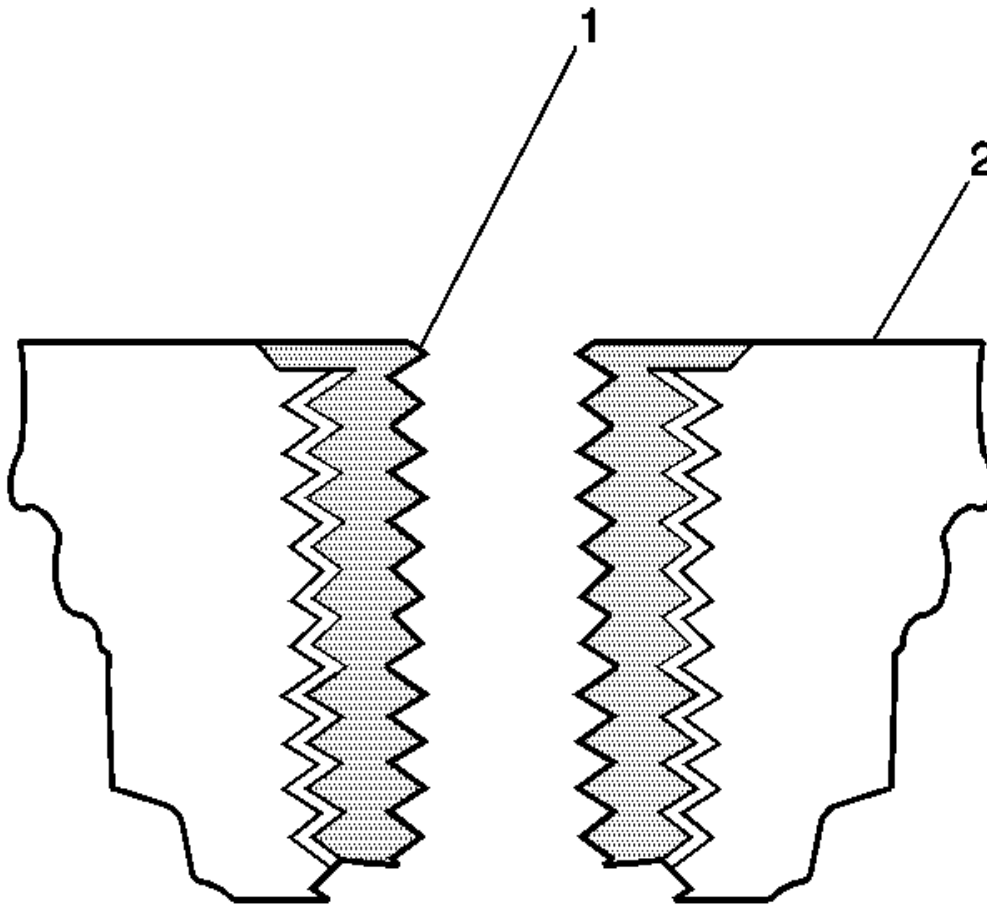


Fig. 410: View Of Bushing Type Insert & Base Material
Courtesy of GENERAL MOTORS CORP.

13. Inspect the insert for proper installation into the hole.

A properly installed insert (1) will be either flush or slightly below flush with the surface of the base material (2).

Cylinder Head Bolt Hole Thread Repair

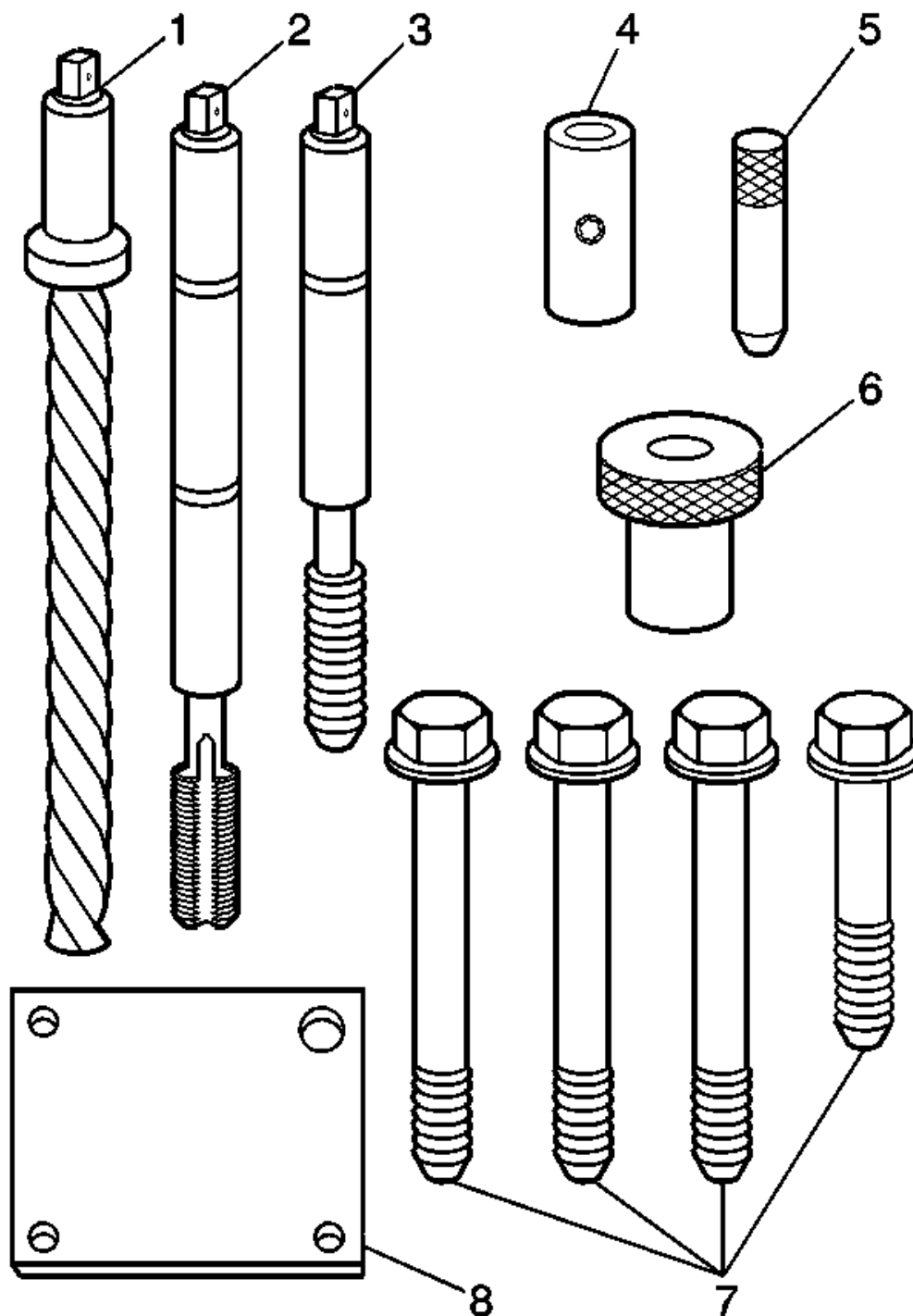


Fig. 411: Identifying Thread Repair Kit Components
Courtesy of GENERAL MOTORS CORP.

1. The cylinder head bolt hole thread repair kit consists of the following items:

- Drill (1)
- Tap (2)
- Installer (3)
- Sleeve (4)
- Alignment Pin (5)
- Bushing (6)
- Bolts (7)
- Fixture Plate (8)

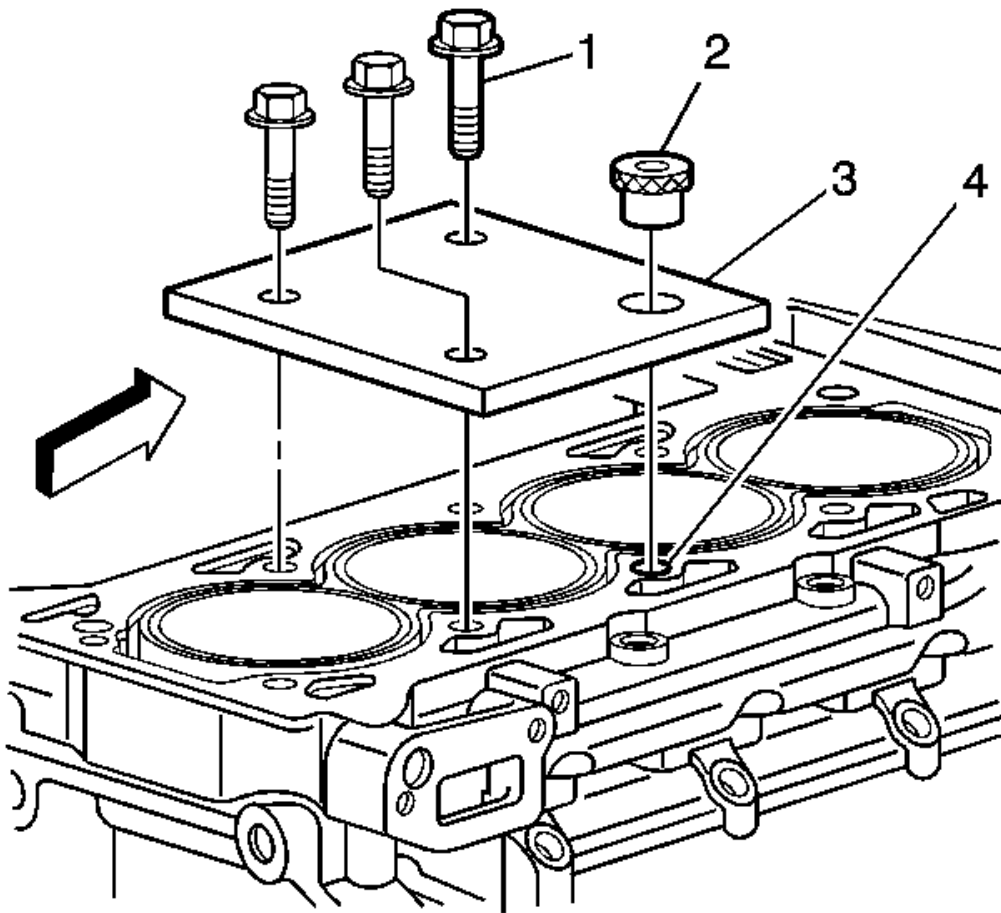


Fig. 412: Installing Fixture Plate, Bolts & Bushing
Courtesy of GENERAL MOTORS CORP.

CAUTION: Refer to SAFETY GLASSES CAUTION .

IMPORTANT: The use of a cutting type fluid GM P/N 1052864 (Canadian P/N 992881), WD 40®, or equivalent, is recommended when performing the drilling and tapping procedures.

Driver oil **MUST** be used on the installer driver tool.

The tool kits are designed for use with either a suitable tap wrench or drill motor.

2. Install the fixture plate (3), bolts (1), and bushing (2) onto the engine block deck.

Position the fixture plate and bushing over the hole that is to be repaired (4).

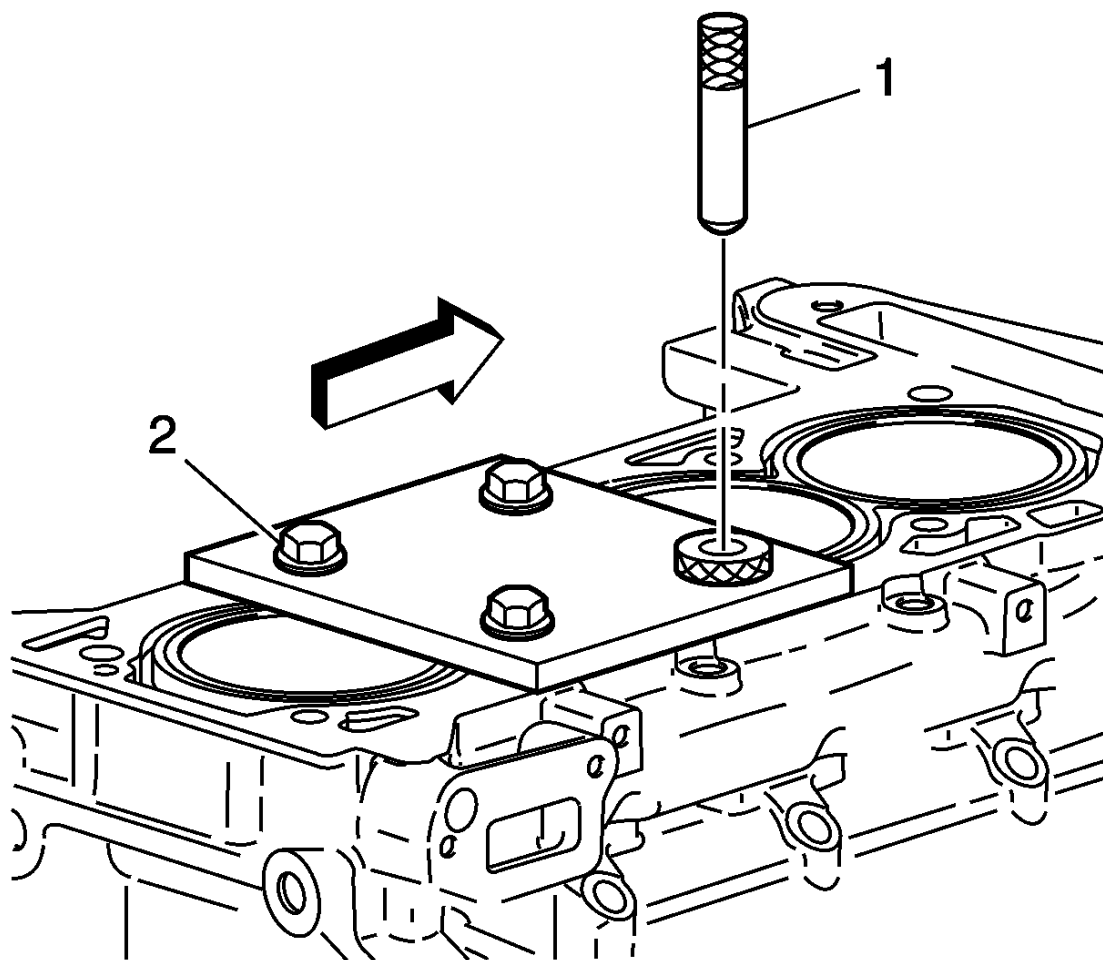


Fig. 413: Identifying Alignment Pin
Courtesy of GENERAL MOTORS CORP.

3. Position the alignment pin (1) through the bushing and into the hole.
4. With the alignment pin in the desired hole, tighten the fixture retaining bolts (2).
5. Remove the alignment pin from the hole.

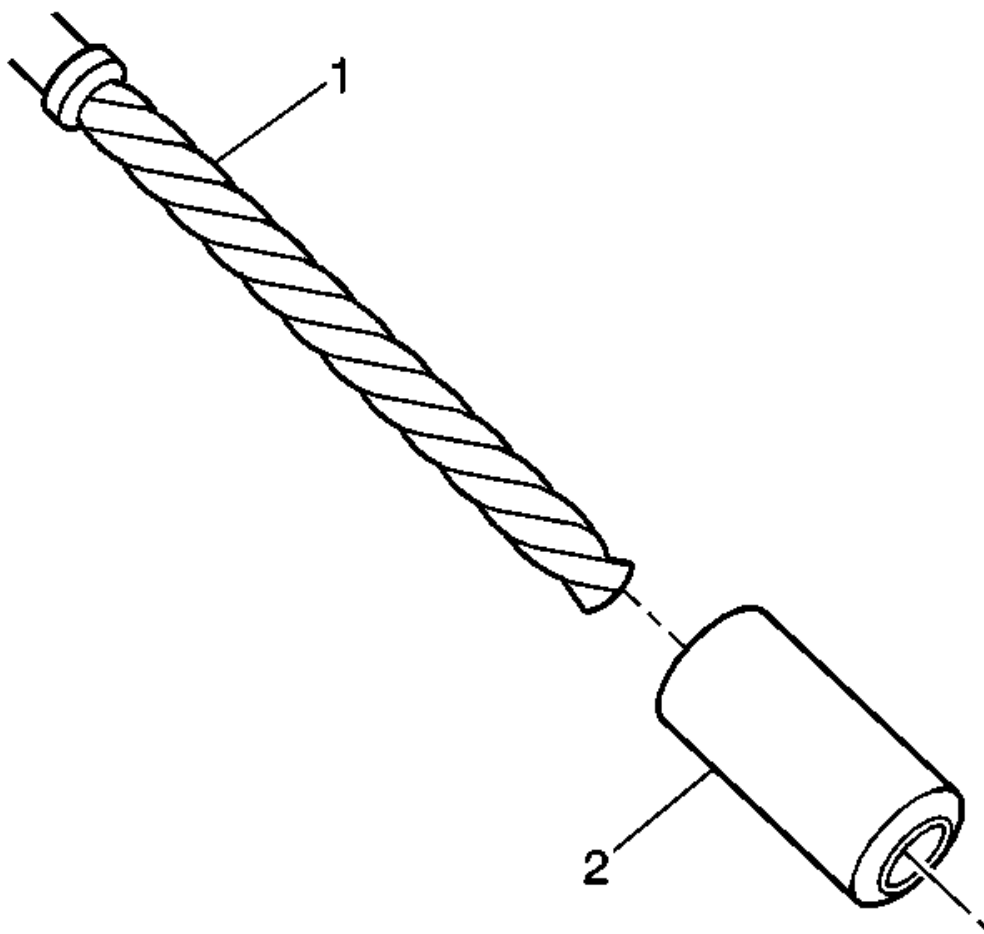


Fig. 414: View Of Stop Collar & Counterbore Drill
Courtesy of GENERAL MOTORS CORP.

6. Install the sleeve (2) onto the drill (1), if required.

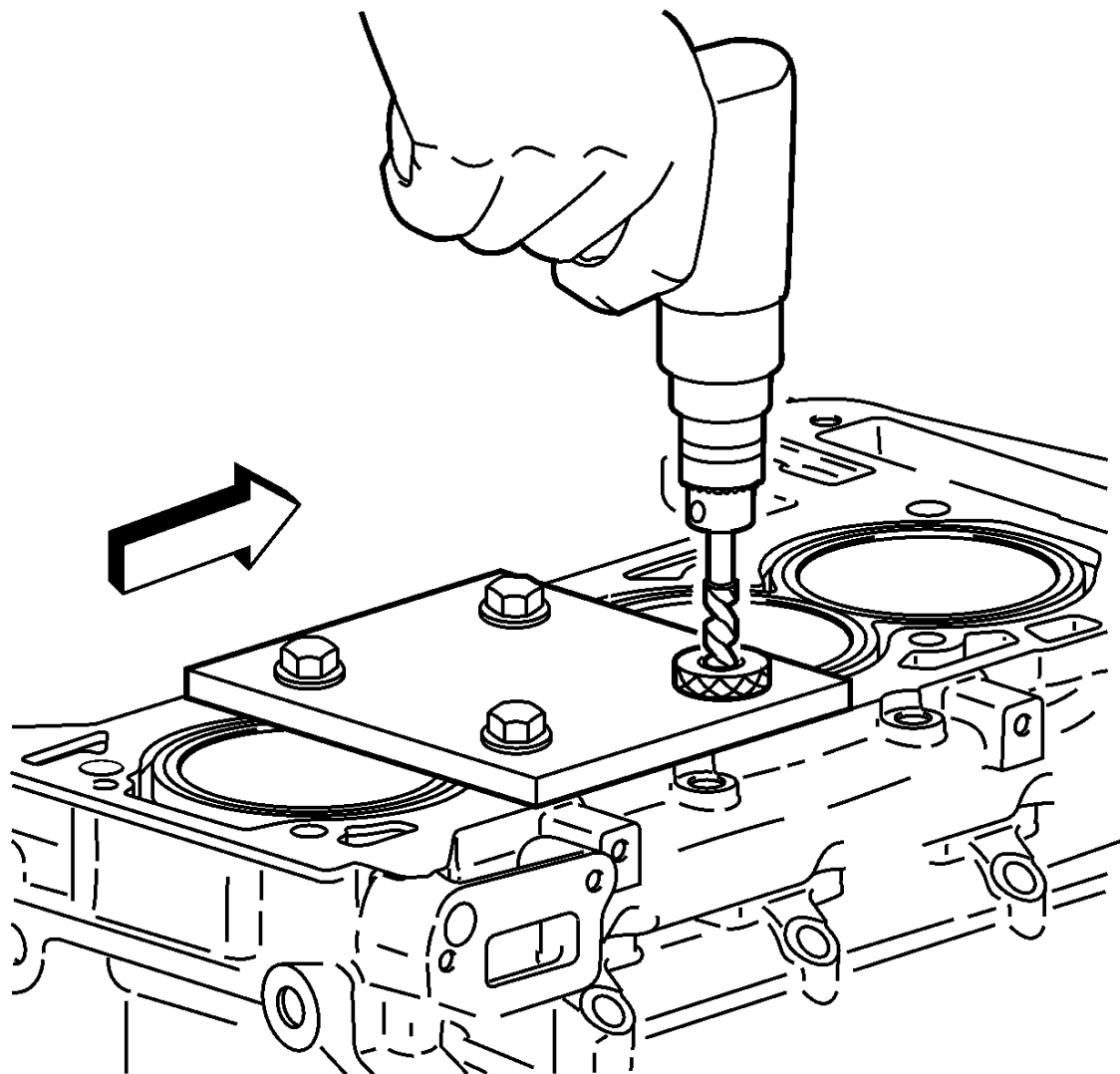


Fig. 415: Drilling Out Threads Of Damaged Hole
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: During the reaming process, it is necessary to repeatedly remove the drill and clean the chips from the hole.

7. Drill out the threads of the damaged hole.

Drill the hole until the stop collar of the drill bit or the sleeve contacts the bushing.

8. Using compressed air, clean out any chips.

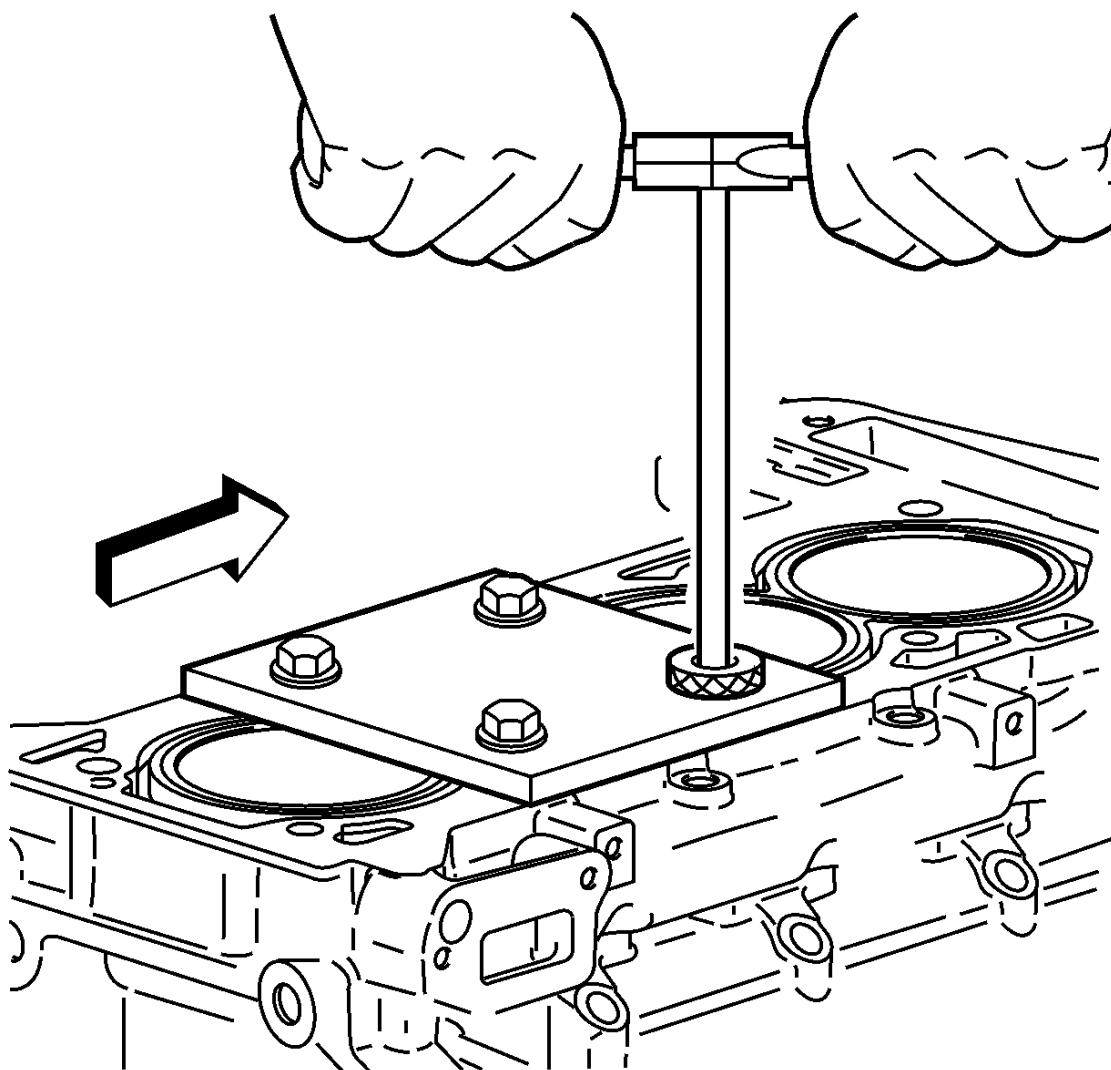


Fig. 416: Tapping Threads Of Drilled Hole With Tap Wrench
Courtesy of GENERAL MOTORS CORP.

9. Using a tap wrench, tap the threads of the drilled hole.

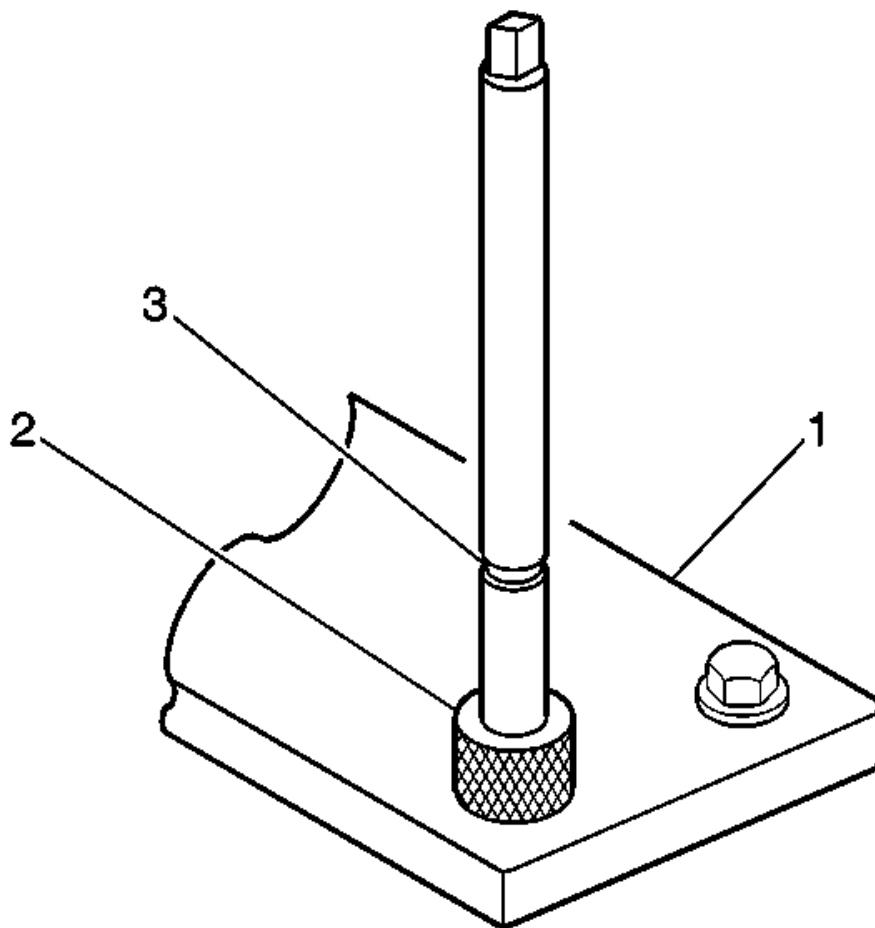


Fig. 417: View Of Fixture Plate, Drill Bushing & Tool Marking
Courtesy of GENERAL MOTORS CORP.

10. Using a TAP wrench, tap the threads of the drilled hole.

In order to tap the new threads to the proper depth, rotate the tap into the hole until the mark (3) on the tap align with the top of the drill bushing (2).

11. Remove the fixture plate (1), bushing (2), and bolts.
12. Using compressed air, clean out any chips.
13. Spray cleaner GM P/N 12346139 or GM P/N 1237798 (Canadian P/N 10953463), or equivalent, into the hole.
14. Using compressed air, clean any cutting oil and chips out of the hole.

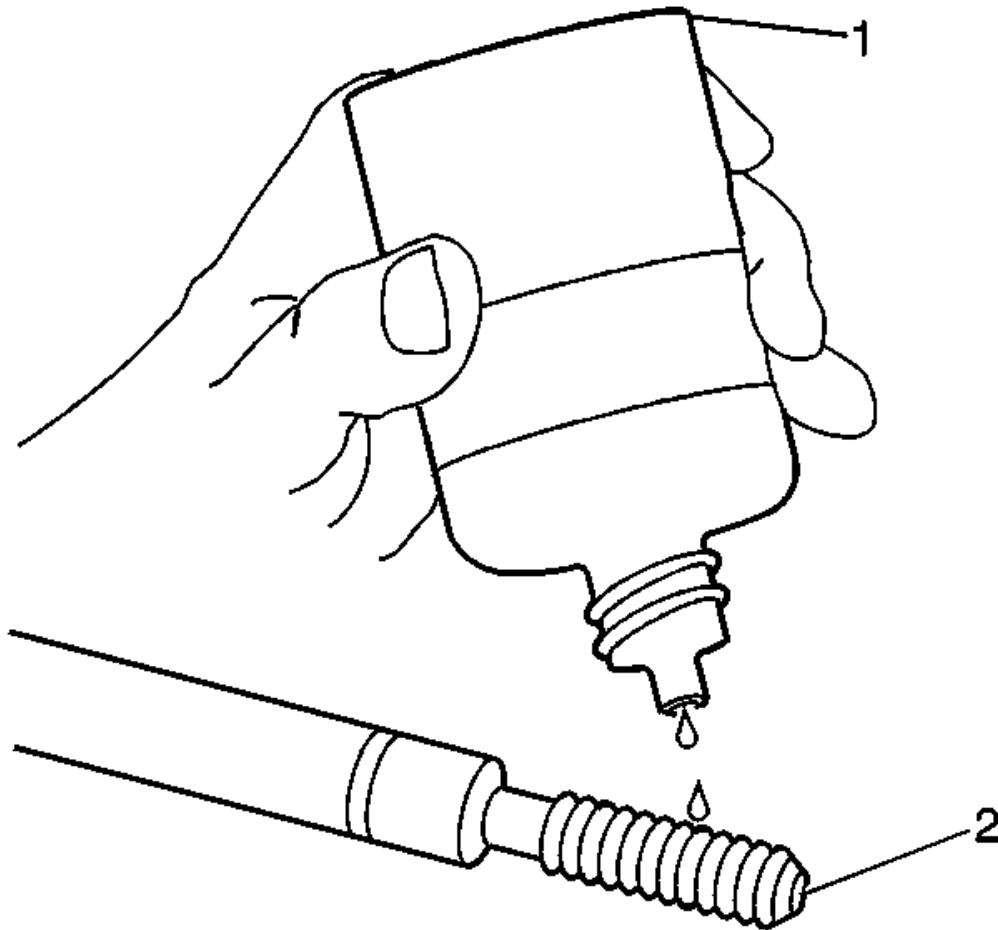


Fig. 418: Lubricating Installer Tool Using Driver Oil
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not allow oil or other foreign material to contact the outside diameter (OD) of the insert.

15. Lubricate the threads of the installer tool (2) with the driver oil (1).

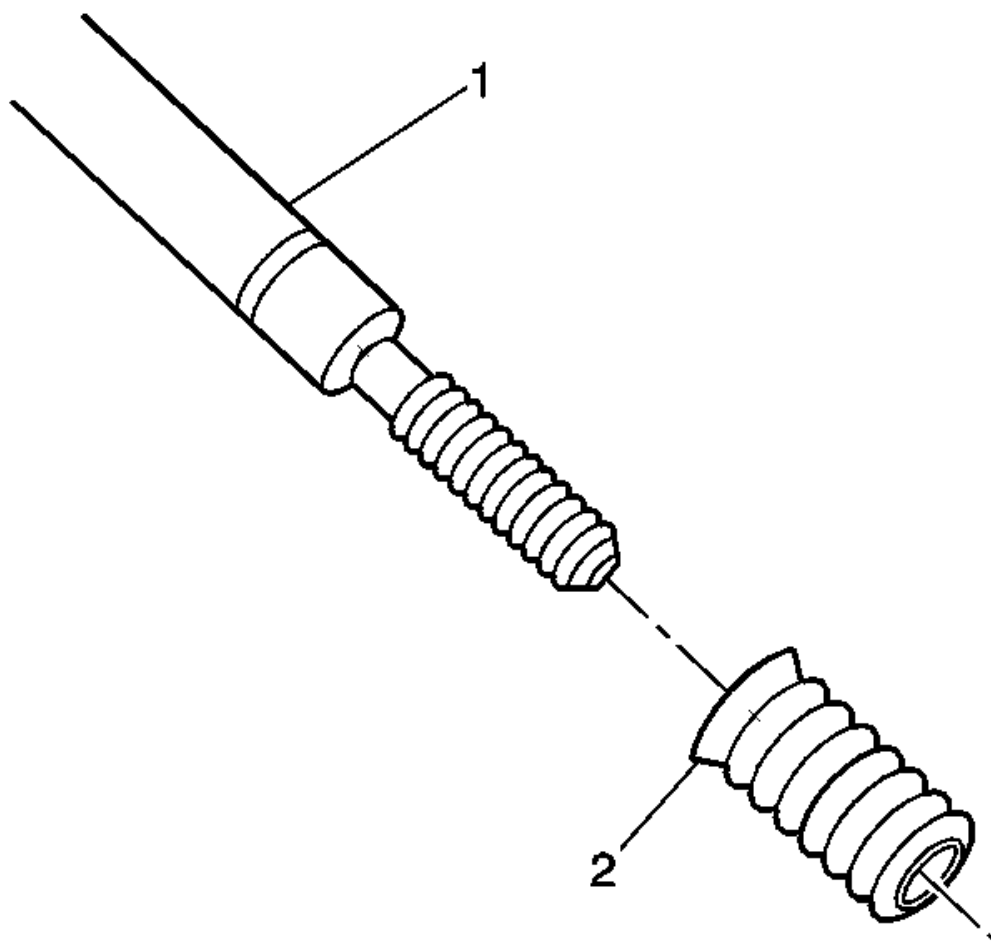


Fig. 419: View of Bushing Type Insert
Courtesy of GENERAL MOTORS CORP.

16. Install the insert (2) onto the driver tool (1).

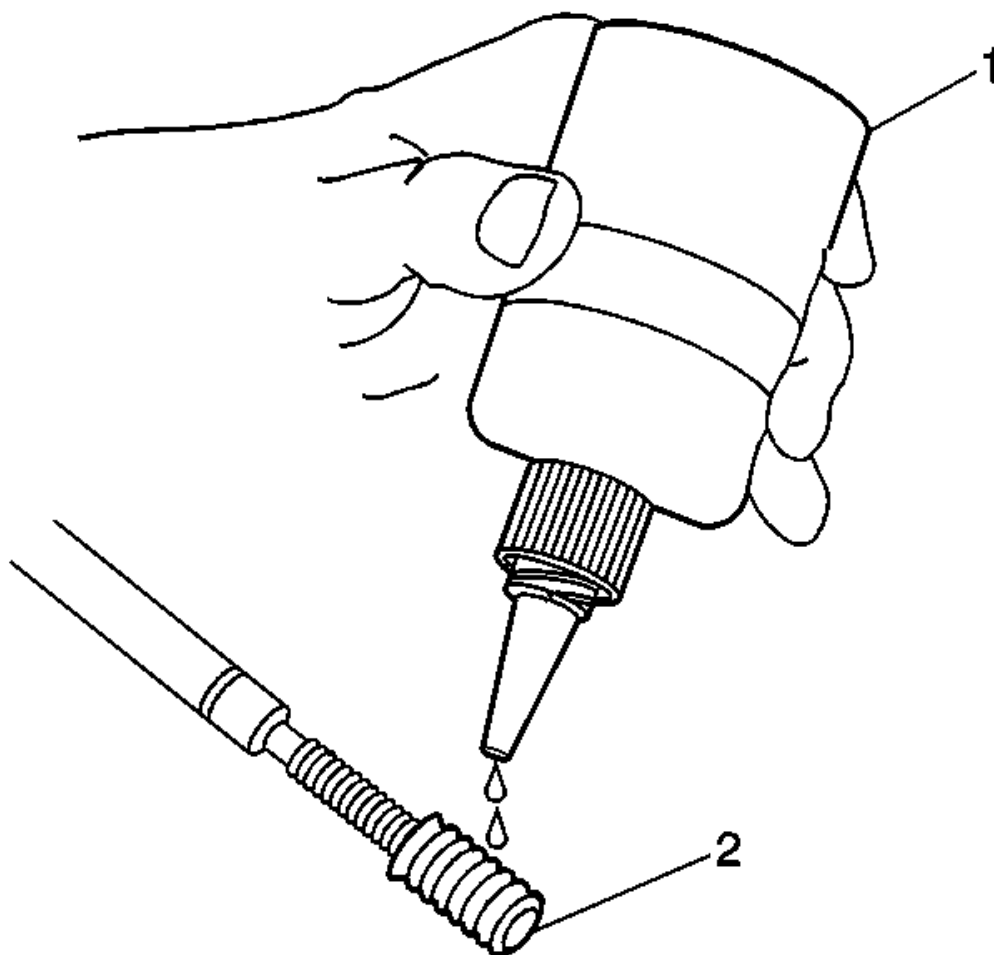


Fig. 420: Applying Threadlock To Insert
Courtesy of GENERAL MOTORS CORP.

17. Apply threadlock LOCTITE™ 277, J 42385-109 (1), or equivalent to the insert OD threads (2).

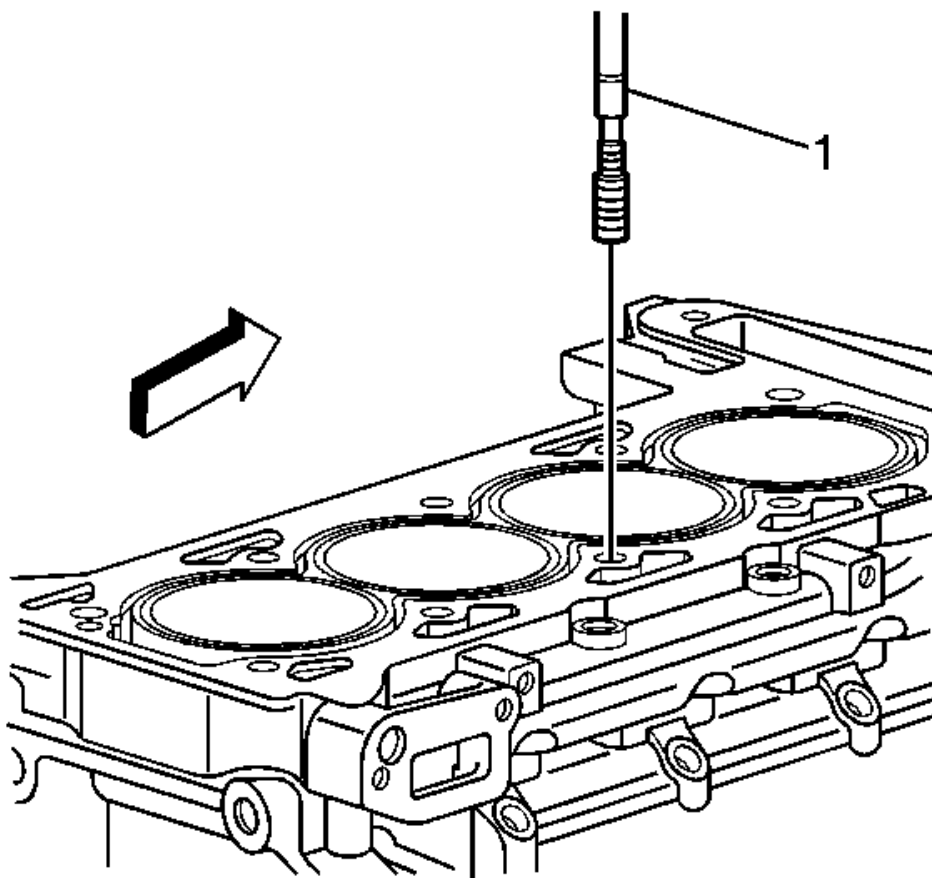


Fig. 421: Installing & Inserting Driver Into Hole
Courtesy of GENERAL MOTORS CORP.

18. Install the insert and driver (1) into the hole.

Rotate the driver tool until the mark on the tool aligns with the deck surface of the engine block.

The installer tool will tighten up before screwing completely through the insert. This is acceptable. You are forming the bottom threads of the insert and mechanically locking the insert to the base material threads.

Main Cap Bolt Hole Thread Repair

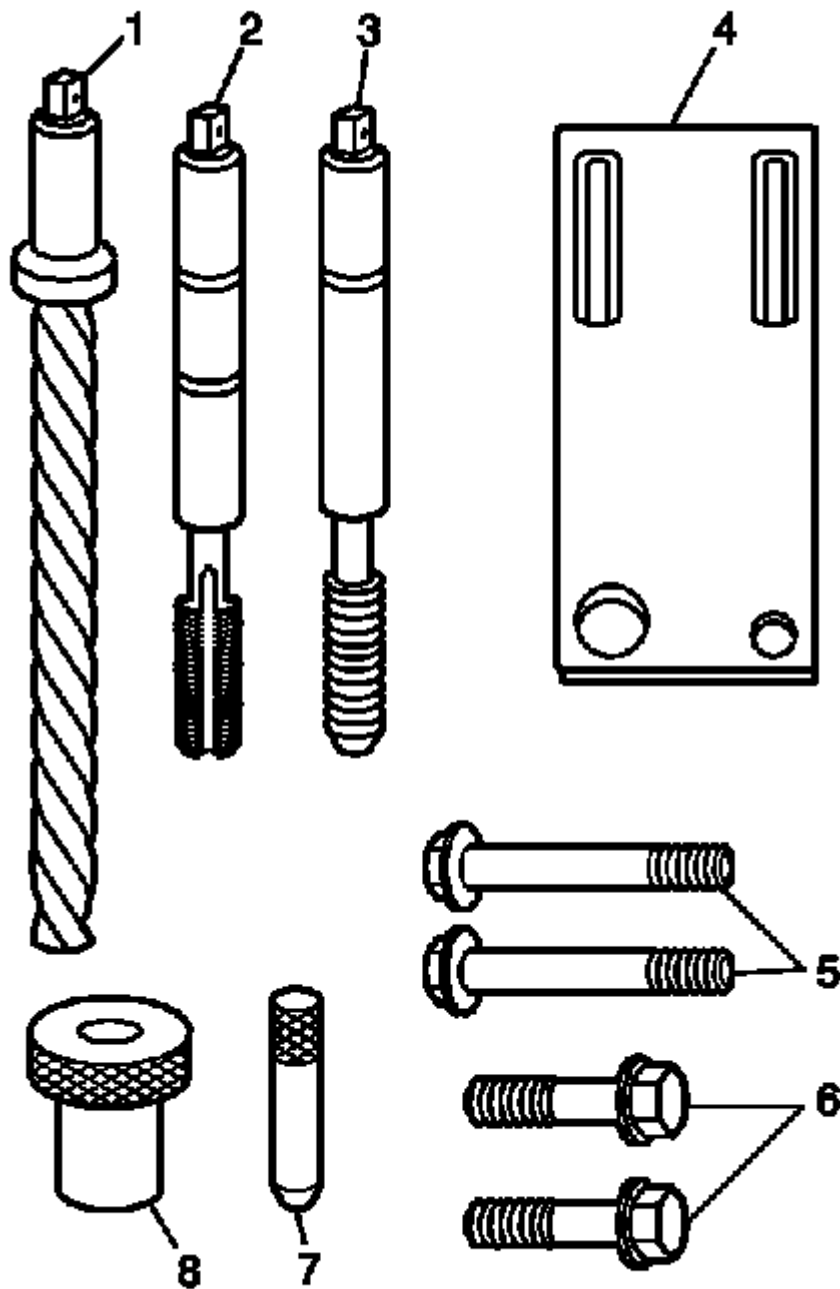


Fig. 422: Identifying Thread Repair Kit Components
Courtesy of GENERAL MOTORS CORP.

1. The main cap bolt hole thread repair kit consists of the following items:
 - Drill (1)
 - Tap (2)
 - Installer (3)

- Fixture Plate (4)
- Long Bolts (5)
- Short Bolts (6)
- Alignment Pin (7)
- Bushing (8)

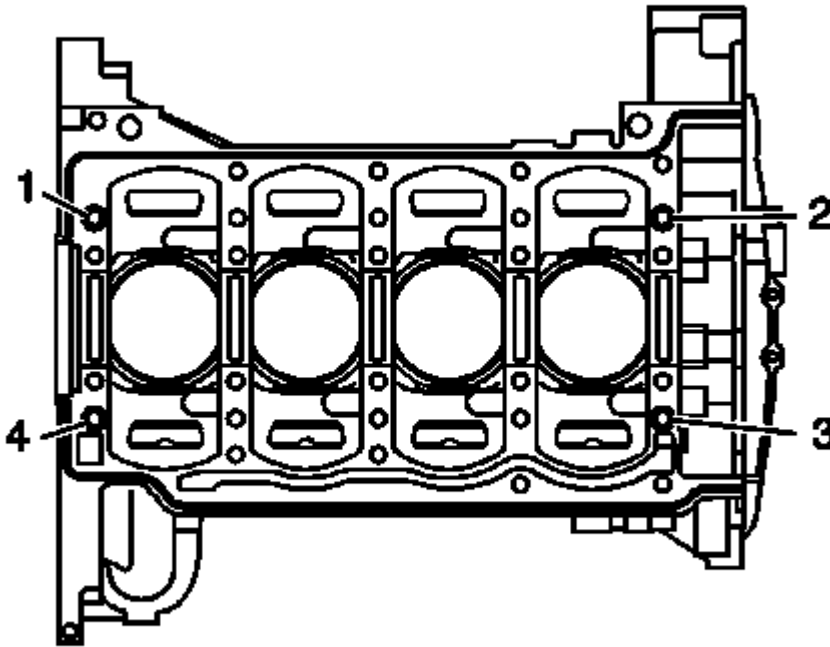


Fig. 423: Identifying Alignment Dowel Pins
Courtesy of GENERAL MOTORS CORP.

2. Remove the alignment dowel pins from the holes (1-4), if necessary.

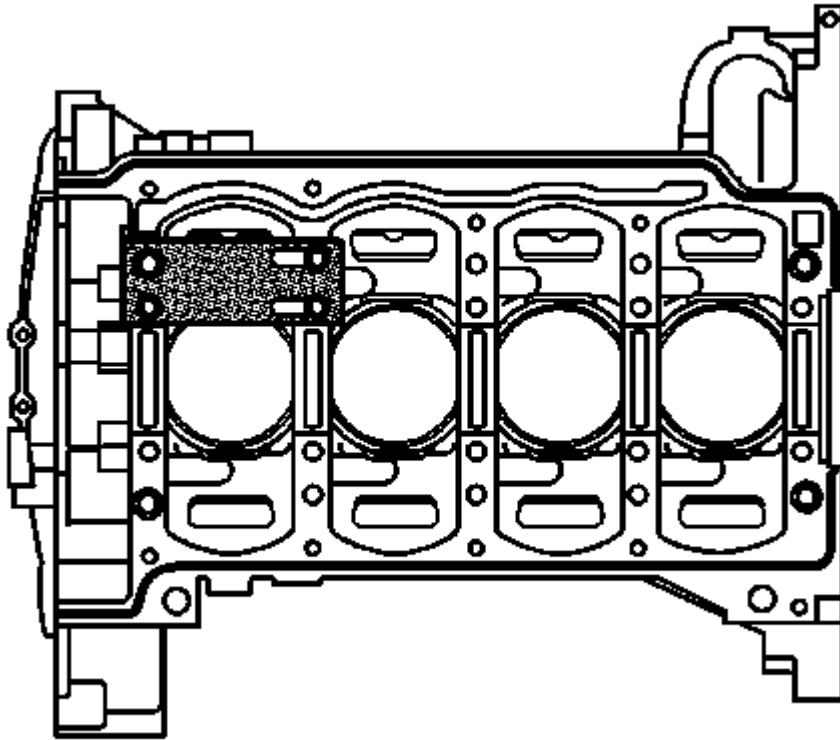


Fig. 424: Installing Fixture Plate, Bolt, & Bushing Onto Engine Block
Courtesy of GENERAL MOTORS CORP.

3. Install the fixture plate, bolt, and bushing, onto the engine block.

Position the fixture plate and bushing over the hole that is to be repaired.

4. Position the alignment pin in the desired hole and tighten the fixture retaining bolts.
5. Drill out the damaged hole.
6. Using compressed air, clean out any chips.

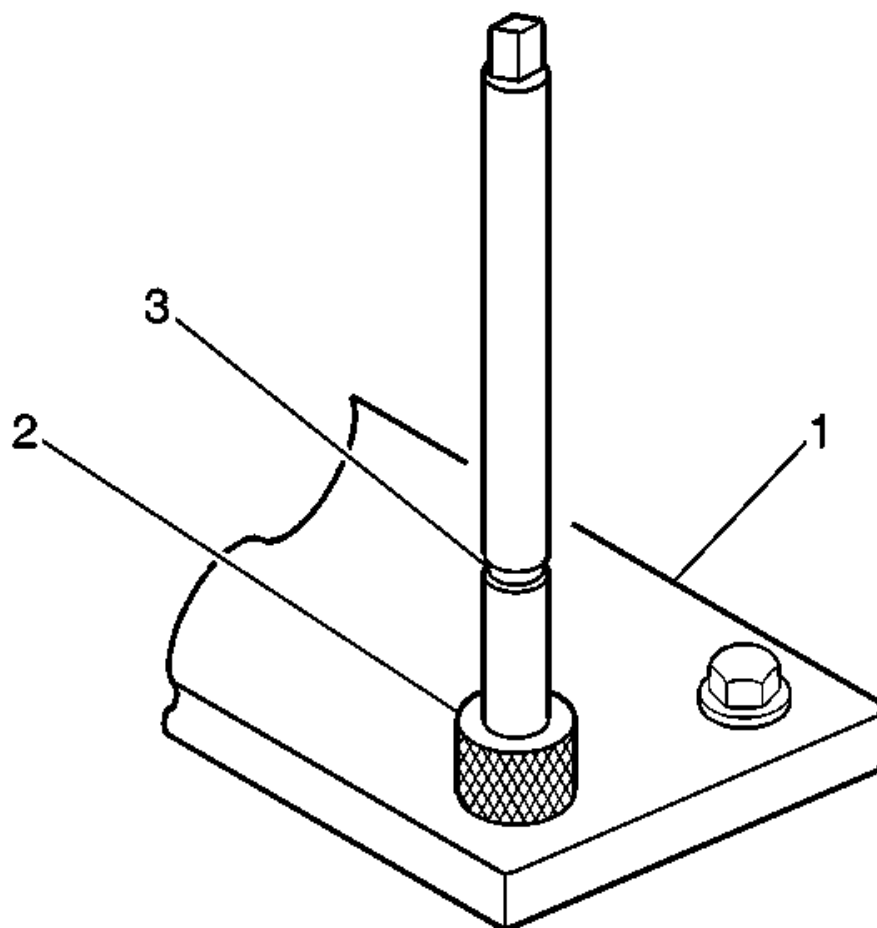


Fig. 425: View Of Fixture Plate, Drill Bushing & Tool Marking
Courtesy of GENERAL MOTORS CORP.

7. Using a tap wrench, tap the threads of the drilled hole.

In order to tap the new threads to the proper depth, rotate the tap into the hole until the mark (3) on the tap aligns with the top of the bushing (2).

8. Using compressed air, clean out any chips.
9. Spray cleaner GM P/N 12346139 (Canadian P/N 10953463) or equivalent, into the hole.
10. Using compressed air, clean any cutting oil and chips out of the hole.

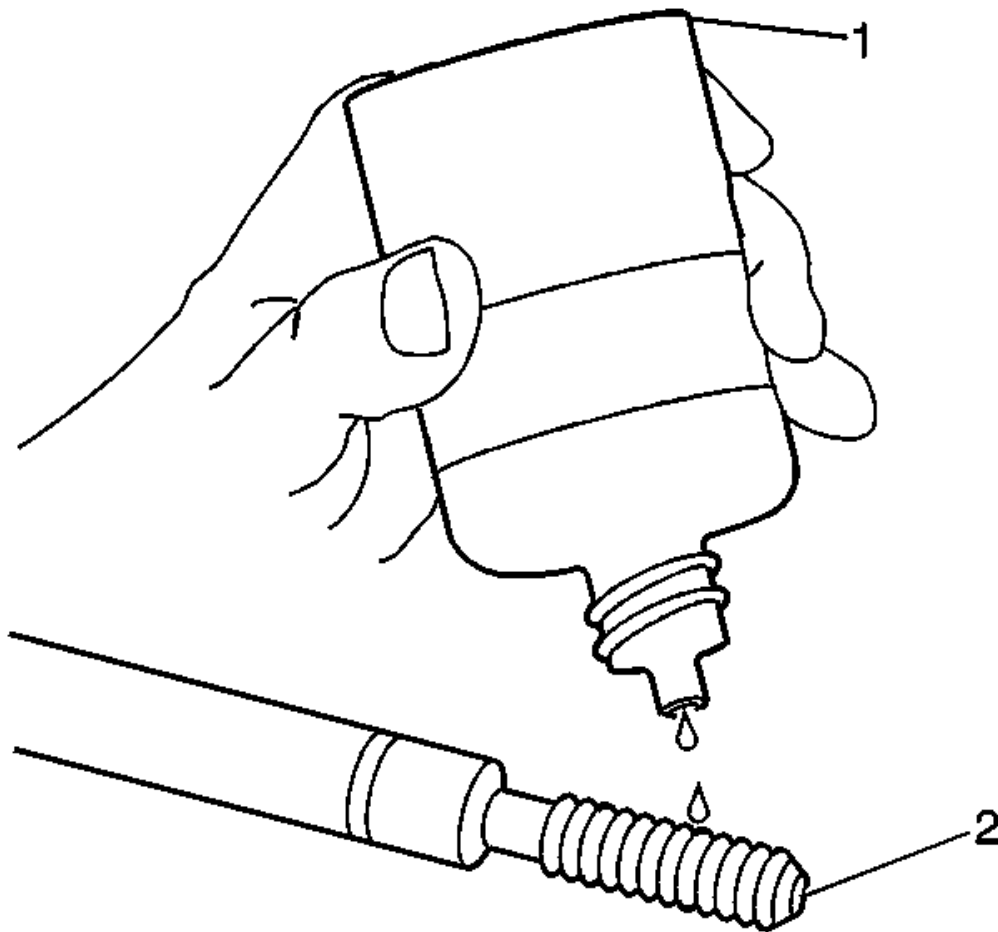


Fig. 426: Lubricating Installer Tool Using Driver Oil
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not allow oil or other foreign material to contact the outside diameter (OD) of the insert.

11. Lubricate the threads of the installer tool (2) with the driver oil (1).

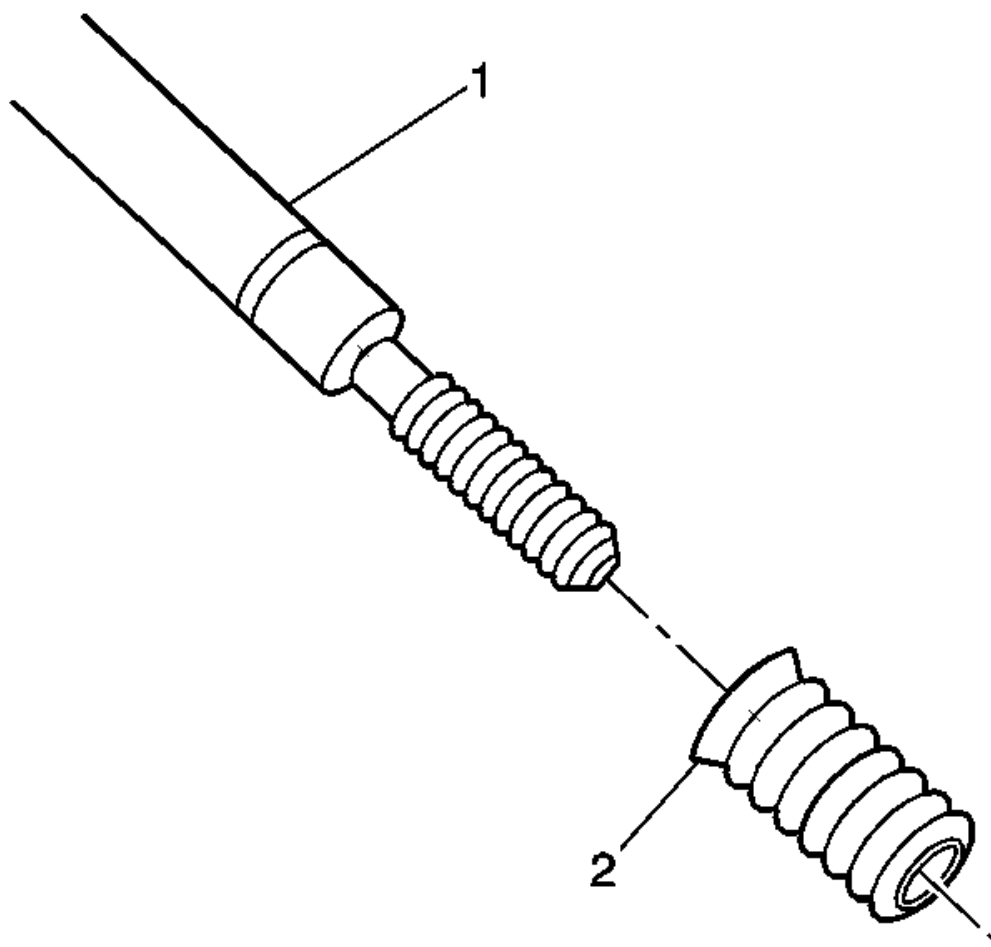


Fig. 427: View of Bushing Type Insert
Courtesy of GENERAL MOTORS CORP.

12. Install the insert (2) onto the driver tool (1).

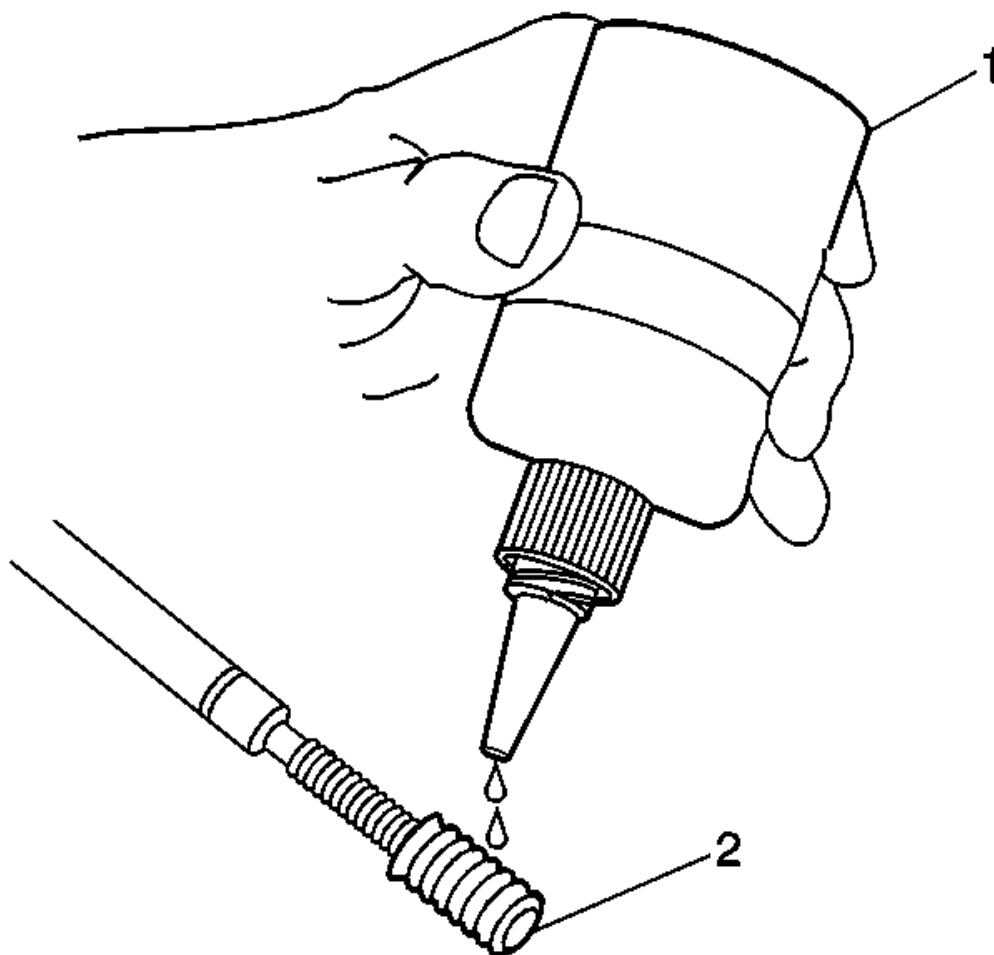


Fig. 428: Applying Threadlock To Insert
Courtesy of GENERAL MOTORS CORP.

13. Apply threadlock LOCTITE™ 277, J 42385-109 (1), or equivalent to the insert OD threads (2).

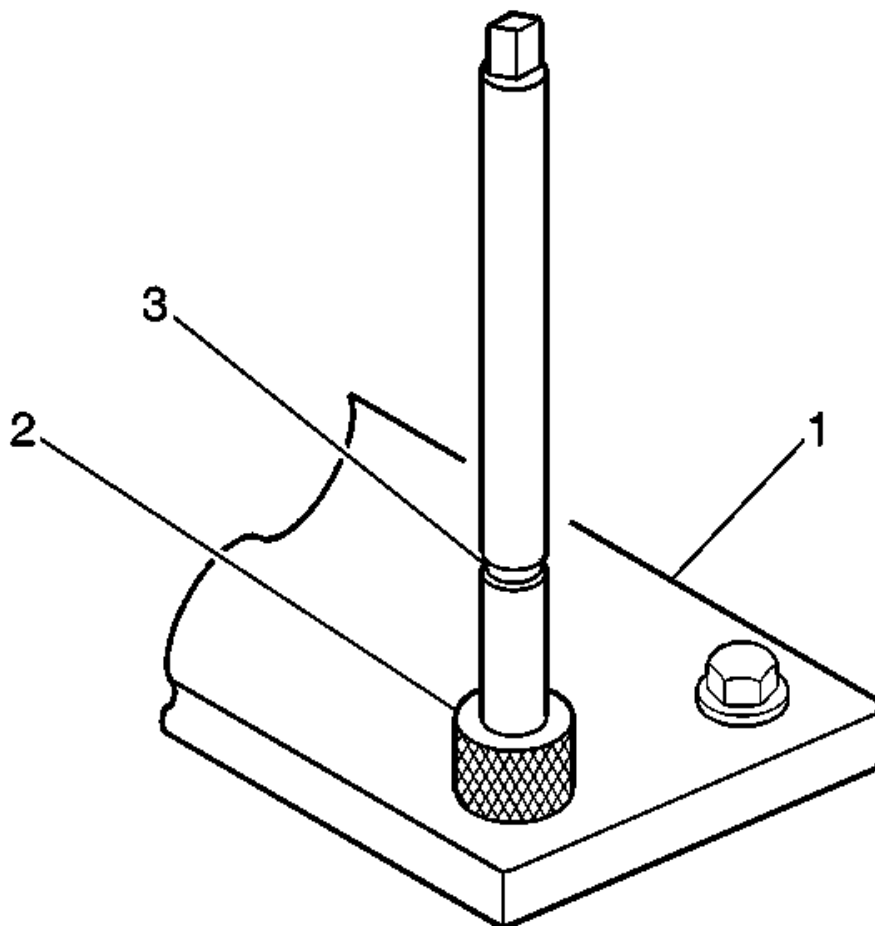


Fig. 429: View Of Fixture Plate, Drill Bushing & Tool Marking
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: The fixture plate and bushing remains installed onto the engine block during the insert installation procedure.

14. Install the insert and driver through the bushing (2), fixture plate (1) and into the hole.

Rotate the driver tool until the mark on the tool (3) aligns with the top of the bushing (2).

The installer tool will tighten up before screwing completely through the insert. This is acceptable. You are forming the bottom threads of the insert and mechanically locking the insert to the base material threads.

15. Remove the driver, bushing (2), fixture plate (1), and bolts.

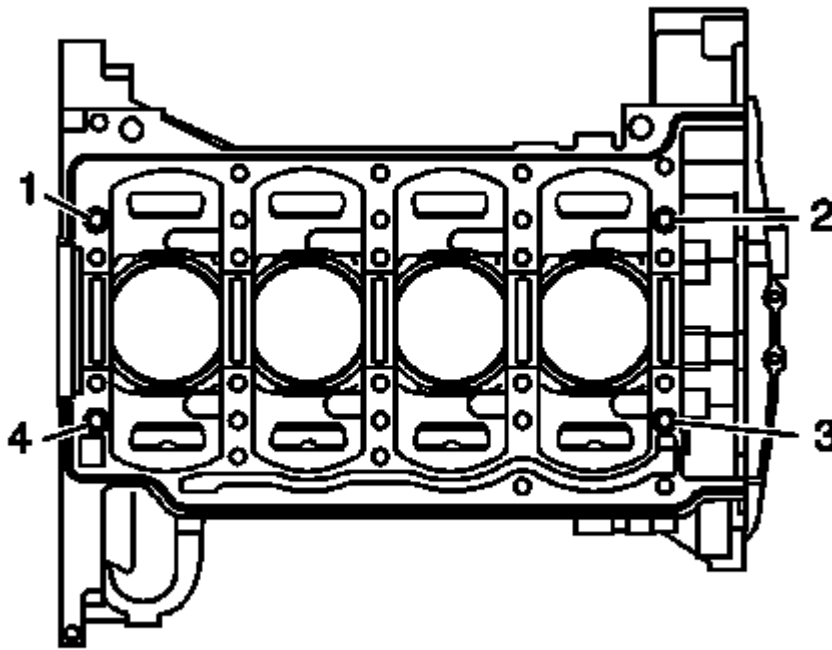


Fig. 430: Identifying Alignment Dowel Pins
Courtesy of GENERAL MOTORS CORP.

16. Install the alignment dowel pins in holes (1-4), if necessary.

SERVICE PRIOR TO ASSEMBLY

The importance of cleanliness during assembly cannot be overstated. Dirt or debris will cause engine damage. An automobile engine is a combination of many machined, honed, polished and lapped surfaces with tolerances that are measured in ten thousandths of an inch. When any internal engine parts are serviced, care and cleanliness are important. A liberal coating of engine oil should be applied to friction areas during assembly in order to protect and lubricate the surfaces on initial operation. Throughout this section, it should be understood that proper cleaning and protection of machined surfaces and friction areas are part of the repair procedure. This is considered standard shop practice even if not specifically stated.

Lubricate all moving parts with engine oil or a specified assembly lubricant. This will provide lubrication for initial start up.

ENGINE BLOCK ASSEMBLE

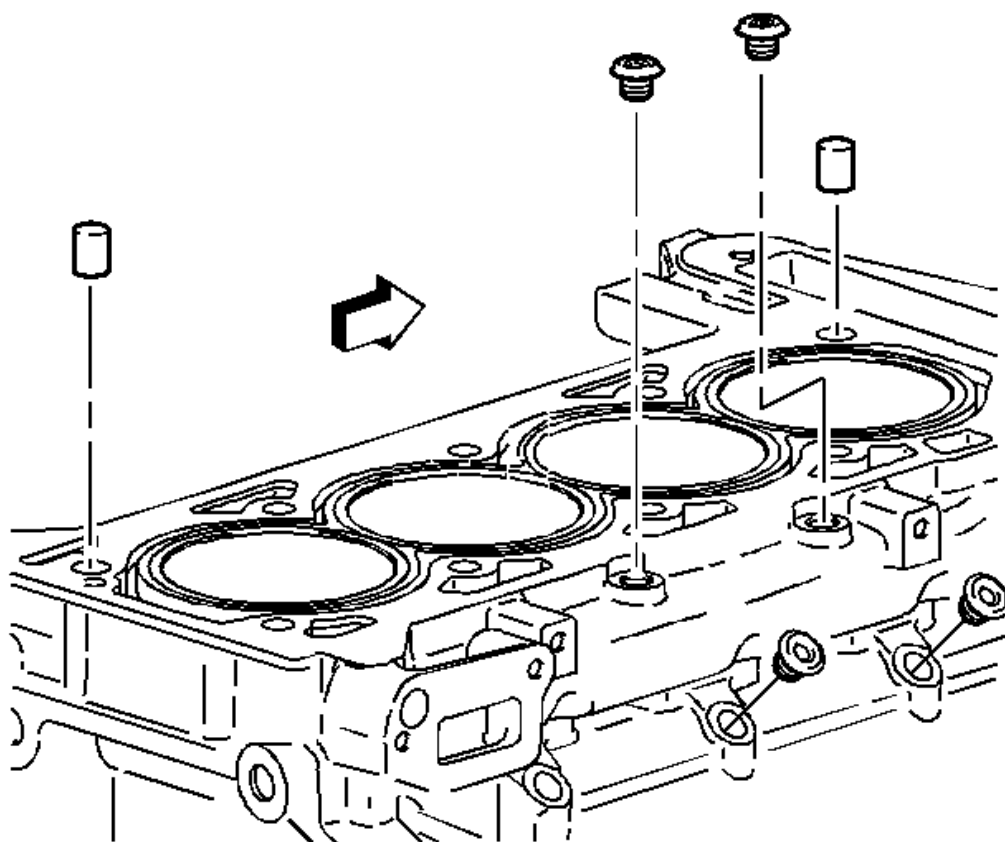


Fig. 431: View Of Oil Passage Plug, Oil Flow Check Valve & Water Jacket Drain Plug
 Courtesy of GENERAL MOTORS CORP.

1. Install the drain plug in the water pump.
2. Apply sealer GM P/N 12346004 (Canadian P/N 10953480) to the plug before installation.

NOTE: Refer to **FASTENER NOTICE** .

3. Install the coolant jacket plugs.

Tighten: Tighten the coolant jacket plug to 35 N.m (26 lb ft).

4. Install the rear oil passage plugs.
5. Apply sealer GM P/N 12346004 (Canadian P/N 10953480) to the plugs before installation.

Tighten: Tighten the oil passage plug to 60 N.m (44 lb ft).

6. Install the other oil passage plugs.
7. Apply sealer GM P/N 12346004 (Canadian P/N 10953480) to the plug before installation.

Tighten: Tighten the oil passage plugs to 35 N.m (26 lb ft).

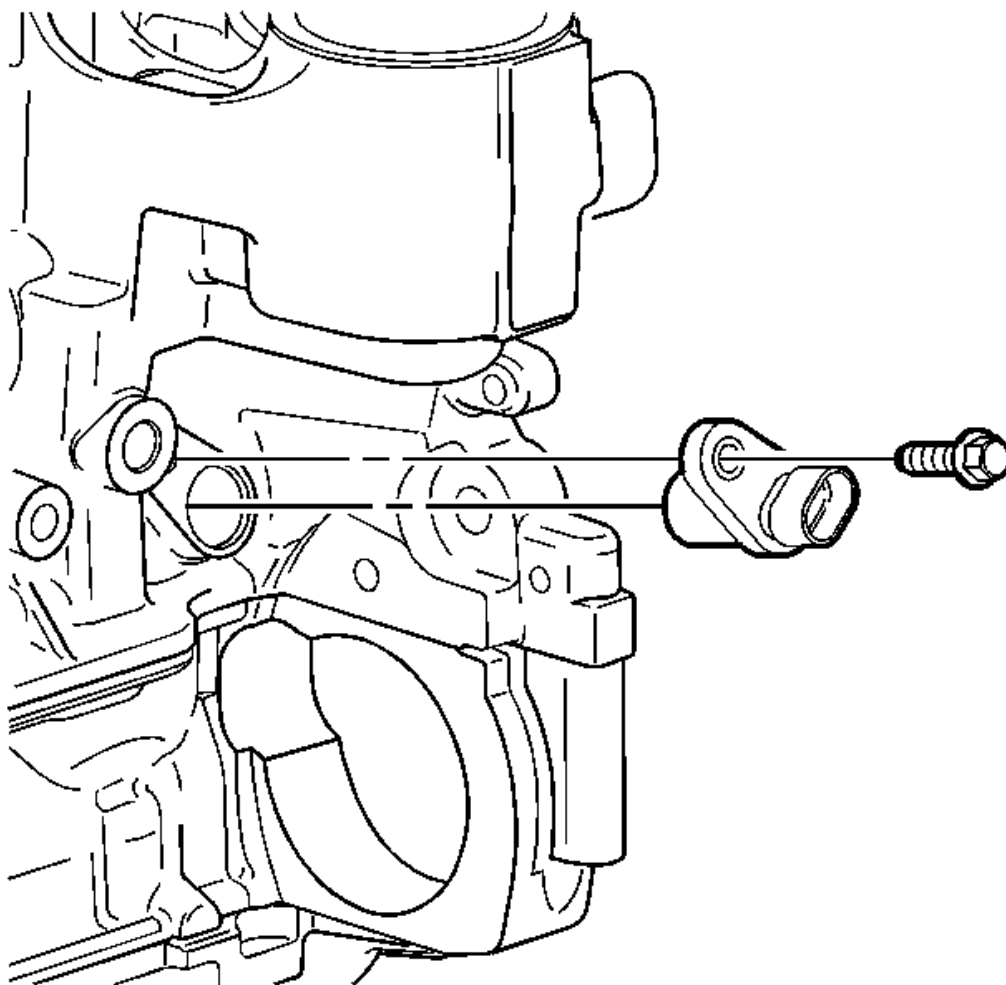


Fig. 432: View Of Crankshaft Position Sensor
Courtesy of GENERAL MOTORS CORP.

8. Lubricate the crankshaft position sensor O-ring with engine oil.
9. Install the crankshaft position sensor and bolt.

Tighten: Tighten the crankshaft position sensor bolt to 10 N.m (89 lb in).

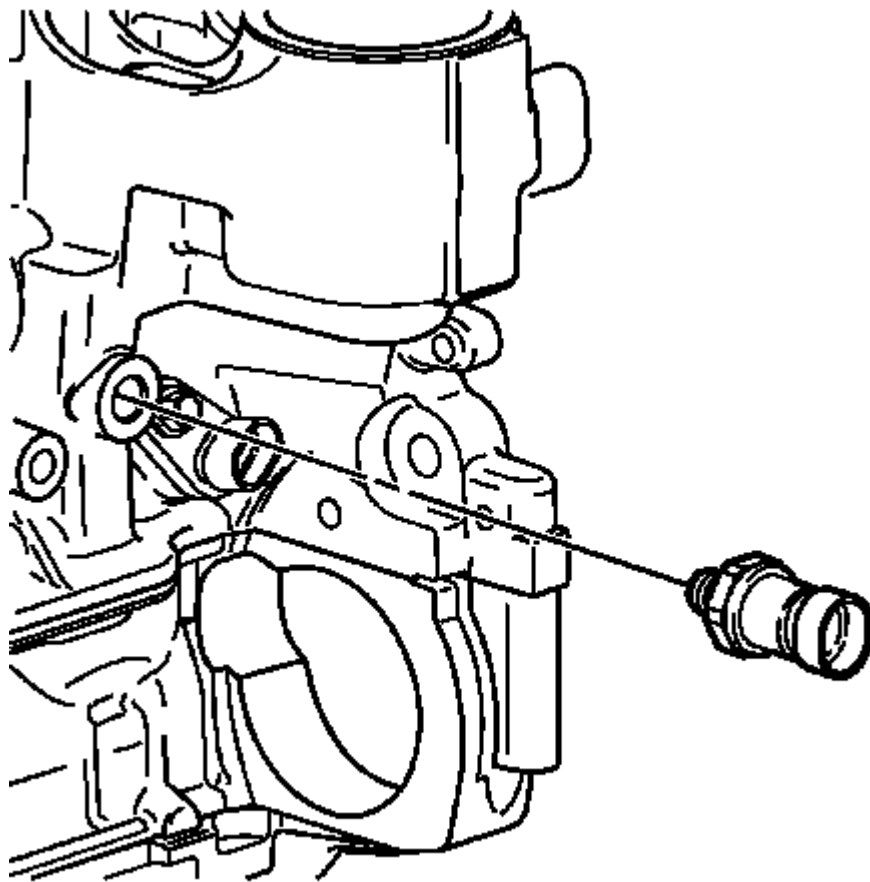


Fig. 433: View Of Engine Oil Pressure Sensor
Courtesy of GENERAL MOTORS CORP.

10. Install the oil pressure switch.

Tighten: Tighten the oil pressure switch to 26 N.m (19 lb ft).

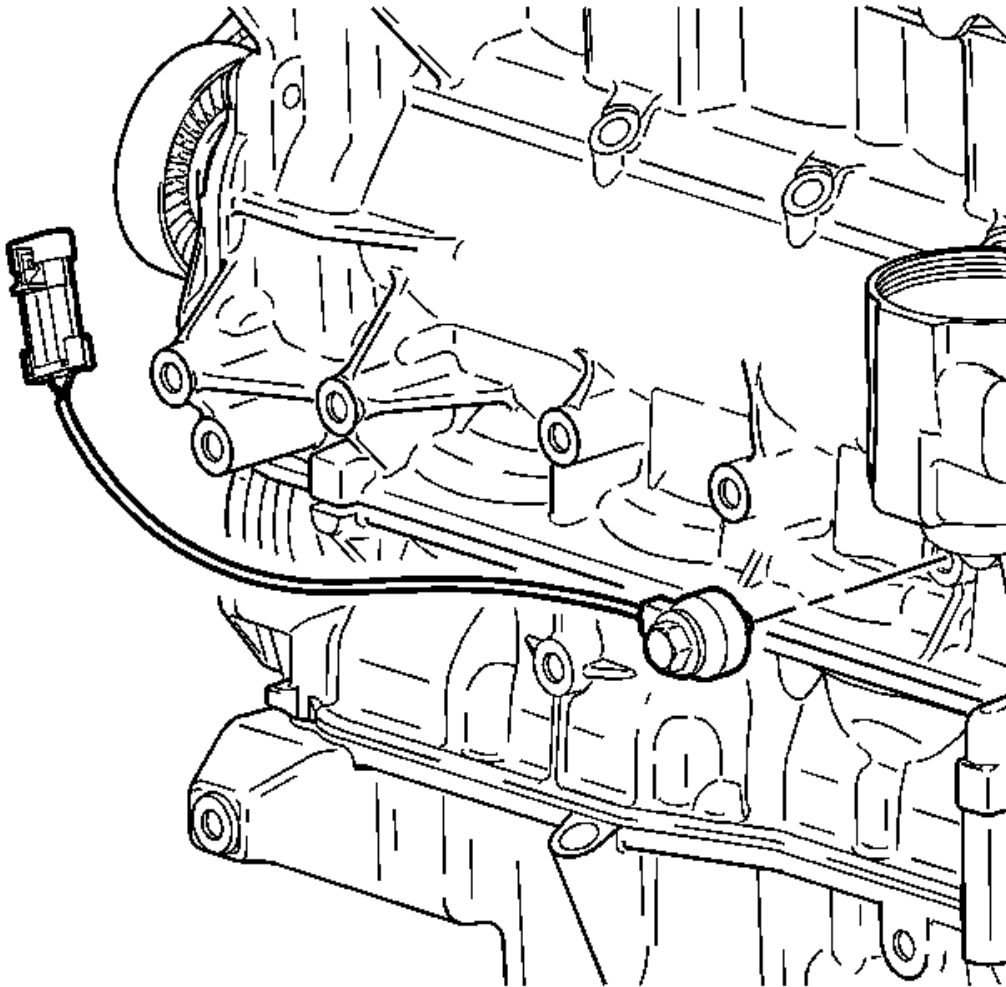


Fig. 434: View of Knock Sensor
Courtesy of GENERAL MOTORS CORP.

11. Install the knock sensor and bolt.

Tighten: Tighten the knock sensor bolt to 25 N.m (18 lb ft).

CRANKSHAFT AND BEARING INSTALLATION

Tools Required

- **J 8087** Cylinder Bore Checking Gage
- **J 45059** Angle Meter

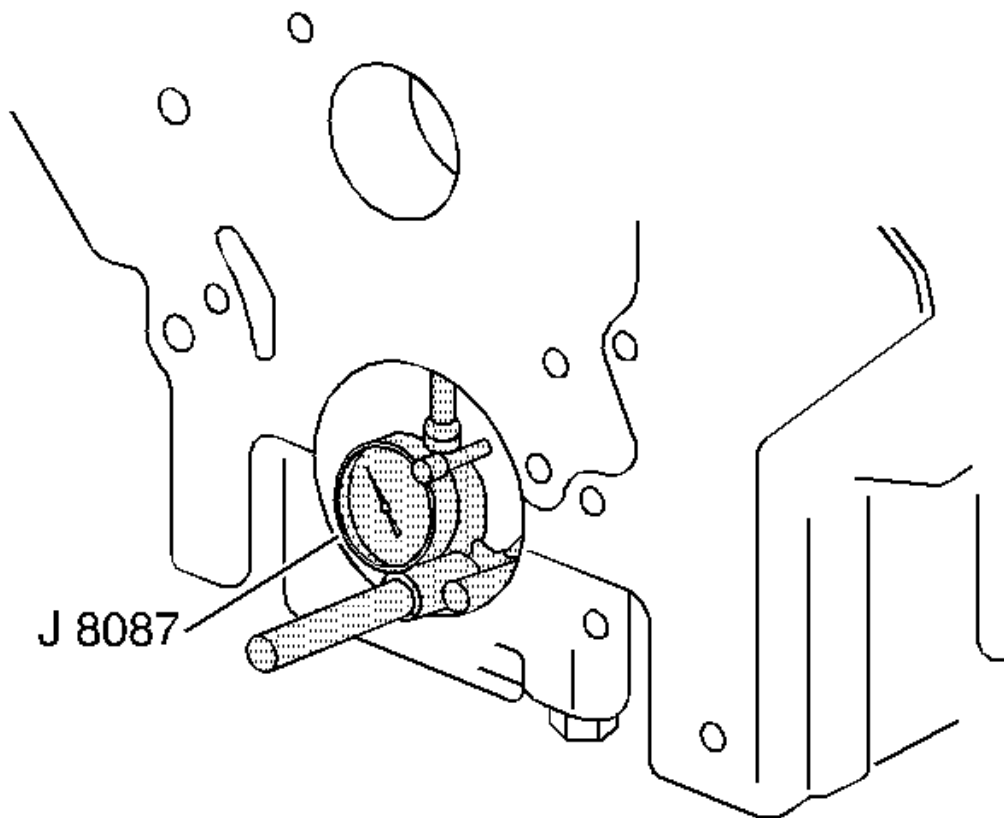


Fig. 435: Inspecting Crankshaft Main Bearing Bores
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: If crankshaft bearing failure is due to other than normal wear, investigate the cause. Inspect the crankshaft or connecting rod bearing bores.

Inspect the connecting rod bearing bores or crankshaft main bearing bores using the following procedure:

- Tighten the bedplate to specification using the **J 45059**.
- Measure the bearing bore for taper and out-of-round using the **J 8087**.
- No taper or out-of-round should exist.

Bearing Selection

1. Measure the bearing clearance to determine the correct replacement bearing insert size. There are 2 methods to measure bearing clearance. Method A gives more reliable results and is preferred.
 - Method A yields measurement from which the bearing clearance can be computed.

- Method B yields the bearing clearance directly. Method B does not give any indication of bearing run-out.

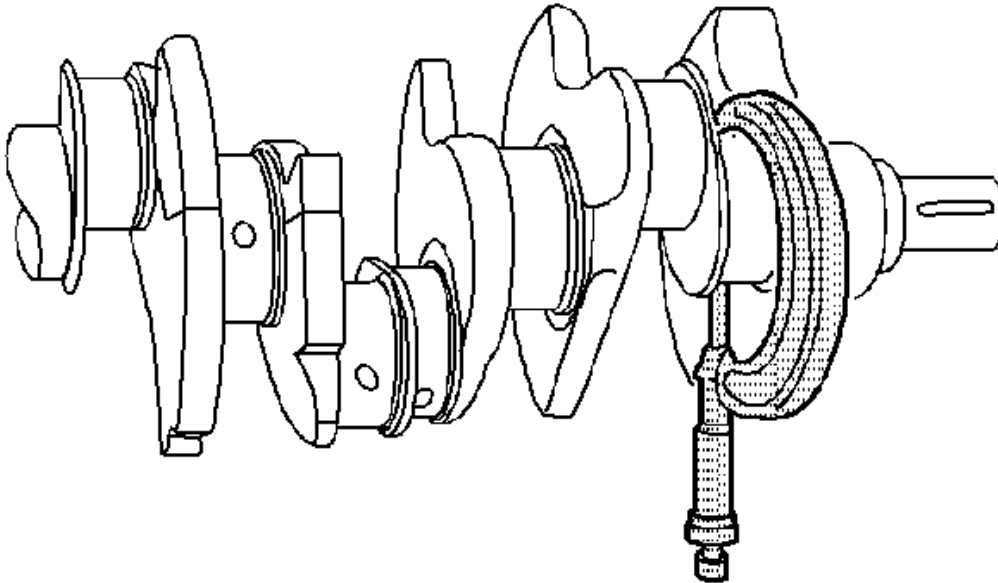


Fig. 436: Measuring Crankshaft Bearing Journal Diameter
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not mix inserts of different nominal size in the same bearing bore.

2. To measure bearing clearance using Method A, use the following procedure:
 1. Measure the crankshaft bearing journal diameter with a micrometer in several places, 90 degrees apart. Average the measurements.
 2. Measure the crankshaft bearing journal taper and runout.
 3. Install the lower crankcase and tighten the bearing cap bolts to specification.
 4. Measure bearing inside diameter (ID) in several places 90 degrees apart, average measurements.
 5. Subtract journal measurement from bearing ID measurement to determine clearance.
 6. Determine whether clearance is within specification.
 7. If out of specification, choose different inserts.
 8. Measure the connecting rod inside diameter in the same direction as the length of the rod with an inside micrometer.
 9. Measure the crankshaft main bearing inside diameter with an inside micrometer.

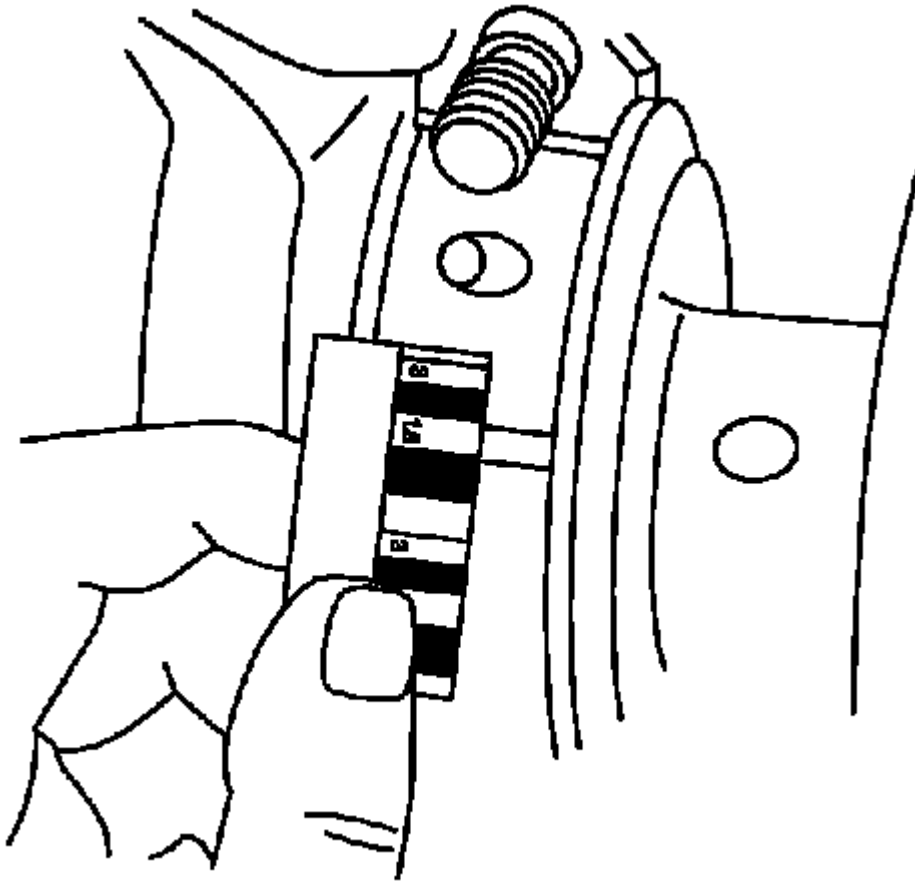


Fig. 437: Measuring Gaging Plastic
Courtesy of GENERAL MOTORS CORP.

3. To measure bearing clearance using Method B, use the following procedure:
 1. Clean the used bearing inserts.
 2. Install the used bearing inserts.
 3. Place a piece of gaging plastic across the entire bearing width.
 4. Install the bearing caps.

NOTE: In order to prevent the possibility of cylinder block or crankshaft bearing cap damage, the crankshaft bearing caps are tapped into the cylinder block cavity using a brass, lead, or a leather mallet before the attaching bolts are installed. Do not use attaching bolts to pull the crankshaft bearing caps into the seats. Failure to use this process may damage a cylinder block or a bearing cap.

5. Install the bearing cap bolts to specification.

IMPORTANT: Do not rotate the crankshaft.

6. Remove the bearing cap, leaving the gaging plastic in place. It does not matter whether the gaging plastic adheres to the journal or to the bearing cap.
7. Measure the gaging plastic at its widest point with the scale printed on the gaging plastic package.
8. Remove the gaging plastic.

LOWER CRANKCASE INSTALLATION

Tools Required

J 45059 Angle Meter

Installation Procedure

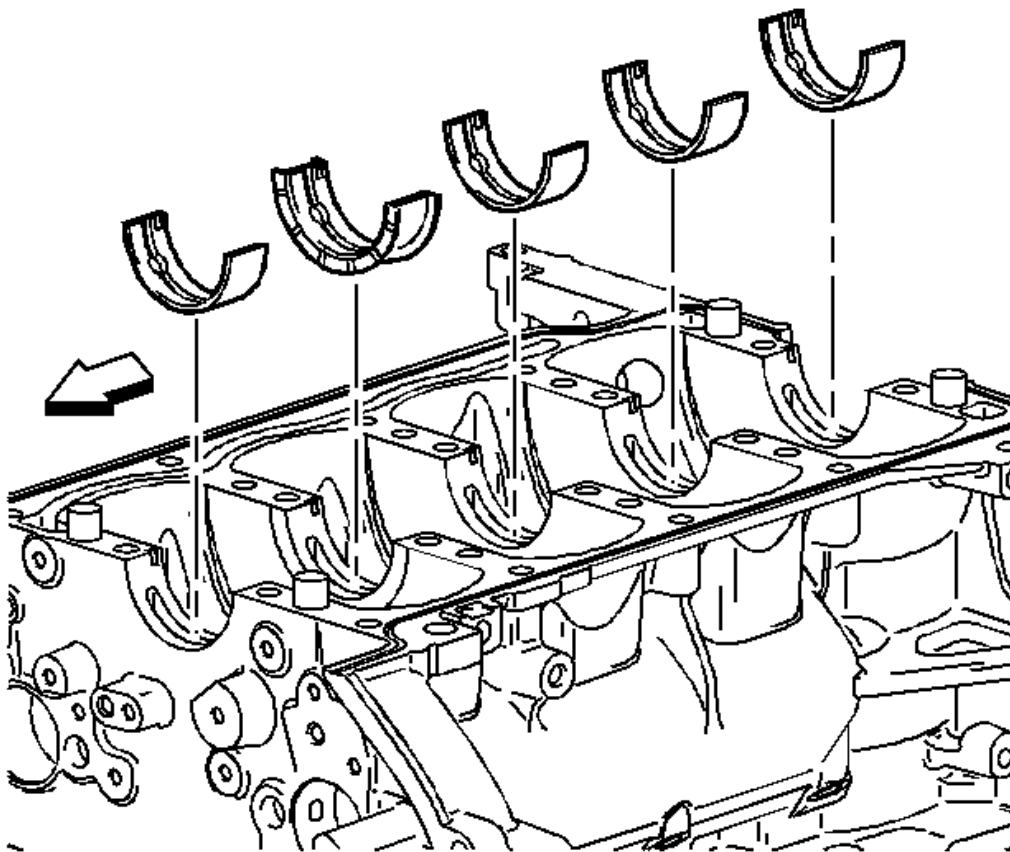


Fig. 438: View Of Crankshaft Bearing Inserts
Courtesy of GENERAL MOTORS CORP.

1. Install the upper crankshaft bearings and lubricate bearing surfaces with engine oil.

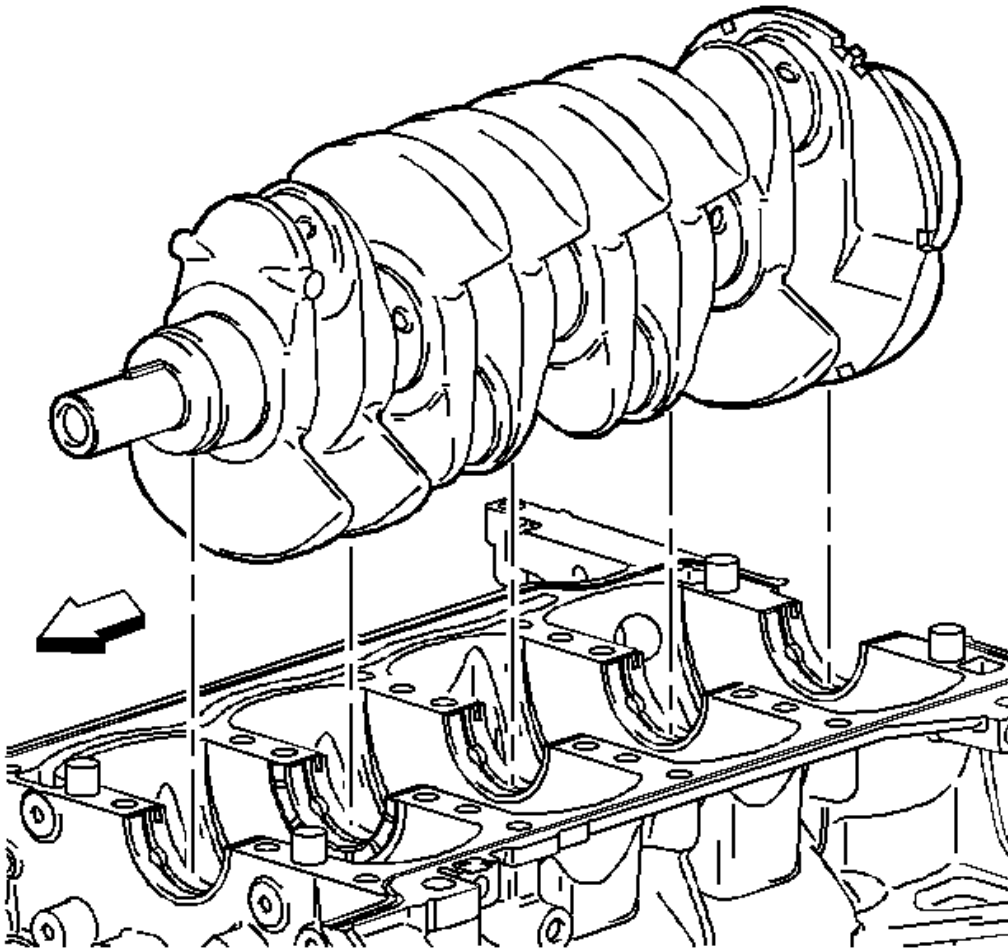


Fig. 439: Installing Crankshaft On Journals
Courtesy of GENERAL MOTORS CORP.

2. Install the crankshaft on the journals.

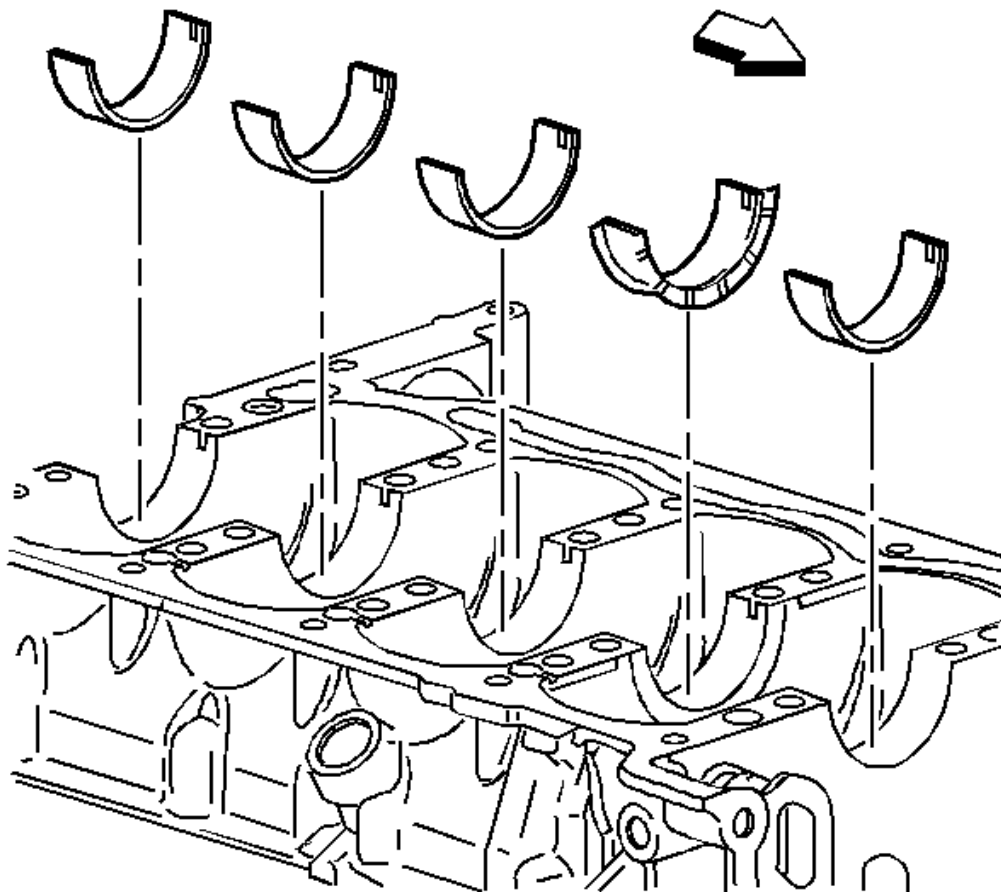


Fig. 440: Identifying Crankshaft Bearing Inserts
Courtesy of GENERAL MOTORS CORP.

3. Install the lower bearing halves, without grooves, into the lower crankcase. Apply oil to bearing surfaces.

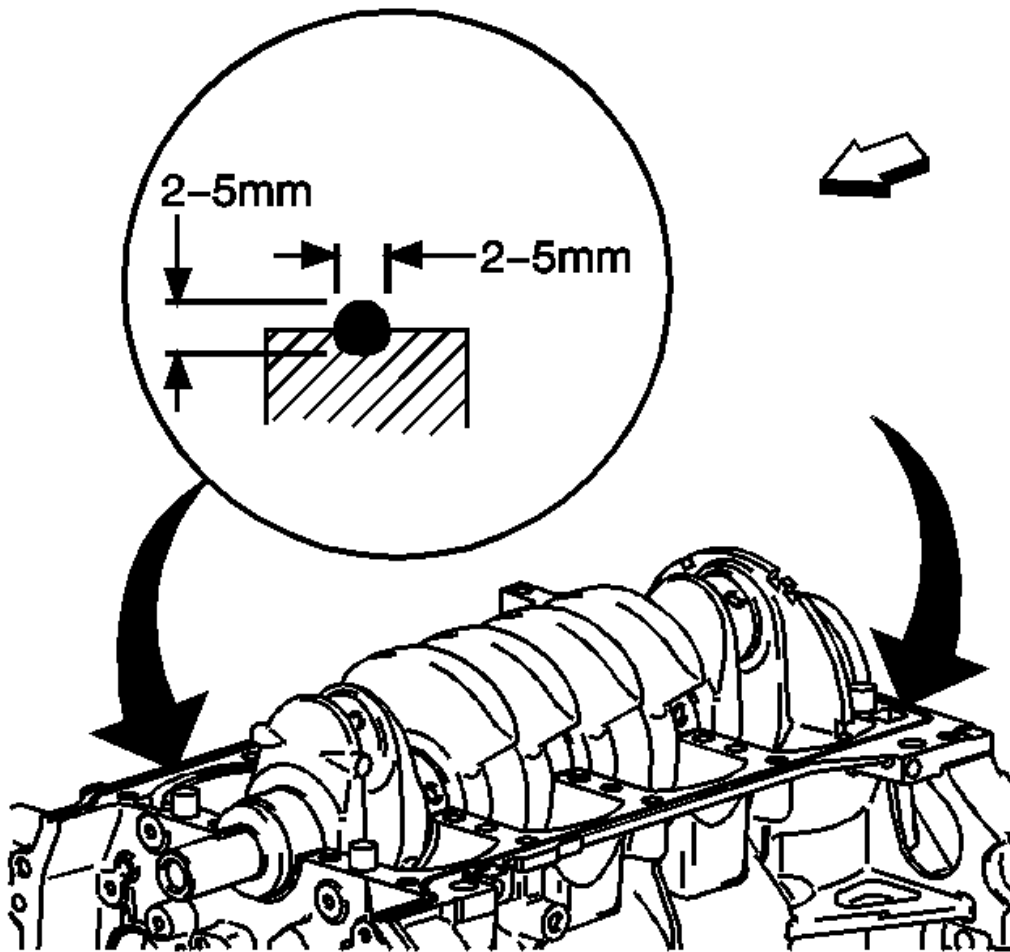


Fig. 441: Applying Sealer To Engine Block Bedplate Mating Surfaces
Courtesy of GENERAL MOTORS CORP.

4. Apply sealer GM P/N 12378521 (Canadian P/N 88901148) to the surfaces of the engine block to bedplate mating surfaces.

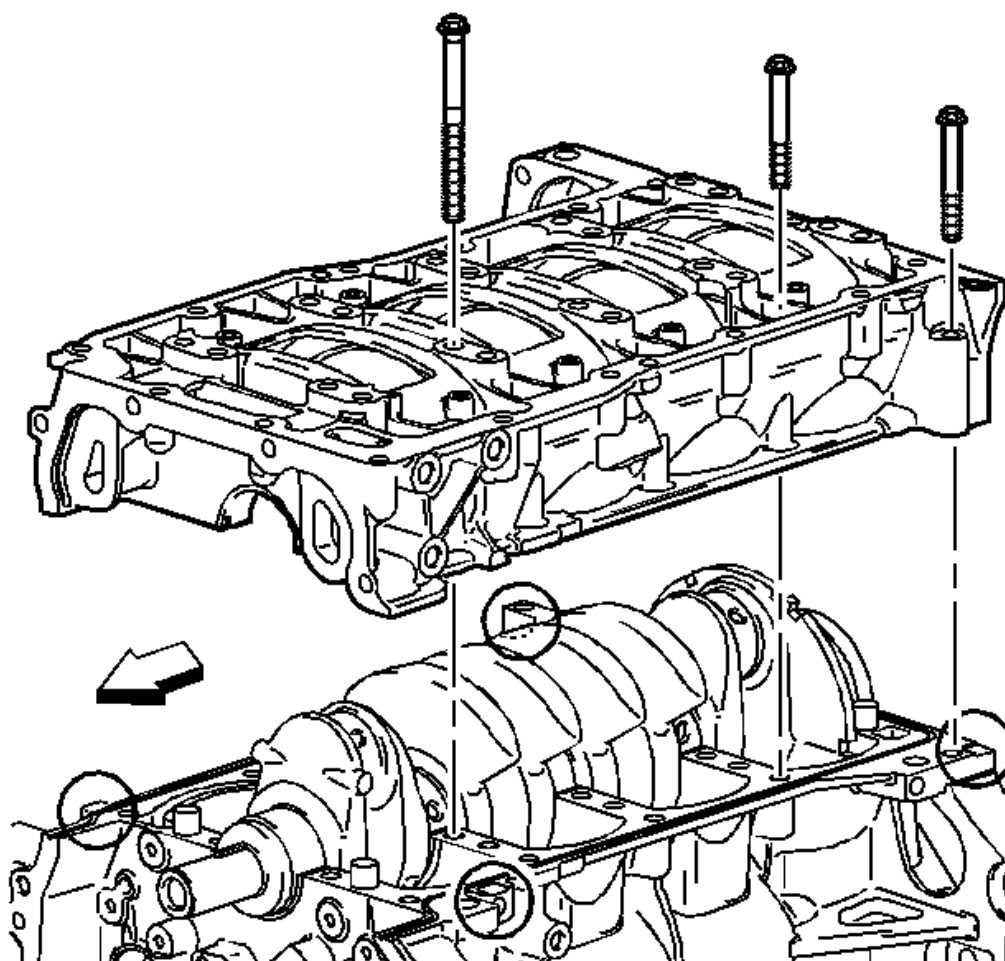


Fig. 442: View Of Upper & Lower Crankcase W/Bolts
Courtesy of GENERAL MOTORS CORP.

5. Install the lower crankcase. Tap gently into place with a suitable tool if necessary. Ensure it is aligned properly on the dowels.

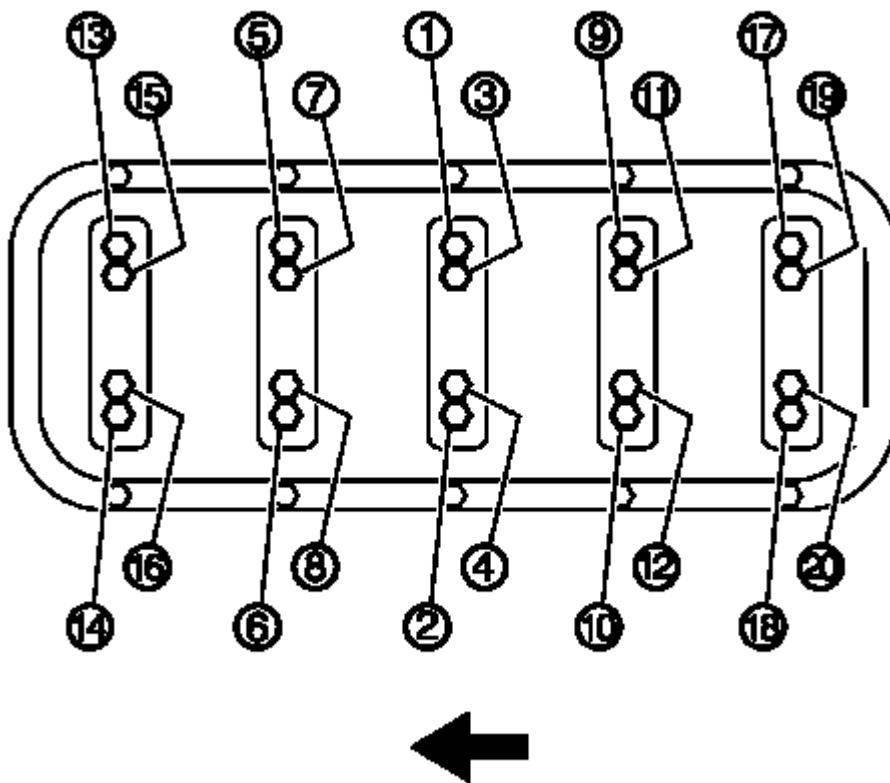


Fig. 443: Identifying Crankshaft Bearing Bolt Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

6. Install the NEW crankshaft bearing bolts in sequence finger tight.
 1. Tighten the crankshaft bearing bolts in sequence.

Tighten: Tighten the crankshaft bearing bolts to 20 N.m (15 lb ft).

2. Tighten the crankshaft bearing bolts in sequence using the **J 45059** .

Tighten: Tighten the crankshaft bearing bolts 70 degrees using the torque angle meter.

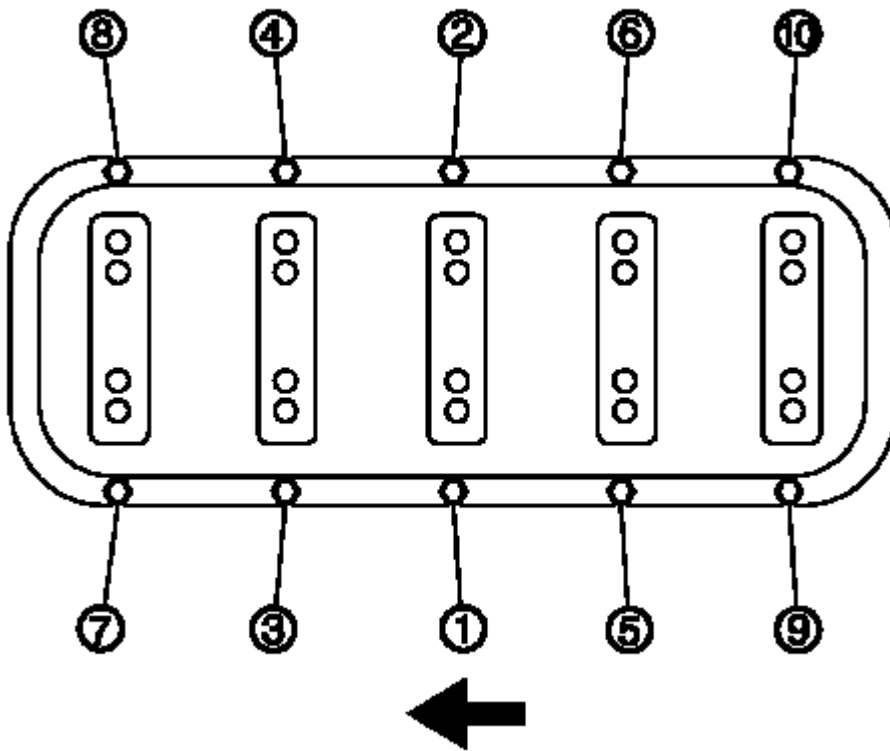


Fig. 444: Lower Crankcase Perimeter Bolt Tightening Sequence
 Courtesy of GENERAL MOTORS CORP.

7. Tighten the lower crankcase perimeter bolts in sequence.

Tighten: Tighten the lower crankcase perimeter bolts to 25 N.m (18 lb ft).

CRANKSHAFT REAR OIL SEAL INSTALLATION

Tools Required

J 42067 Rear Crankshaft Seal Installer

Installation Procedure

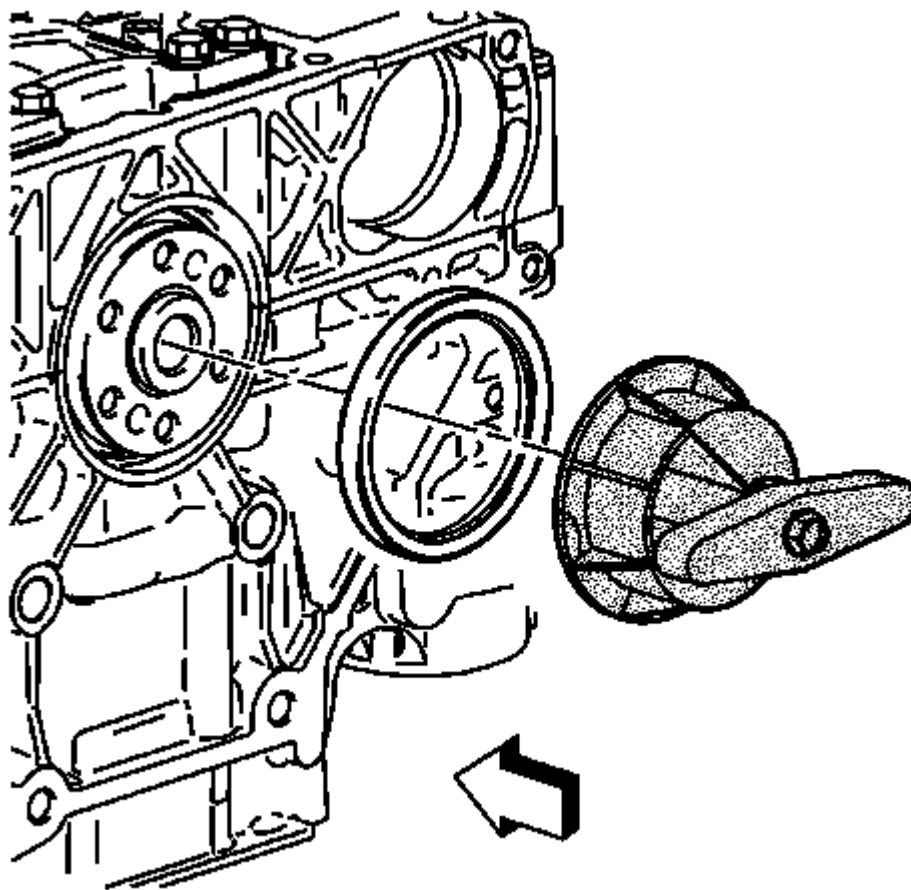


Fig. 445: Installing Crankshaft Rear Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Remove excess sealer from seal recess.
2. Lubricate the outside diameter of the new crankshaft seal with clean engine oil.
3. Using the **J 42067** , press the new crankshaft seal into the housing. The **J 42067** also establishes the depth of the seal in the crankshaft seal bore.

PISTON, CONNECTING ROD, AND BEARING INSTALLATION

Tools Required

- **J 43953** Piston Ring Compressor. See **Special Tools**.
- **J 45059** Angle Meter
- **J-43966-1 / J 41742** Connecting Rod Guides. See **Special Tools**.

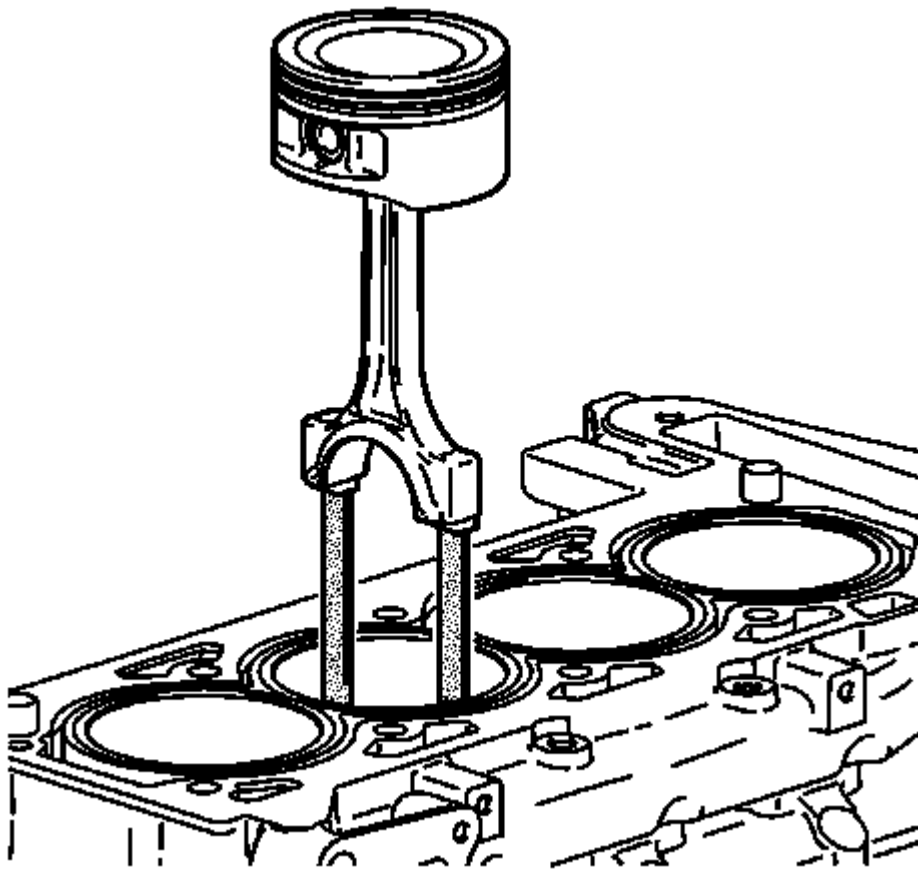


Fig. 446: J-43966-1 Installed On Connecting Rod Bolts
 Courtesy of GENERAL MOTORS CORP.

1. Install the connecting rod bearings. Use the proper size bearings.
 1. Install the bearing inserts into the connecting rod and the connecting rod cap.
 2. Lubricate the connecting rod bearings with engine oil.
2. Install the **J-43966-1 / J 41742** into the connecting rod bolt holes. See **Special Tools**. This protects the crankshaft journal during piston and connecting rod installation.
3. Install the piston and the connecting rod to the correct bore.
 1. Stagger each piston ring end gap equally around the piston.
 2. Lubricate the piston and the piston rings with engine oil.
 3. Install **J 43953** over the piston. See **Special Tools**. Do not disturb the piston ring end gap location.
 4. The piston must be installed so that the mark on the top of the piston faces the front of the engine.
 5. Place the piston in its matching bore.
 6. Tap the piston into its bore with a hammer handle. Guide the connecting rod to the connecting rod journal while tapping the piston into place.
 7. Hold the **J 43953** against the engine block until all the rings have entered the cylinder bore. See **Special Tools**.
 8. Remove the connecting rod guides from the connecting rod bolt holes.

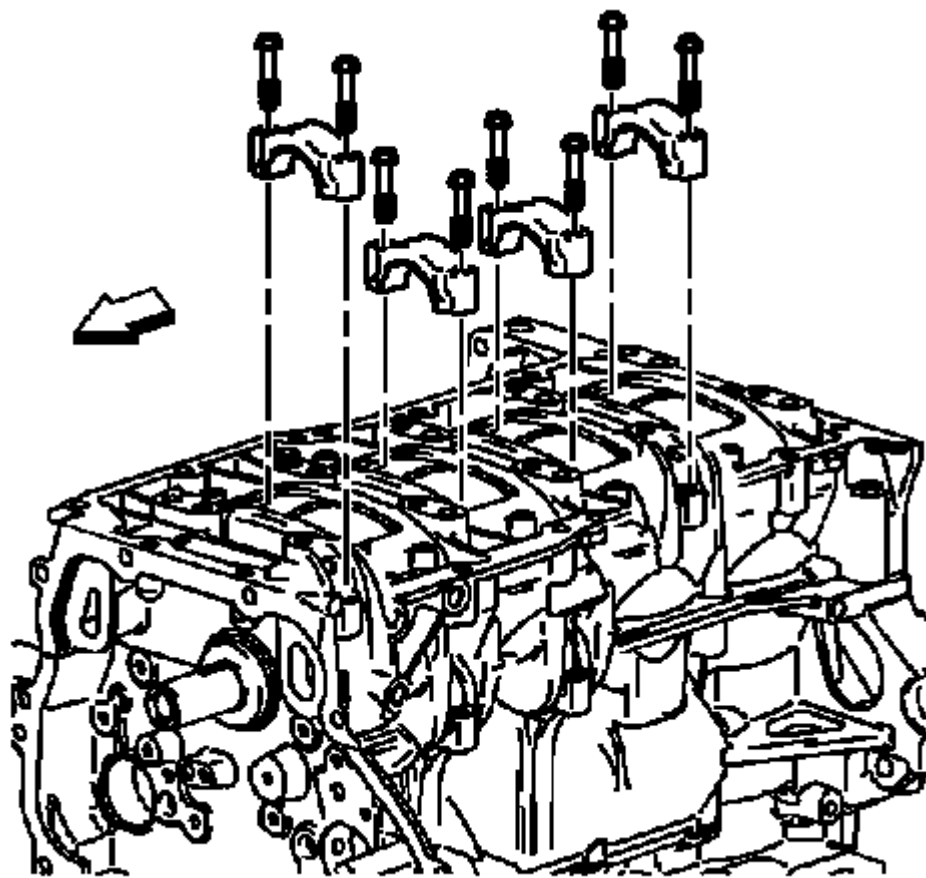


Fig. 447: View Of Connecting Rod Nuts And Caps
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Ensure that the connecting rod cap is properly oriented on the connecting rod.

4. Install the connecting rod cap.

NOTE: Refer to **FASTENER NOTICE** .

5. Install the connecting rod bolts. Always use new bolts.

Tighten: Tighten the connecting rod bolt nuts to 25 N.m (18 lb ft), plus 100 degrees using **J 45059** .

6. Install the remaining connecting rods and piston assemblies.

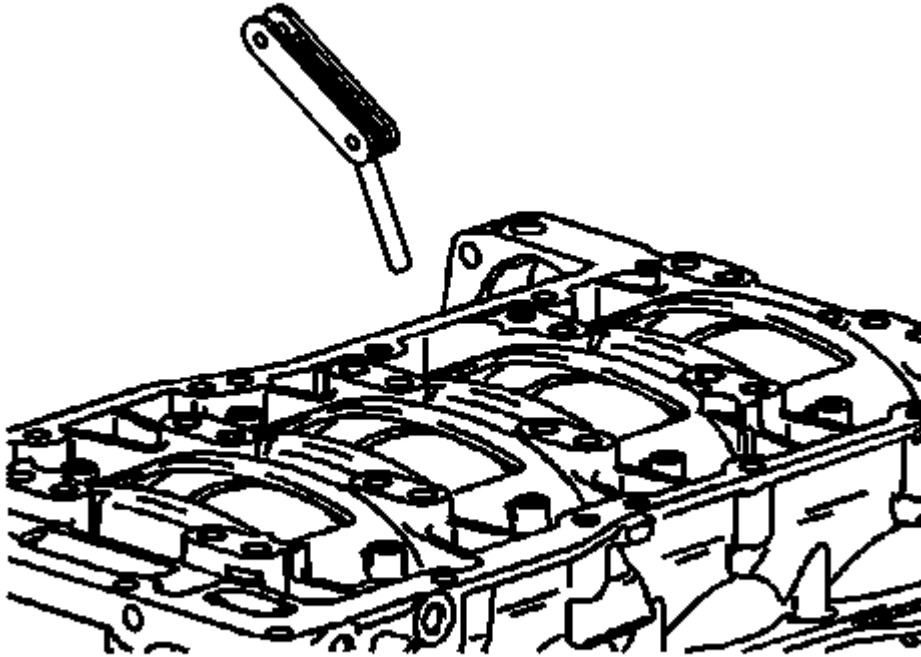


Fig. 448: Measuring Connecting Rod Side Clearance
Courtesy of GENERAL MOTORS CORP.

7. Measure the connecting rod side clearance with a feeler gage.

The correct clearance is 0.070-0.370 mm (0.0027-0.0145 in).

CYLINDER HEAD INSTALLATION

Tools Required

J 45059 Angle Meter

Installation Procedure

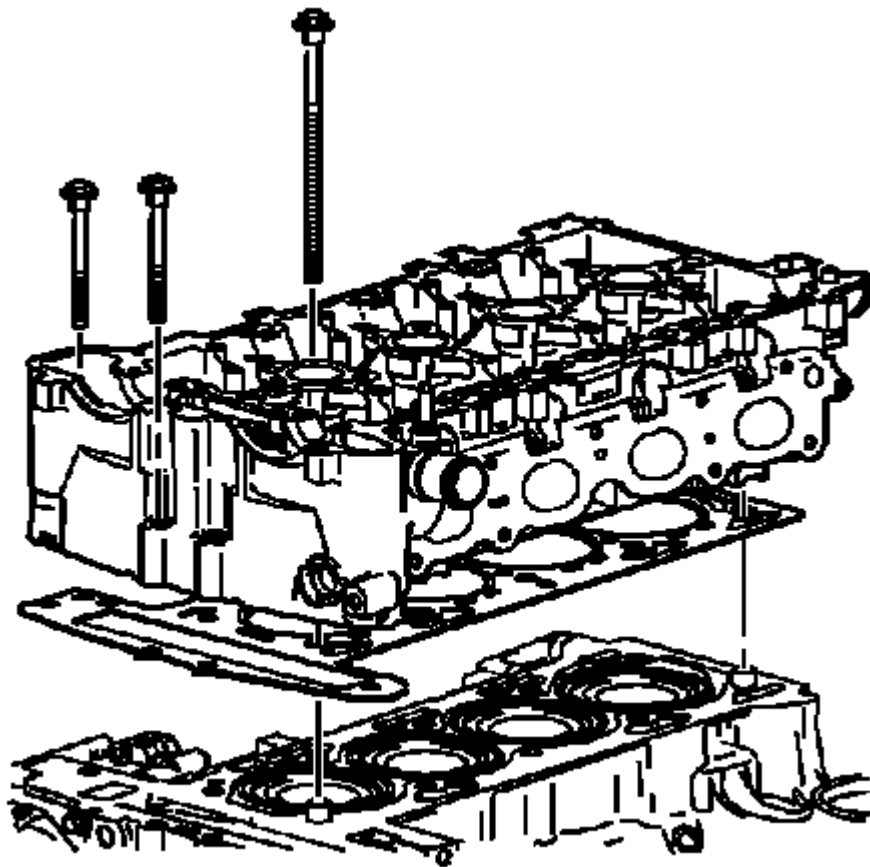


Fig. 449: View Of Cylinder Head And Gasket
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Do not use any sealing material.

1. Install the cylinder head gasket to the block.
2. Install the cylinder head.

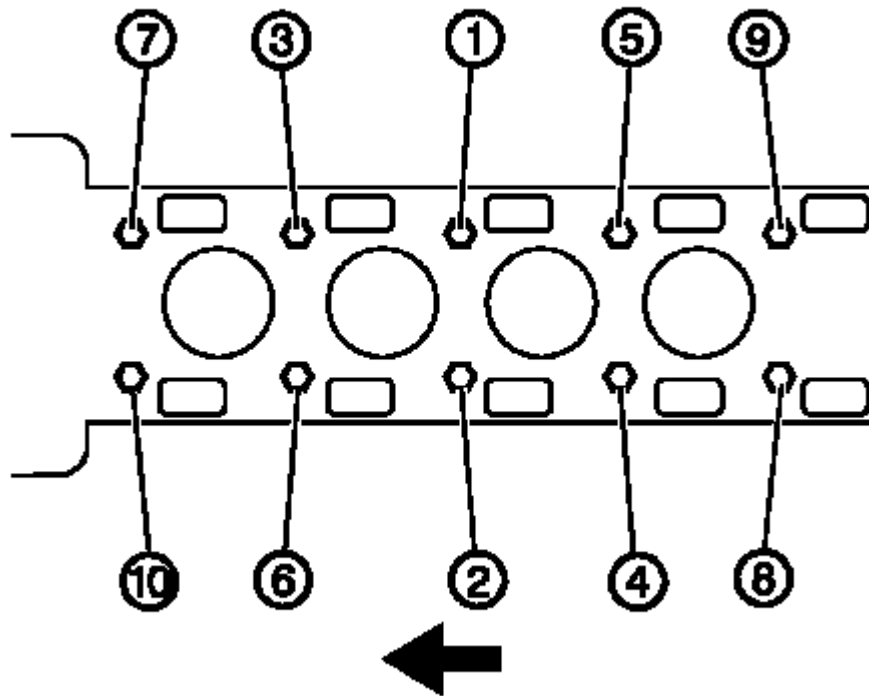


Fig. 450: Identifying Cylinder Head Bolt Tightening Sequence
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Always use new cylinder head bolts.

NOTE: Refer to FASTENER NOTICE .

3. Install and tighten the cylinder head bolts in sequence.

Tighten:

- Tighten the bolts to 30 N.m (22 lb ft).
- Then turn all the bolts 155 degrees in sequence. Use the **J 45059** .

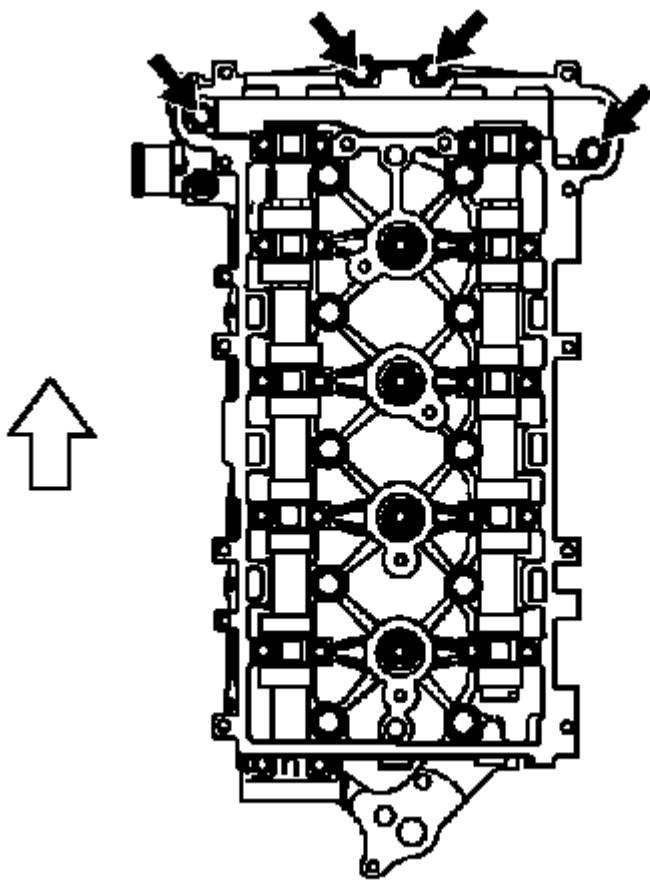


Fig. 451: Locating Front Cylinder Head Bolts
Courtesy of GENERAL MOTORS CORP.

4. Install the front cylinder head bolts.

Tighten: Tighten the cylinder head bolts to 35 N.m (26 lb ft).

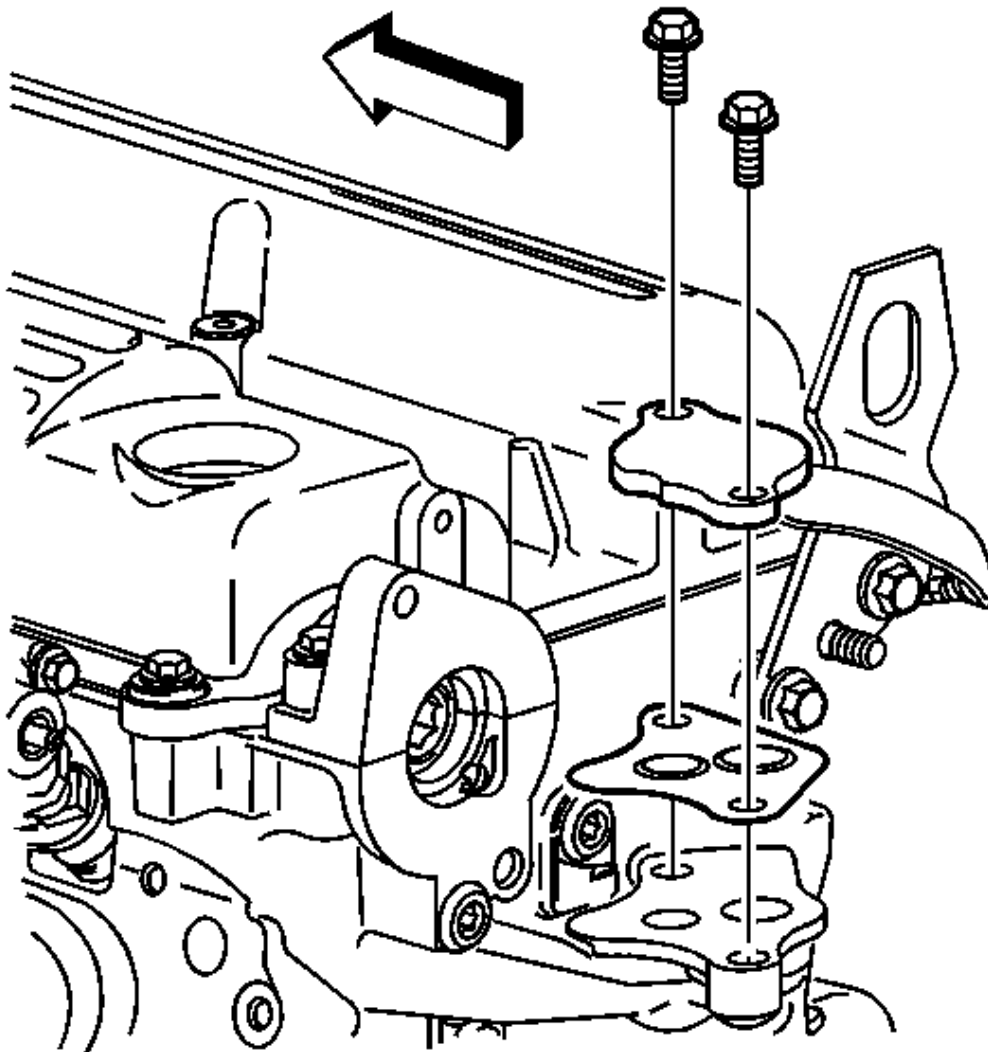


Fig. 452: Identifying EGR Cover, Bolts, And Cover Gasket
Courtesy of GENERAL MOTORS CORP.

5. Install the exhaust gas recirculation (EGR) cover, bolts, and the EGR cover gasket.

Tighten: Tighten the EGR cover bolts to 25 N.m (18 lb ft).

INTAKE CAMSHAFT, BEARING CAP, AND LASH ADJUSTER INSTALLATION

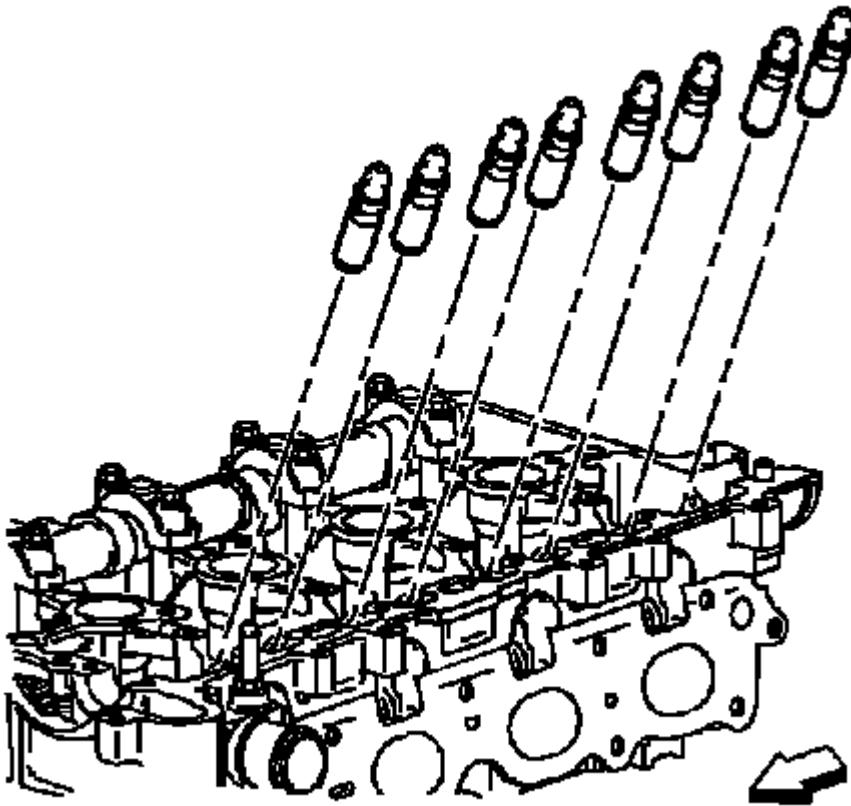


Fig. 453: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

1. Install the hydraulic lash adjusters into their bores in the cylinder head.
2. Lubricate the hydraulic lash adjusters with GM P/N 12345501 (Canadian P/N 992704) or equivalent.

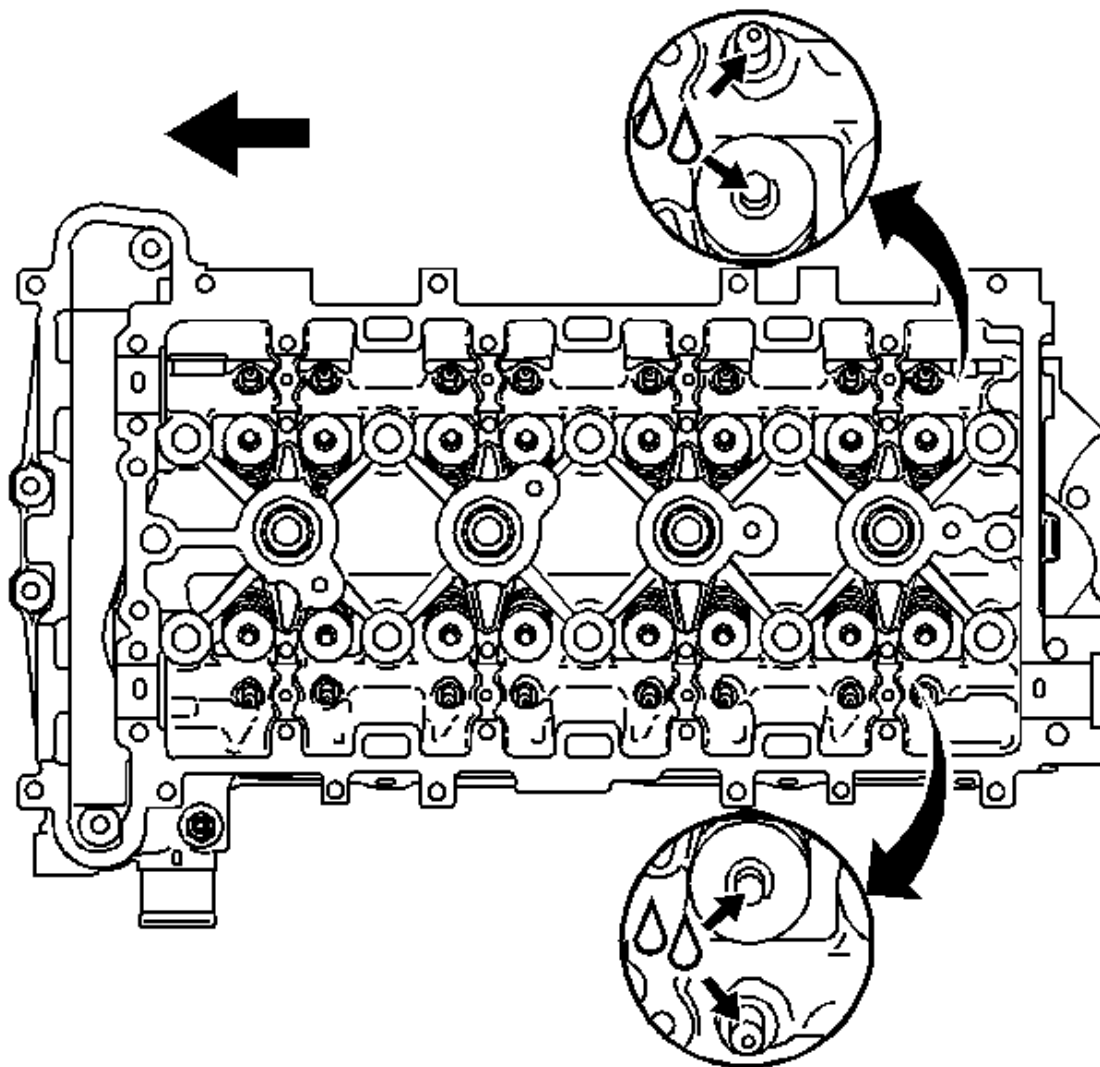


Fig. 454: Lubricating Valve Tips
Courtesy of GENERAL MOTORS CORP.

3. Lubricate the valve tips.

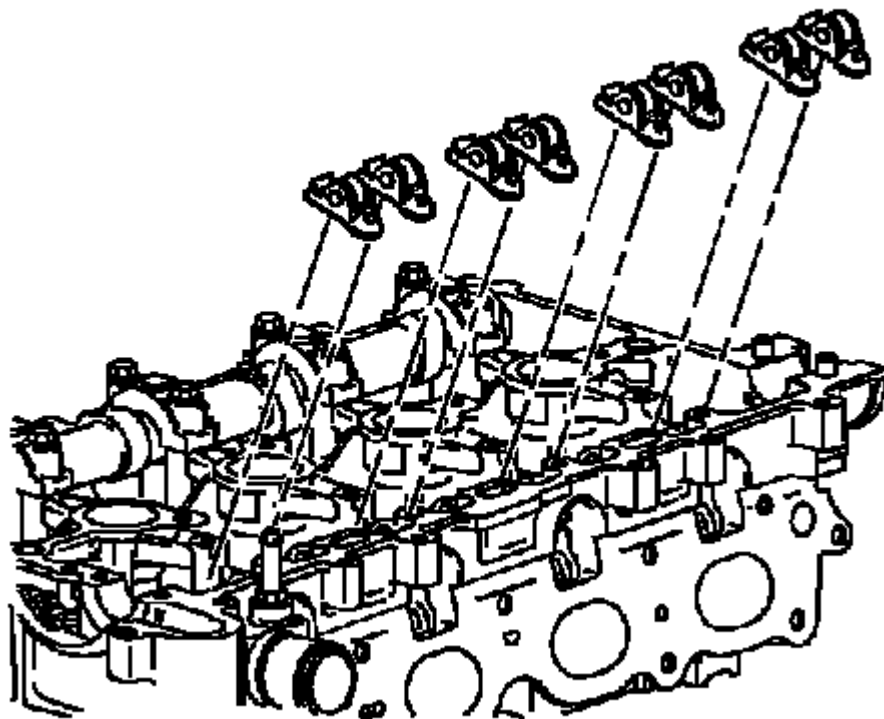


Fig. 455: View Of Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Used roller followers must be returned to the original position on the camshaft. If the camshaft is being replaced, the roller followers actuated by the camshaft must also be replaced.

4. Position the roller followers on the tip of the valve stem and on the lash adjuster. Lubricate roller followers with GM P/N 12345501 (Canadian P/N 992704) or equivalent.

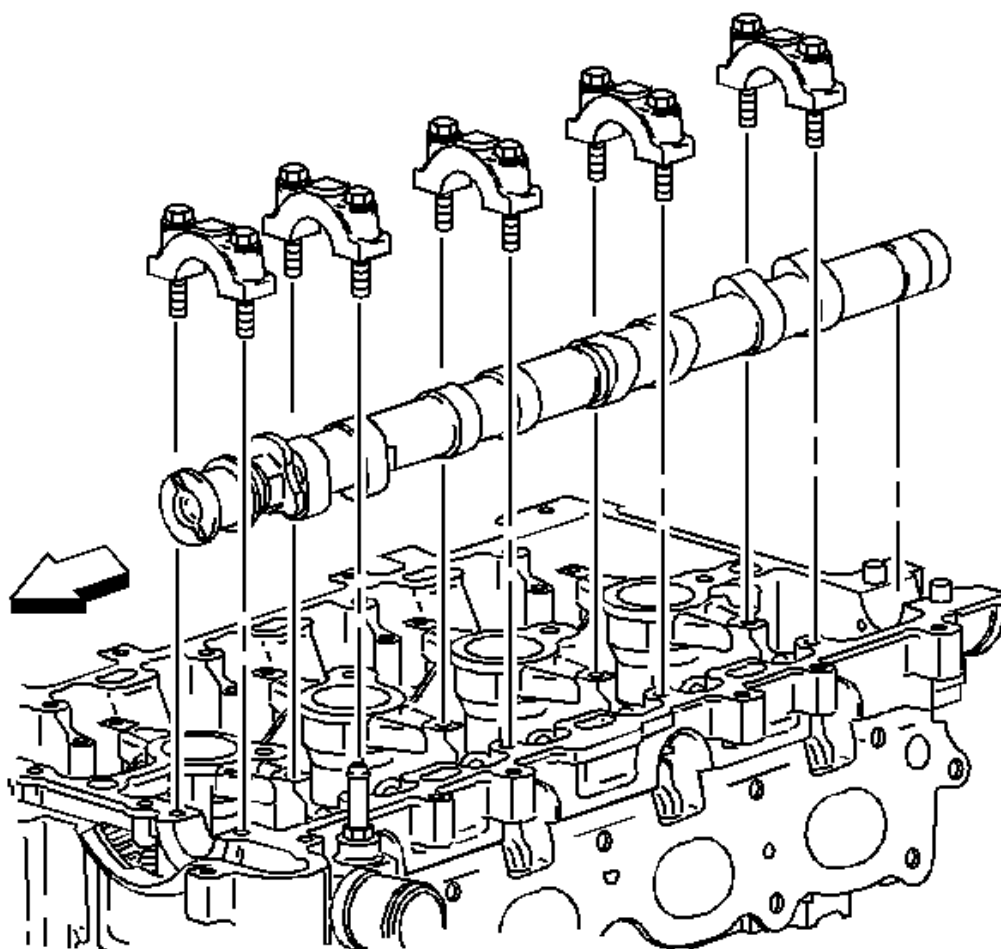


Fig. 456: View Of Camshaft Bearing Caps
Courtesy of GENERAL MOTORS CORP.

5. Set the intake camshaft on top of the roller followers in the camshaft bearing journals. Lubricate with GM P/N 12345501 (Canadian P/N 992704) or equivalent.
6. Install the camshaft caps and hand start the camshaft cap bolts.

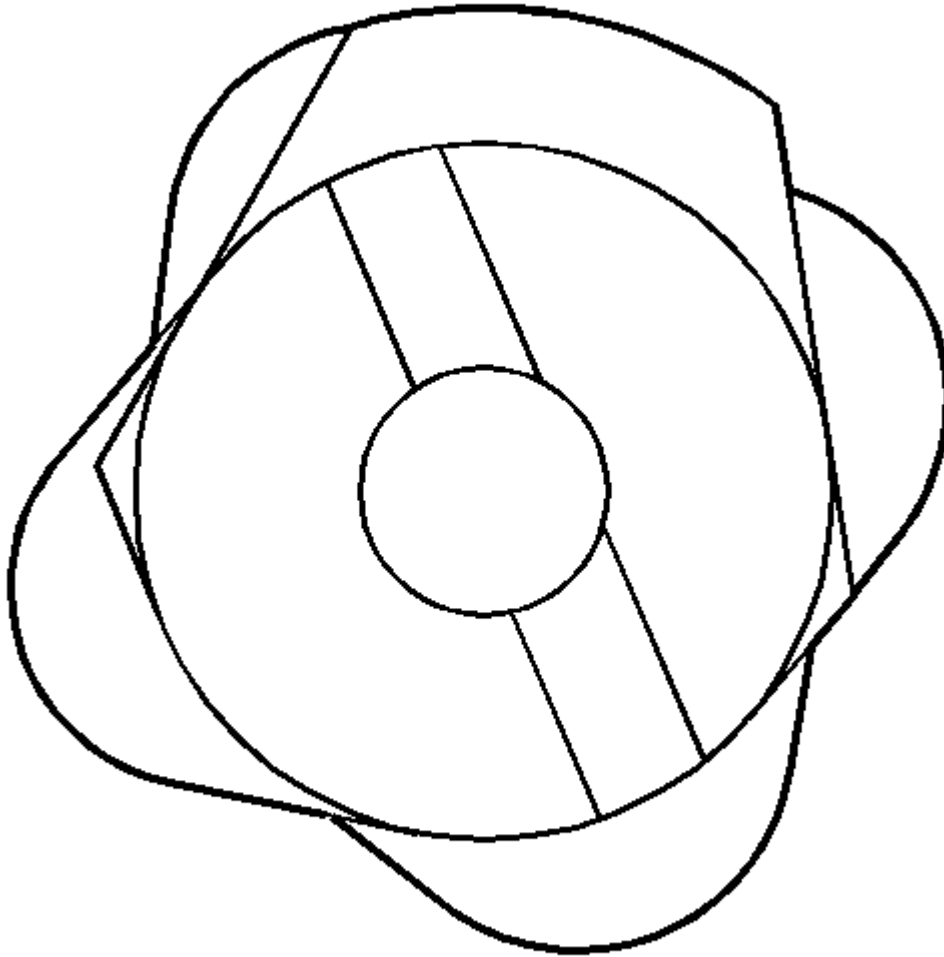


Fig. 457: View Of Camshaft Alignment Notches
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

7. The timing chain sprocket alignment notch should be oriented to the 11 o'clock position.
8. Tighten the camshaft cap bolts in increments of 3 turns until they are seated.

Tighten: Tighten the camshaft caps to 10 N.m (89 lb in).

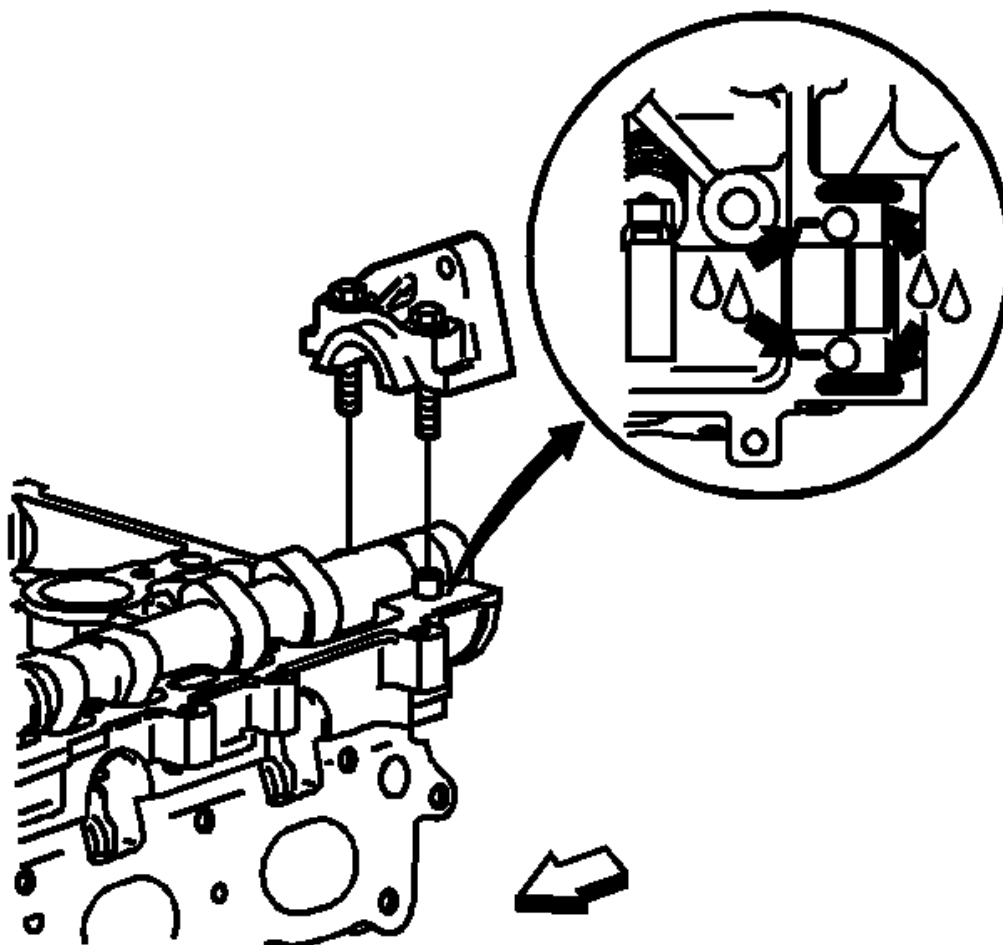


Fig. 458: Applying Camshaft Bearing Cap Sealer To Rear Cap
Courtesy of GENERAL MOTORS CORP.

9. Apply sealer GM P/N 12378521 (Canadian P/N 88901148) or equivalent to rear intake camshaft cap.
10. Install the rear intake camshaft cap bolts.

Tighten: Tighten the bolts to 25 N.m (18 lb ft).

EXHAUST CAMSHAFT, BEARING CAP, AND LASH ADJUSTER INSTALLATION

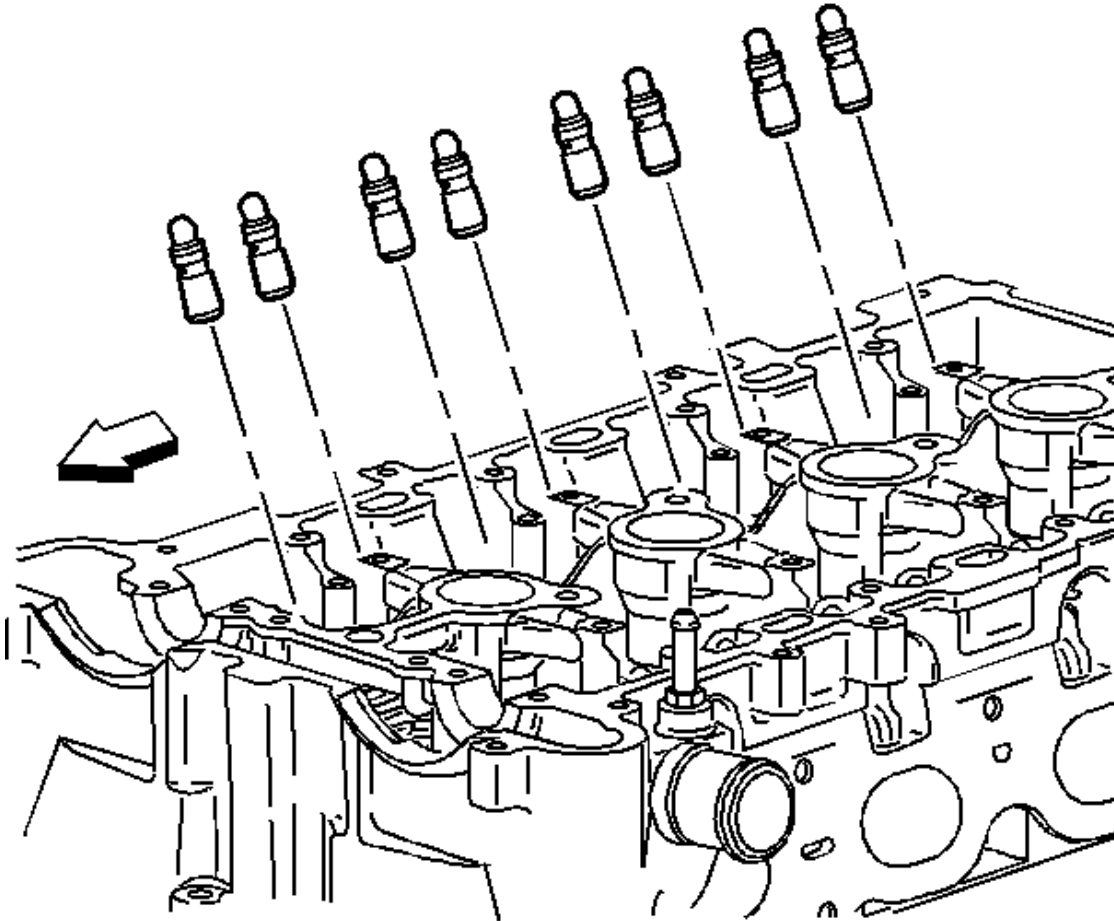


Fig. 459: View Of Hydraulic Element Lash Adjusters
Courtesy of GENERAL MOTORS CORP.

1. Install the hydraulic lash adjusters into their bores in the cylinder head. Apply lubricant GM P/N 12345501 (Canadian P/N 992704) or equivalent.

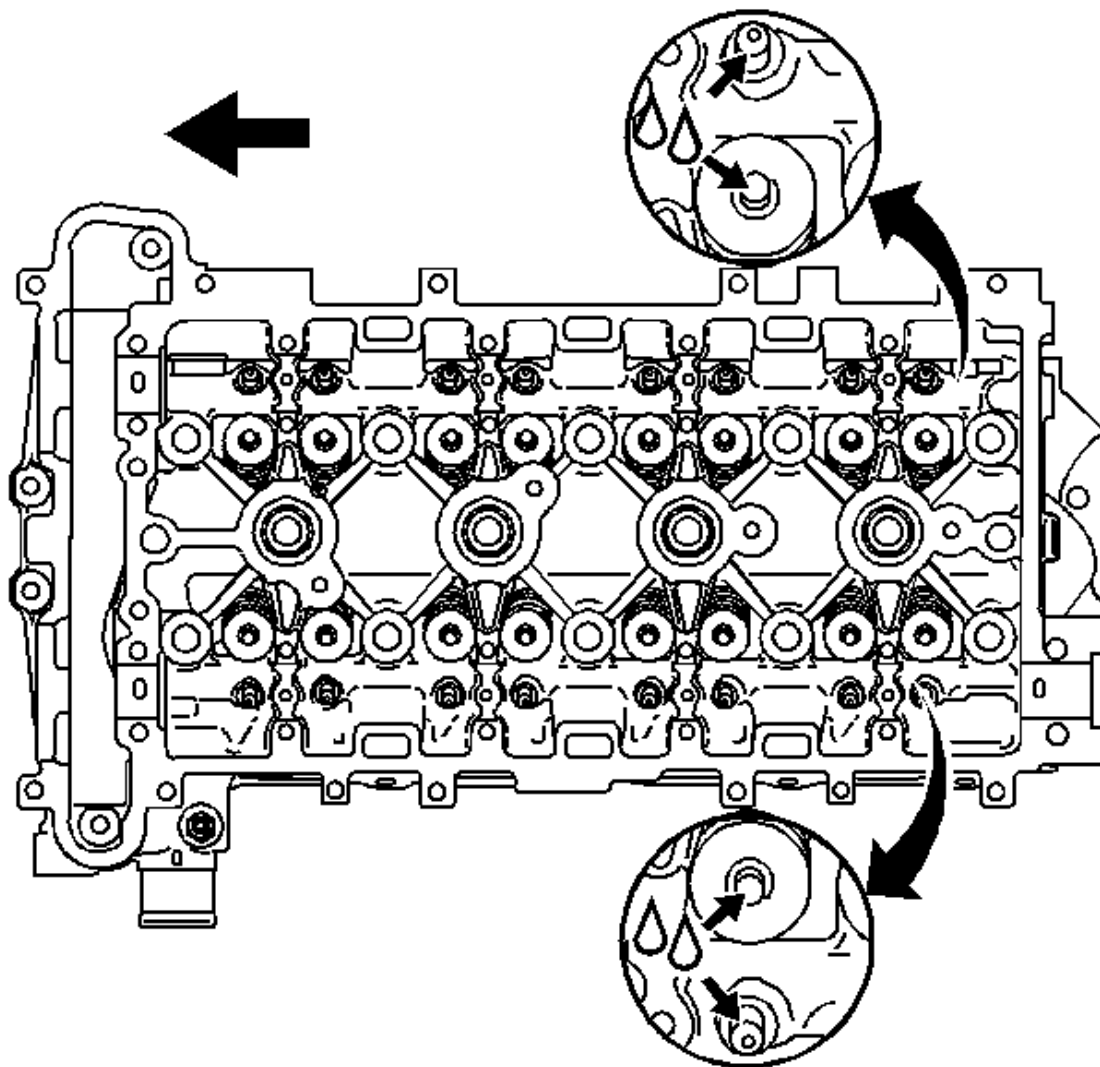


Fig. 460: Lubricating Valve Tips
Courtesy of GENERAL MOTORS CORP.

2. Lubricate the valve tips with GM P/N 12345501 (Canadian P/N 992704) or equivalent.

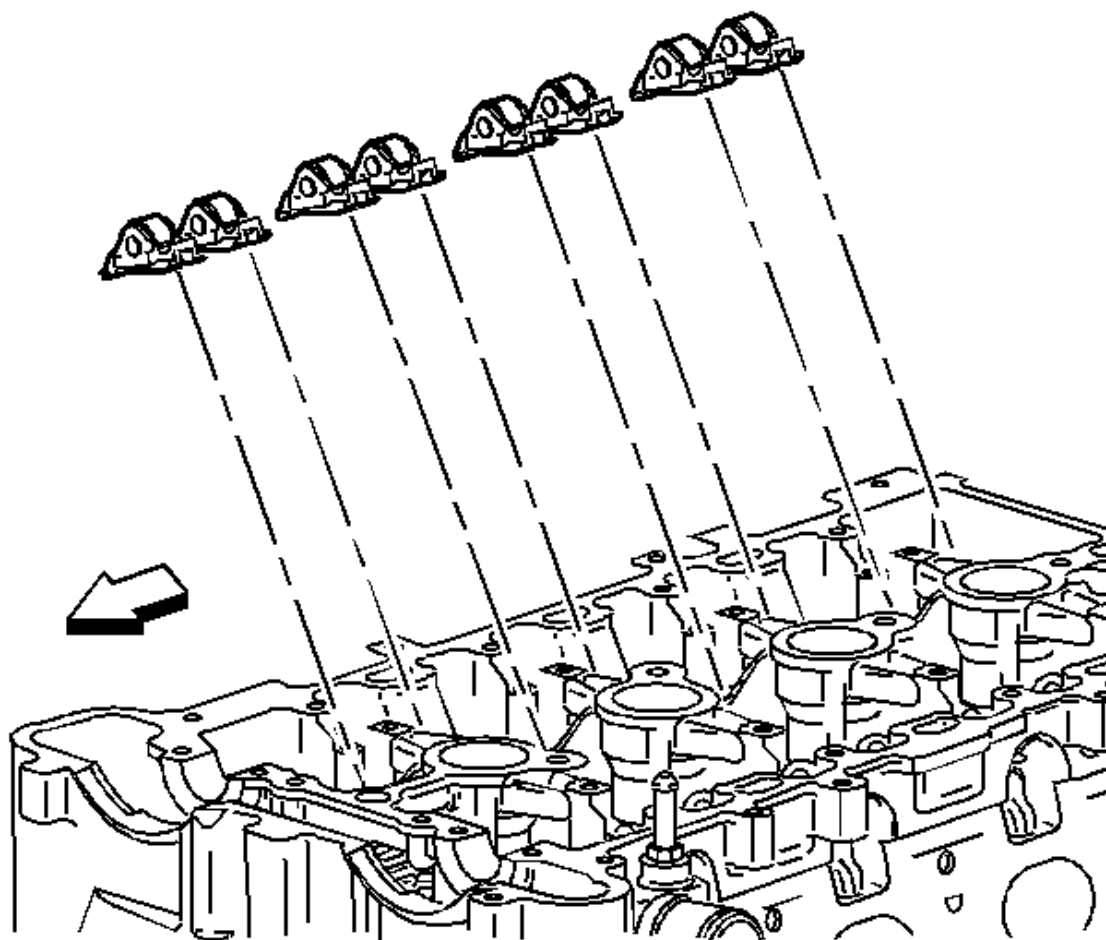


Fig. 461: Identifying Exhaust Camshaft Roller Followers
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Used roller followers must be returned to the original position on the camshaft. If the camshaft is being replaced, the roller followers actuated by the camshaft must also be replaced.

3. Position the roller followers on the tip of the valve stem and on the lash adjuster, apply lubricant GM P/N 12345501 (Canadian P/N 992704) or equivalent.

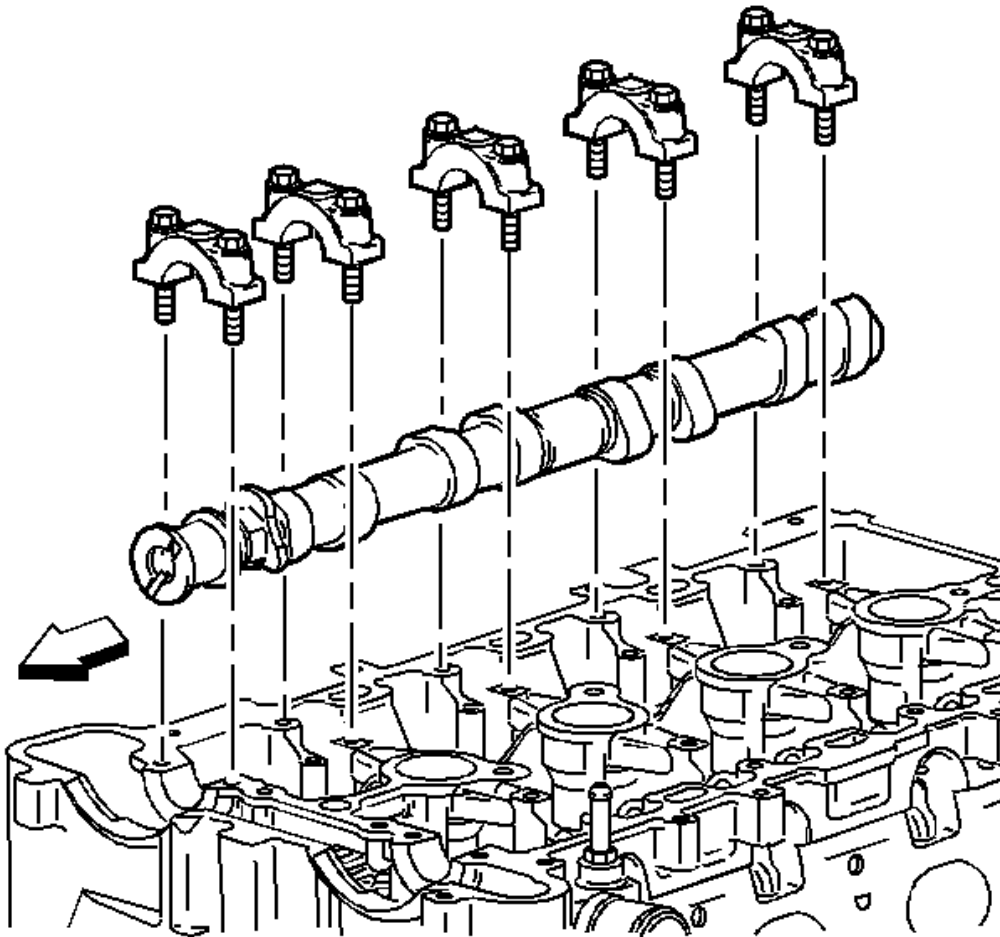


Fig. 462: View Of Camshaft & Bearing Caps

Courtesy of GENERAL MOTORS CORP.

4. Set the exhaust camshaft on top of the roller followers in the camshaft journals. Lubricate with GM P/N 12345501 (Canadian P/N 992704) or equivalent.
5. Install the camshaft caps and hand start the camshaft cap bolts.

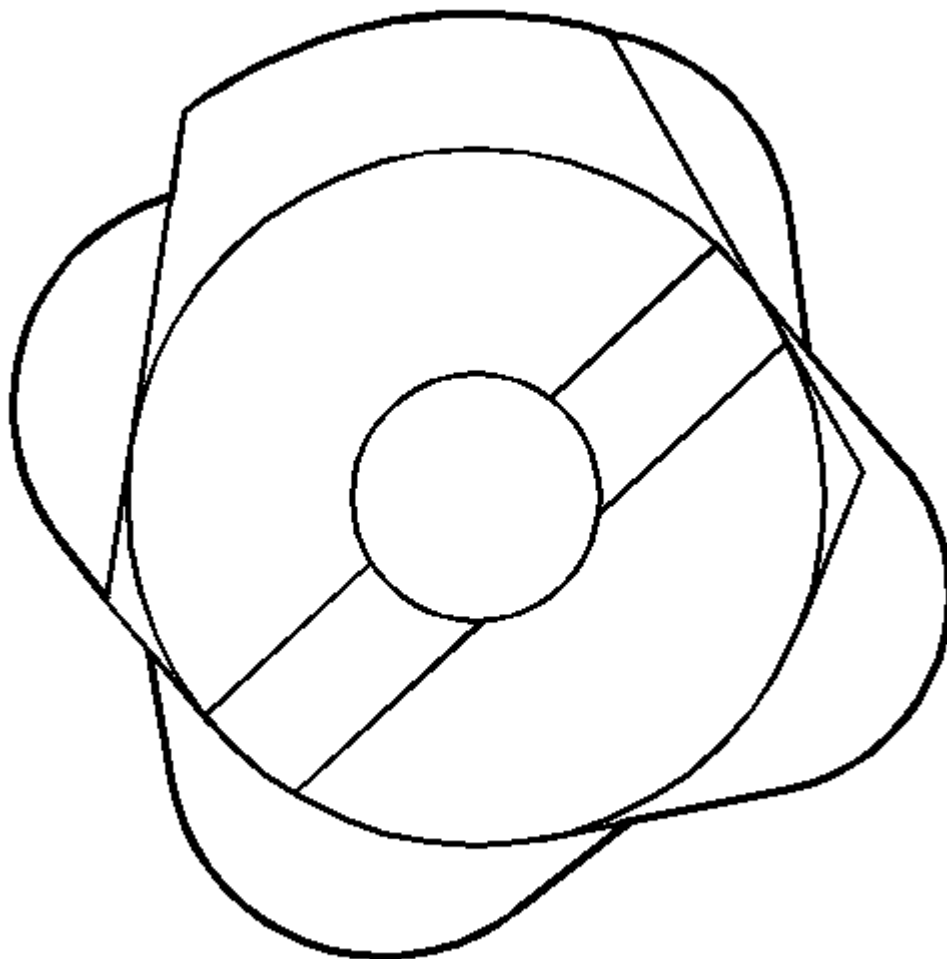


Fig. 463: View Of Timing Chain Sprocket Alignment Notch
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **Fastener Notice** .

6. The timing chain sprocket alignment notch should be oriented to the 2 o' clock position.
7. Tighten the camshaft bearing cap bolts in increments of 3 turns until they are seated, lubricate.

Tighten: Tighten the camshaft caps to 10 N.m (89 lb in).

BALANCE SHAFT INSTALLATION

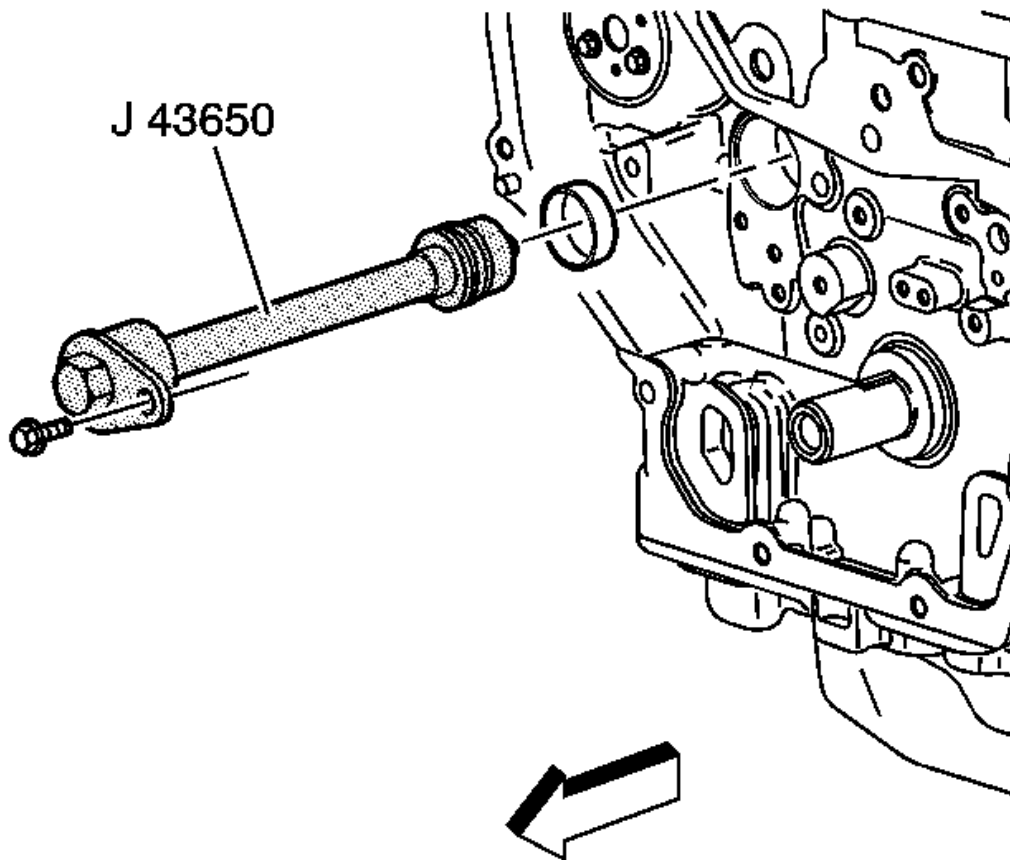
Tools Required**J 43650** Balance Shaft Bushing Remover/Installer**Installation Procedure**

Fig. 464: Installing Balance Shaft Using J 43650
Courtesy of GENERAL MOTORS CORP.

1. Install the balance shaft bushing using the **J 43650** .

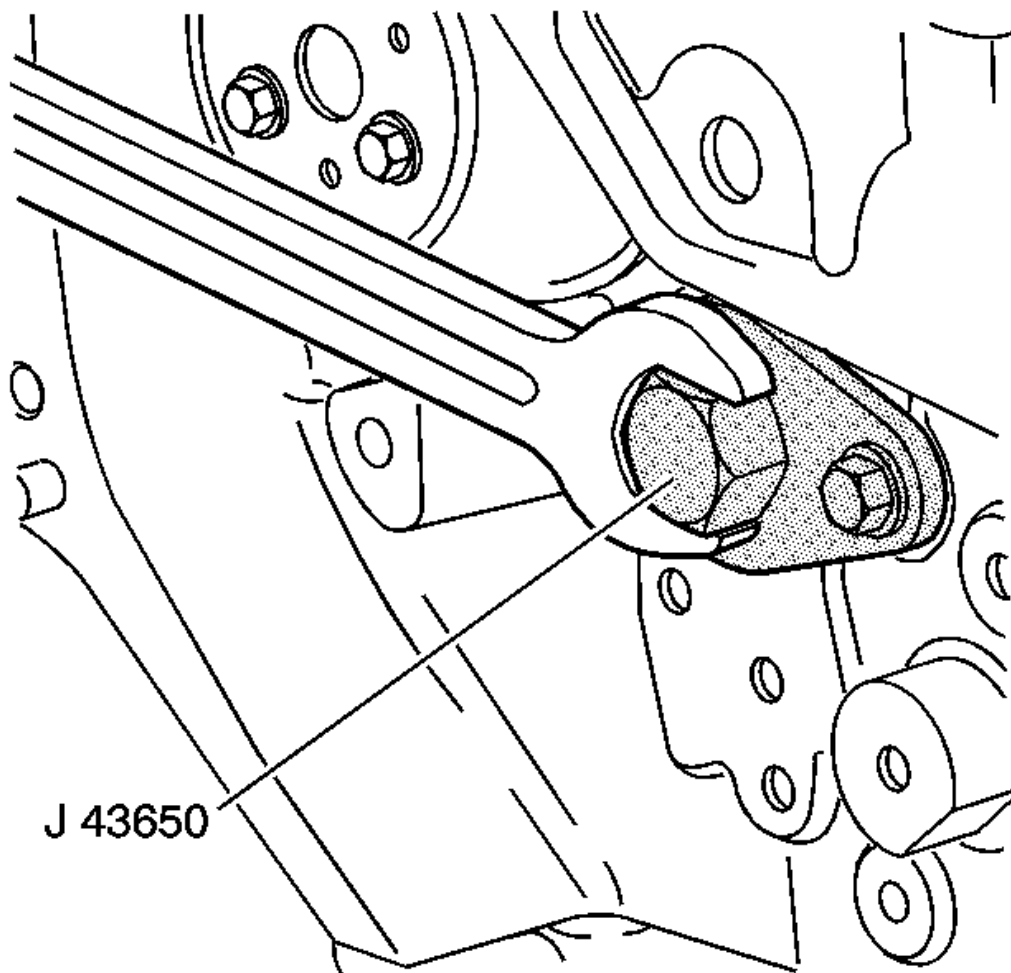


Fig. 465: Seating Balance Shaft Bushing
Courtesy of GENERAL MOTORS CORP.

2. Seat the balance shaft bushing into the bore using the **J 43650** and a wrench.
3. When the **J 43650** is fully seated in the engine block, remove it with a wrench.

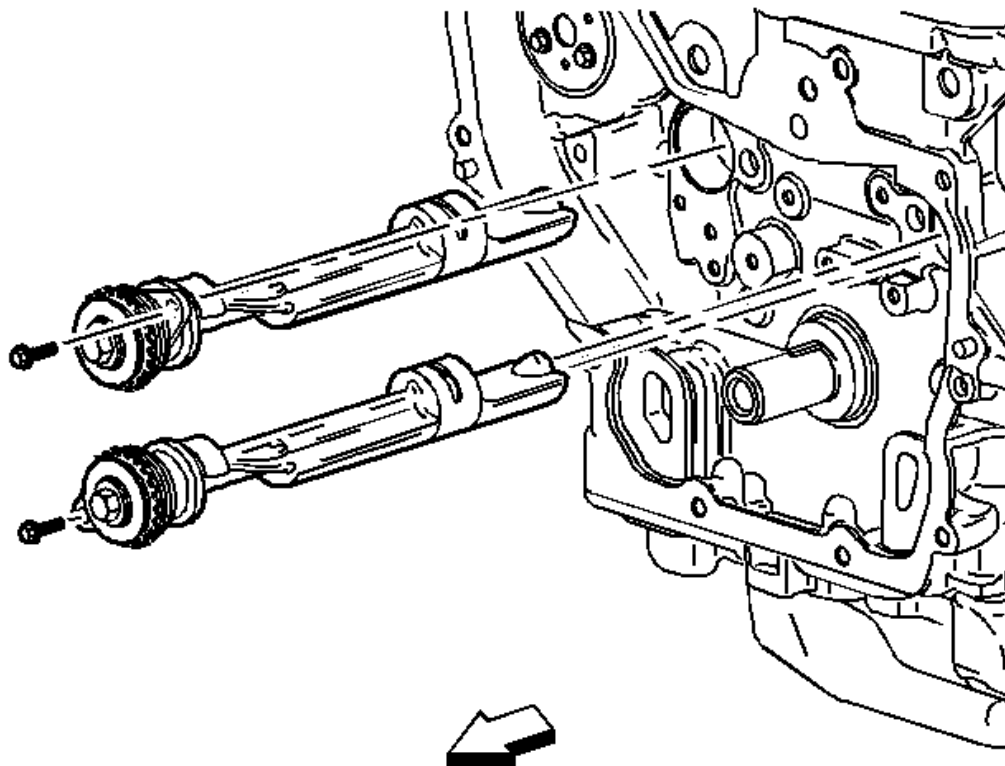


Fig. 466: View Of Balance Shafts assemblies
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: If the balance shafts are not properly timed to the engine, the engine may vibrate or make noise.

Install the balance shaft assemblies to the engine using the following steps:

4. Place the number one piston at top dead center (TDC).
5. Lubricate the balance shaft lobes with engine oil.
6. Install the balance shafts into their bores.

NOTE: Refer to **FASTENER NOTICE** .

7. Install the balance shaft retaining bolts.

Tighten: Tighten the balance shaft retaining bolts to 10 N.m (89 lb in).

WATER PUMP INSTALLATION

Prior to installing the water pump, read the entire procedure. Pay special attention to avoid part damage and to ensure proper sealing.

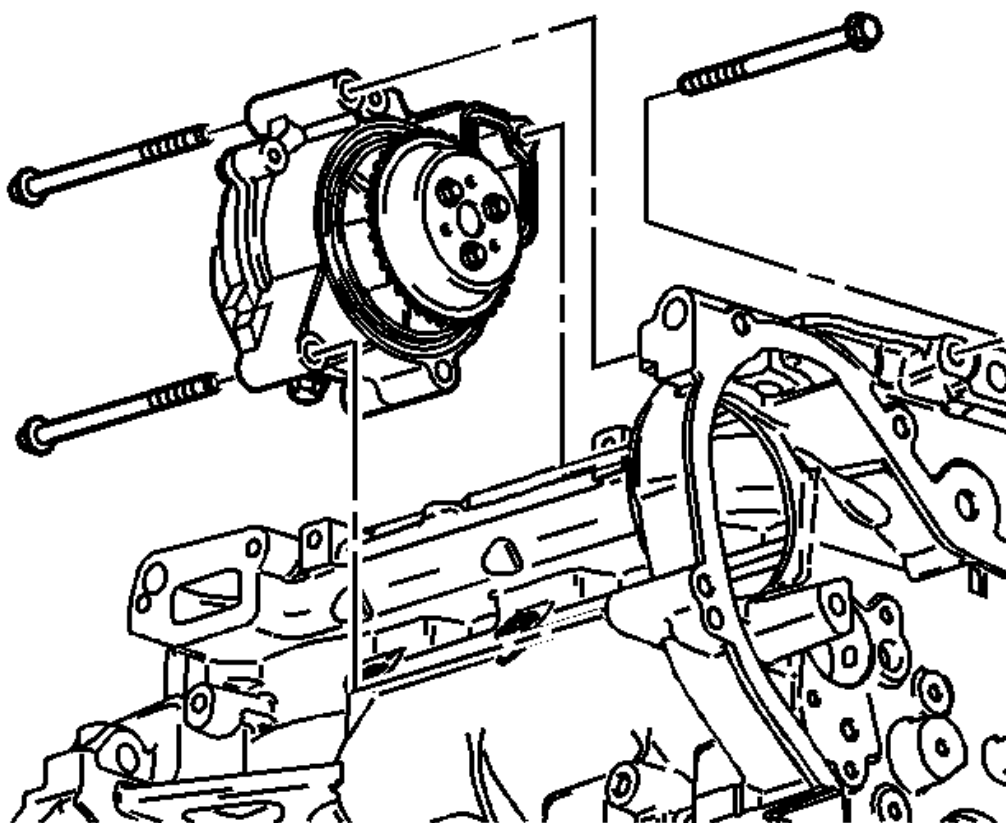


Fig. 467: View Of Water Pump Assembly
Courtesy of GENERAL MOTORS CORP.

1. Install the water pump assembly.
2. Install the water pump bolts. Finger tighten the bolts.

NOTE: Refer to Fastener Notice .

3. Tighten the water pump bolts.

Tighten: Tighten the bolts to 25 N.m (18 lb ft).

4. Apply sealant GM P/N 12346004 (Canadian P/N 10953480) or equivalent to the water pump drain plug.
5. Install the water pump drain plug, if necessary.

Tighten: Tighten the water pump drain plug to 20 N.m (15 lb ft).

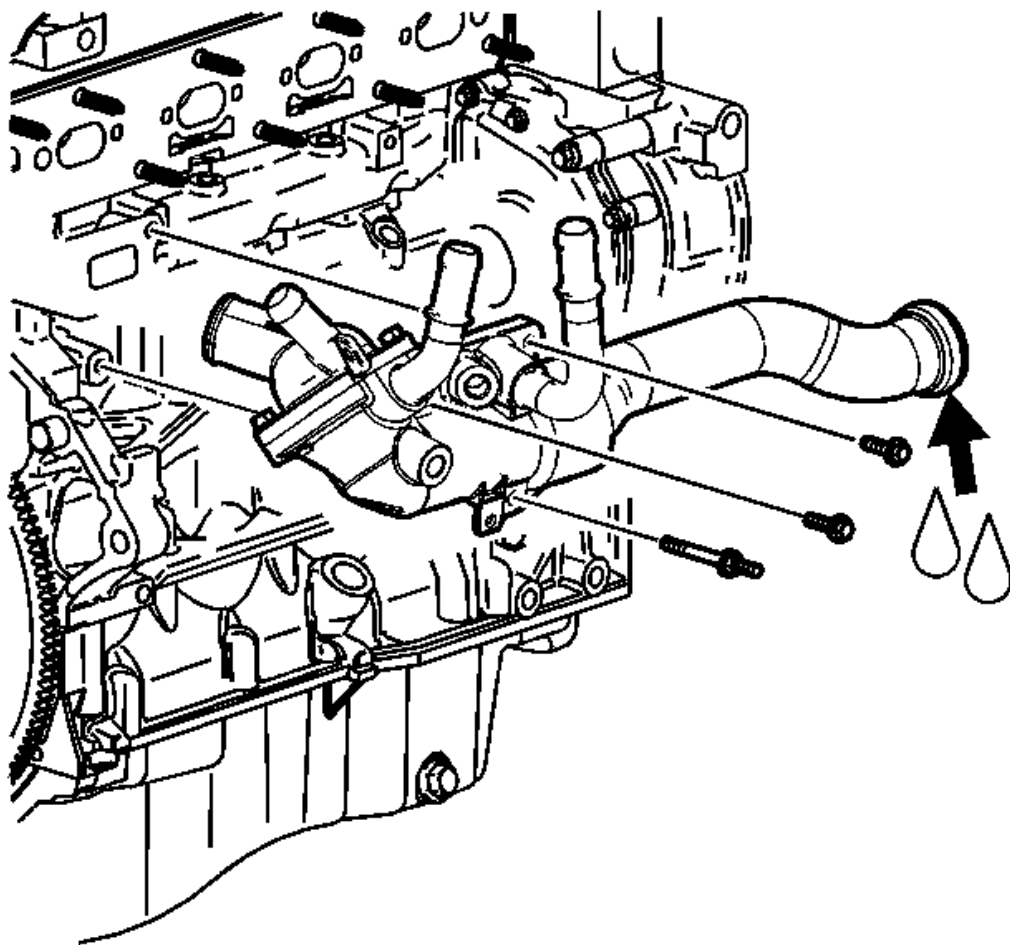


Fig. 468: View Of Water Feed Tube
Courtesy of GENERAL MOTORS CORP.

6. Install the water feed tube.
7. Lubricate the feed tube O-ring with antifreeze.
8. Install the water feed tube by twisting and pushing toward the water pump. Take care not to tear or damage the O-ring.
9. Install the thermostat housing to block bolts and stud.

Tighten: Tighten the bolts to 10 N.m (89 lb in).

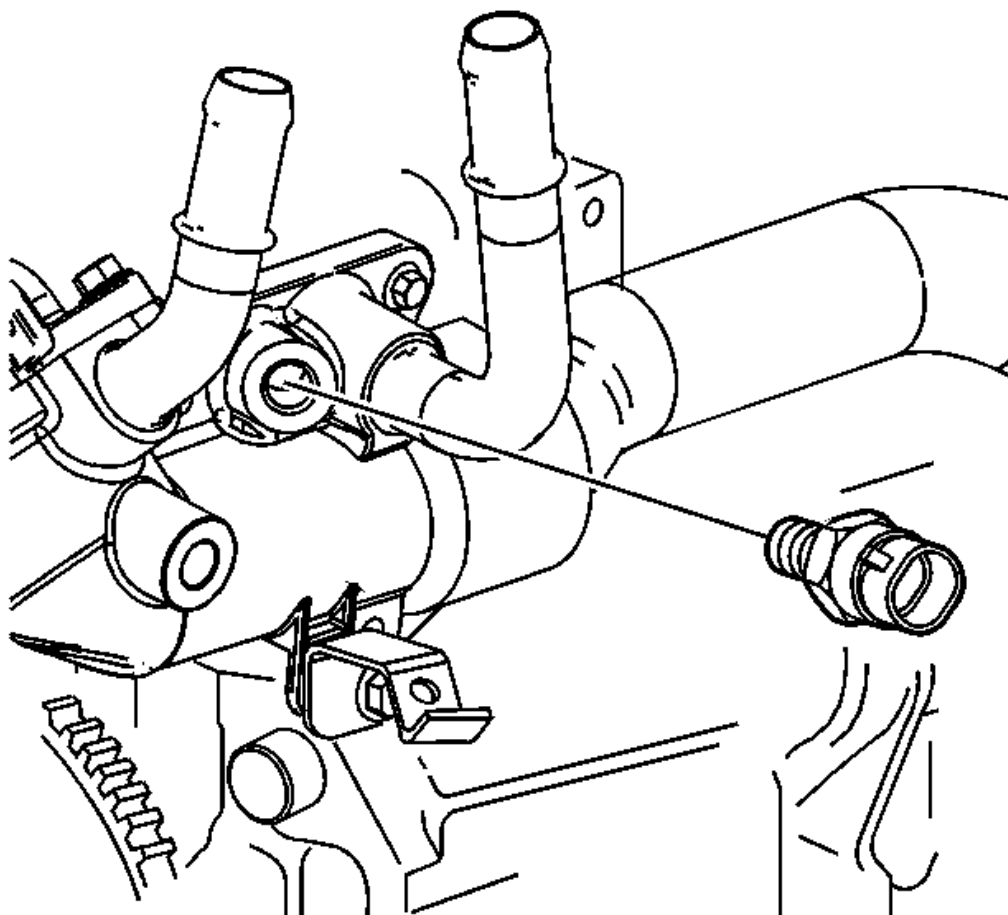


Fig. 469: Locating Engine Coolant Temperature Sensor
Courtesy of GENERAL MOTORS CORP.

10. Install the engine coolant temperature sensor by hand.
11. Tighten the engine coolant temperature sensor.

Tighten: Tighten the engine coolant temperature sensor to 20 N.m (15 lb ft).

BALANCE SHAFT TO ENGINE TIMING

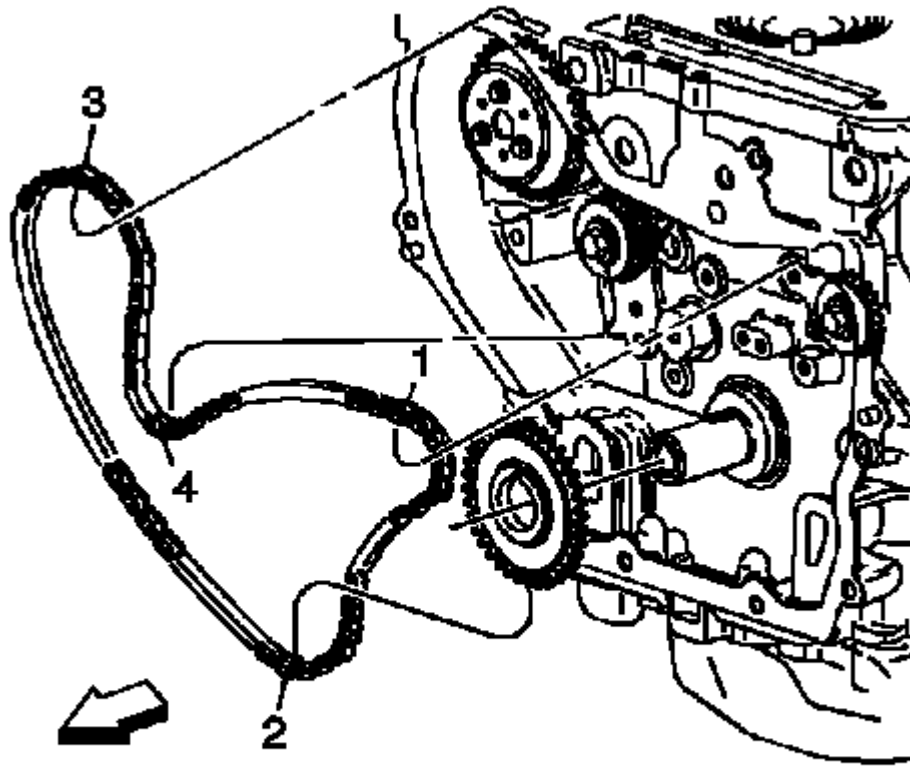


Fig. 470: Aligning Balance Shaft Drive Chain
 Courtesy of GENERAL MOTORS CORP.

1. Install the balance shaft drive sprocket.

IMPORTANT: If the balance shafts are not properly timed to the engine, the engine may vibrate or make noise.

2. Install the balance shaft drive chain with the colored links lined up on with the marks on the balance shaft drive sprockets and the crankshaft sprocket. There are three colored links on the chain. Two links are of matching colors, and one link is of a unique color. Use the following procedure to line up the links with the sprockets:

Orient the chain so that the colored links are visible.

3. Place the uniquely colored link (1) so that it lines up with the timing mark on the intake side balance shaft sprocket.
4. Working clockwise around the chain, place the first matching colored link (2) in line with the timing mark on the crankshaft drive sprocket. (approximately 6 o'clock position on the crank sprocket)
5. Place the chain (3) on the water pump drive sprocket. The alignment is not critical.
6. Align the last matching colored link (4) with the timing mark on the exhaust side balance shaft drive

sprocket.

WATER PUMP AND BALANCE SHAFT CHAIN AND TENSIONER INSTALLATION

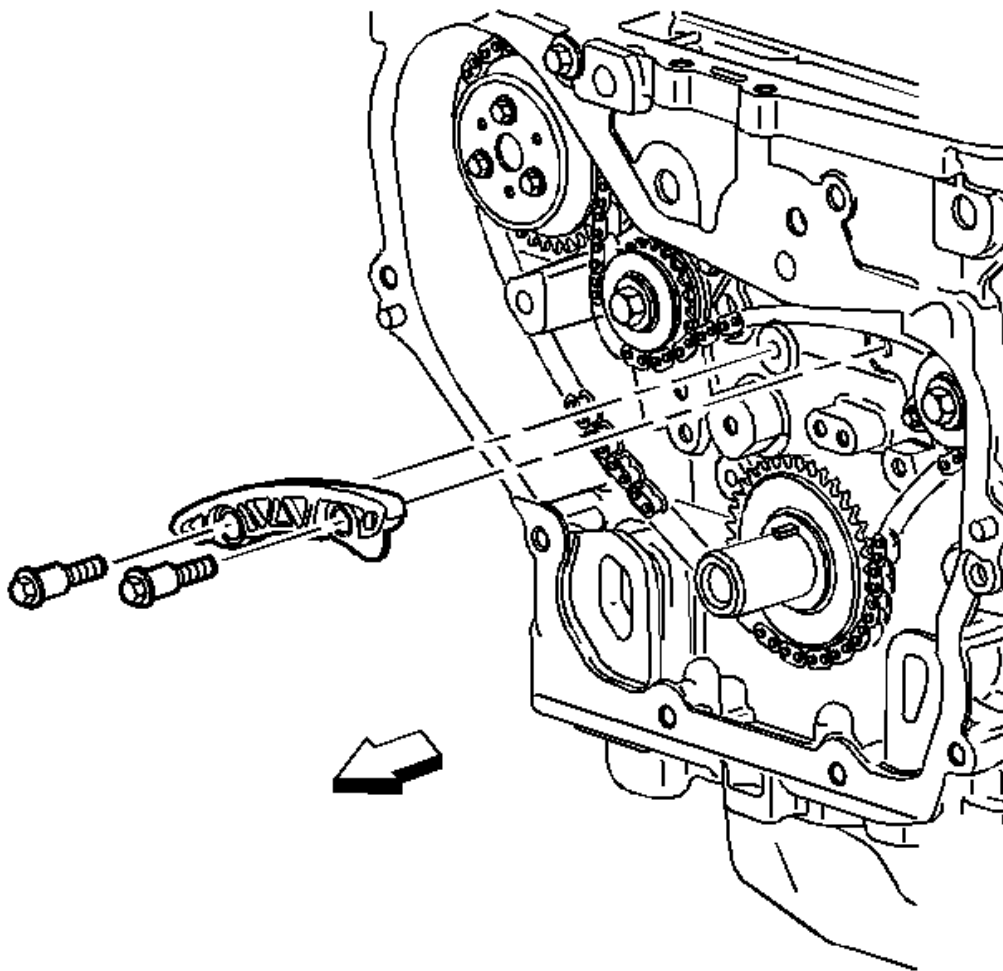


Fig. 471: View Of Upper Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

IMPORTANT: If the balance shafts are not properly timed to the engine, the engine may vibrate and make noise.

1. Install the upper balance shaft chain guide and bolts.

Tighten: Tighten the upper balance shaft chain guide bolts to 15 N.m (11 lb ft).

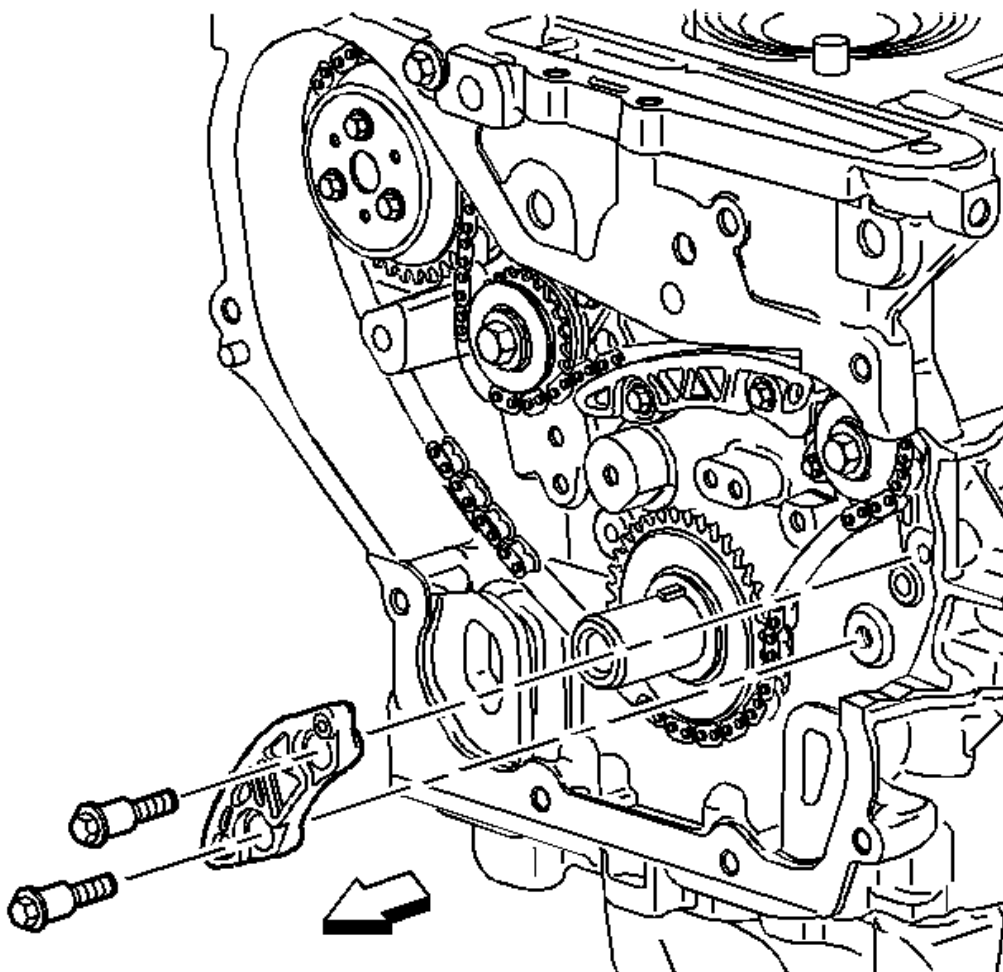


Fig. 472: Exploded View Of Small Balance Shaft Drive Chain Guide
Courtesy of GENERAL MOTORS CORP.

2. Install the small balance shaft chain guide.
3. Install the balance shaft chain guide bolts.

Tighten: Tighten the chain guide bolts to 15 N.m (11 lb ft).

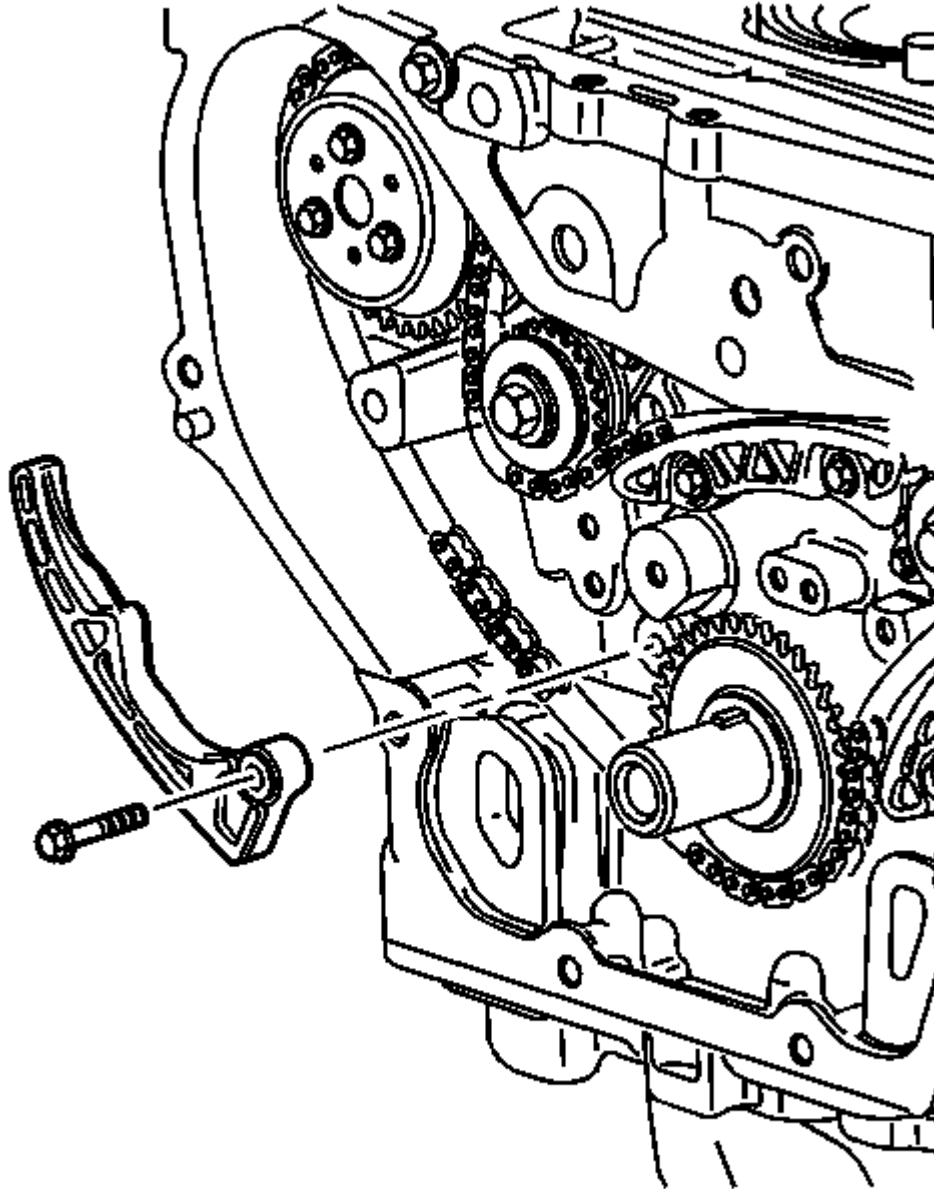


Fig. 473: View Of Adjustable Balance Shaft Chain Guide
Courtesy of GENERAL MOTORS CORP.

4. Install the adjustable balance shaft drive chain guide.
5. Install the adjustable balance shaft drive chain guide bolts.

Tighten: Tighten the chain guide bolts to 10 N.m (89 lb in).

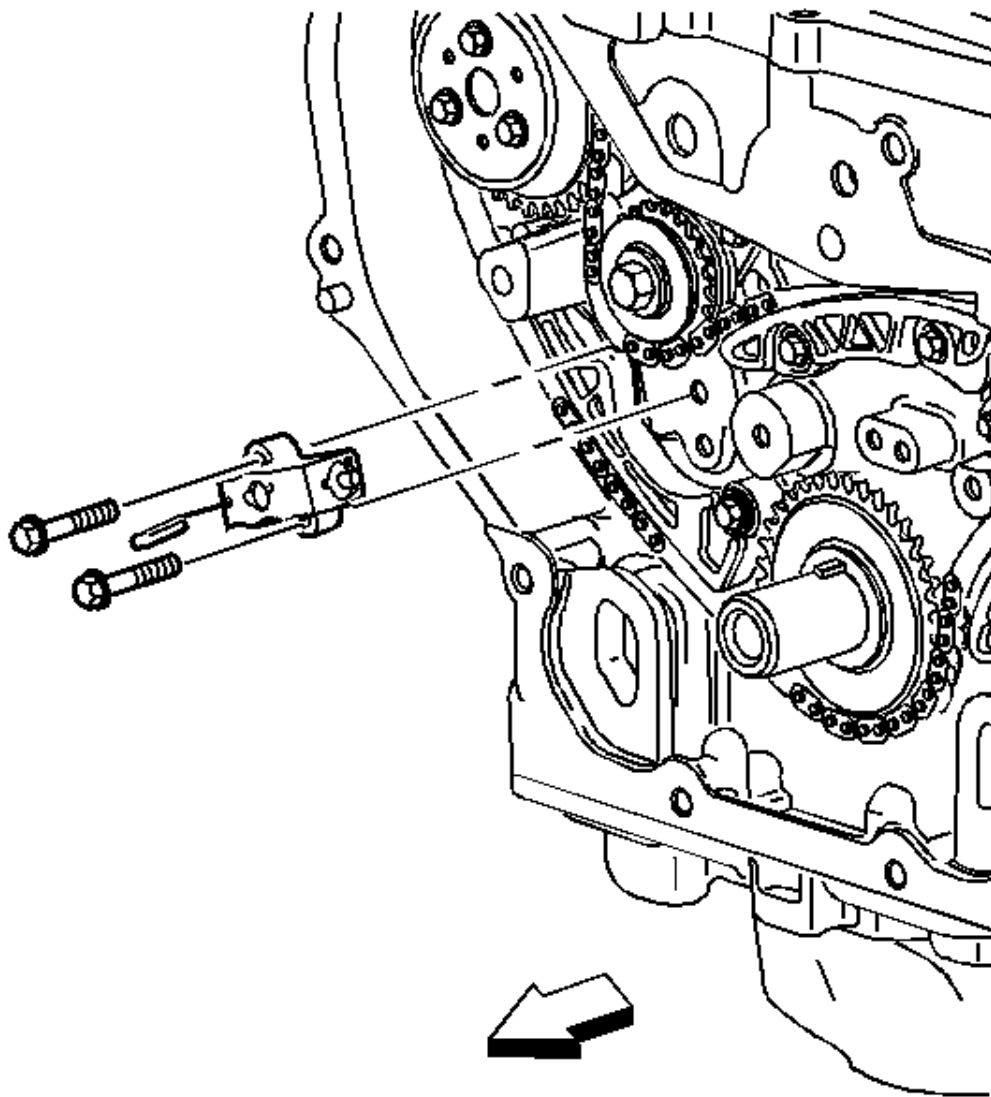


Fig. 474: View Of Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

6. Reset the timing chain tensioner by performing the following steps:
 1. Turn the tensioner plunger 90 degrees in its bore and compress the plunger.
 2. Turn the tensioner back to the original 12 o'clock position and insert a paper clip through the hole in the plunger body and into the hole in the tensioner plunger.

7. Install the timing chain tensioner.
8. Install the chain tensioner bolts.

Tighten: Tighten the chain tensioner bolts to 10 N.m (89 lb in).

9. Remove the paper clip from the balance shaft drive chain tensioner.

CAMSHAFT TIMING CHAIN, SPROCKET, AND TENSIONER INSTALLATION

Tools Required

J 45059 Angle Meter

Installation Procedure

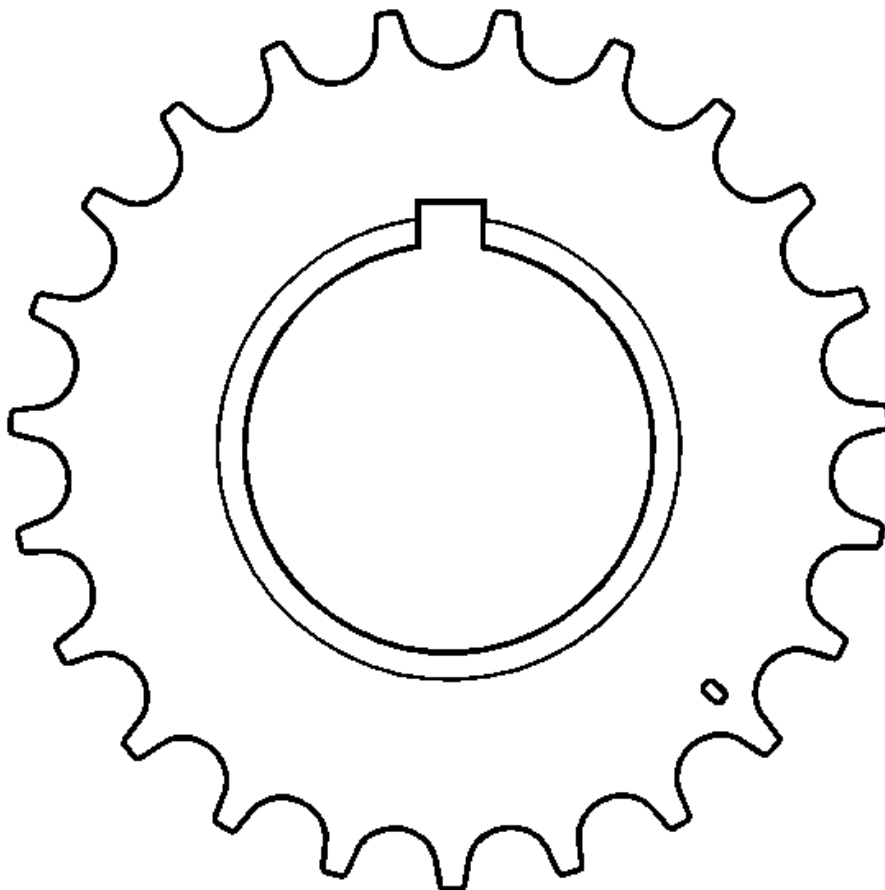


Fig. 475: View Of Crankshaft Sprocket Timing Mark
Courtesy of GENERAL MOTORS CORP.

1. Install the timing chain drive sprocket to the crankshaft with the timing mark in the 5 o'clock position.

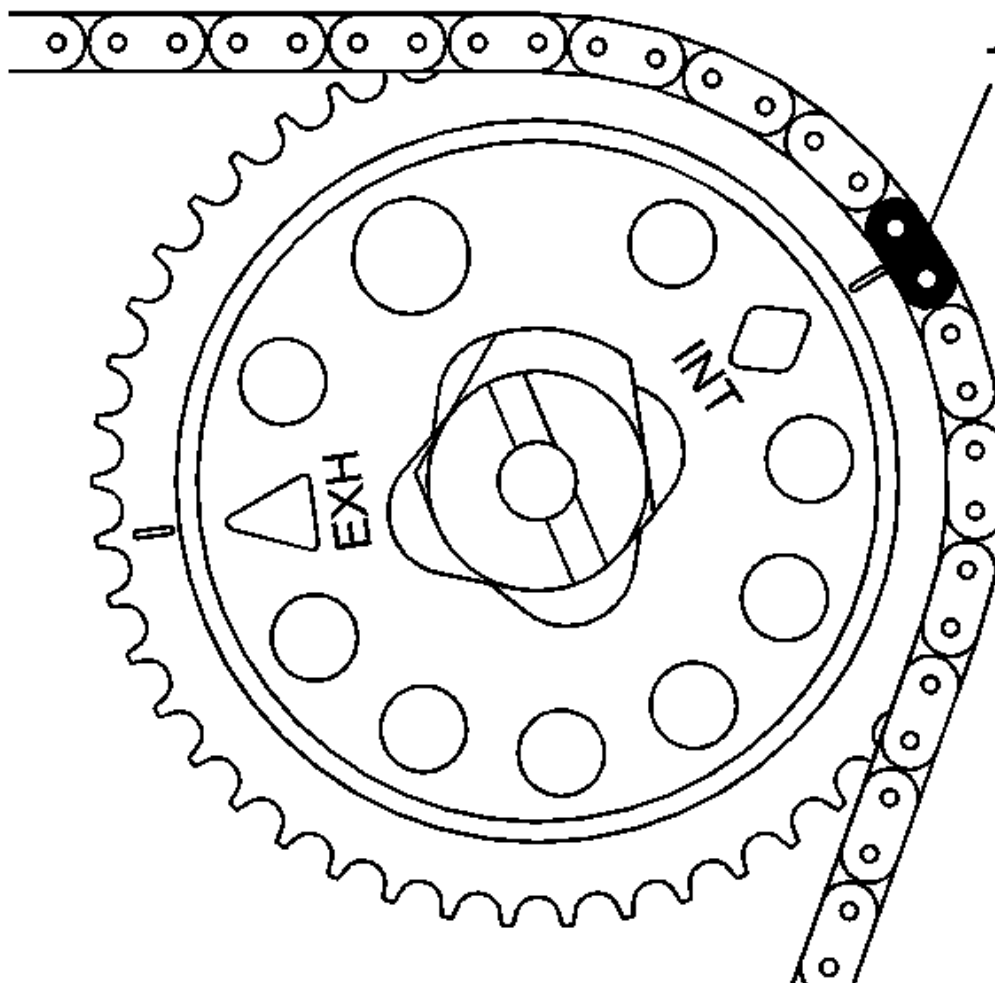


Fig. 476: Aligning Timing Chain Link & Intake Sprocket Timing Mark
Courtesy of GENERAL MOTORS CORP.

IMPORTANT:

- There are 3 colored links on the timing chain. Two links are of matching color, and one link is of a unique color. Use the following procedure to line up the links with the sprockets. Orient the chain so that the colored links are visible.
 - Always use new sprocket bolts.
2. Assemble the intake camshaft sprocket to the timing chain with the timing mark lined up with the uniquely colored link (1). Hand tighten a new intake camshaft sprocket bolt.

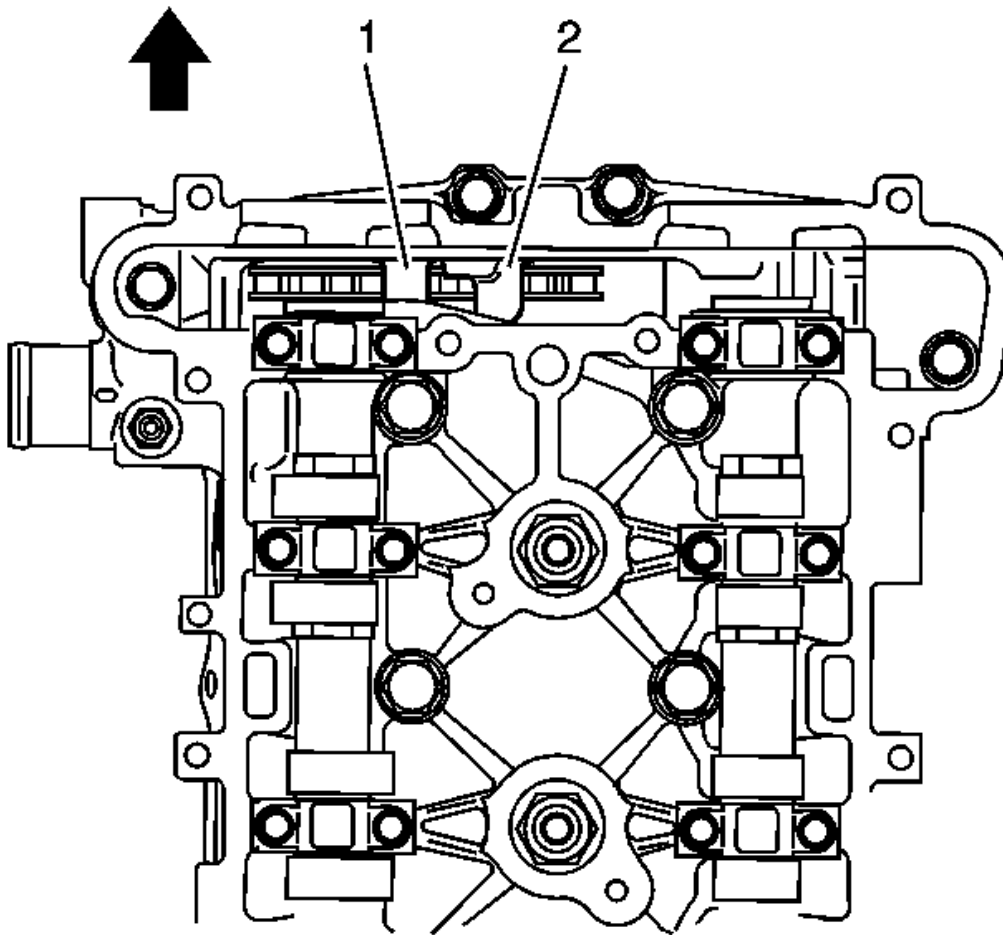


Fig. 477: Locating Cylinder Block Bosses

Courtesy of GENERAL MOTORS CORP.

3. Lower the timing chain through the opening in the cylinder head. Use care to ensure that the chain goes around both sides of the cylinder block bosses (1, 2).

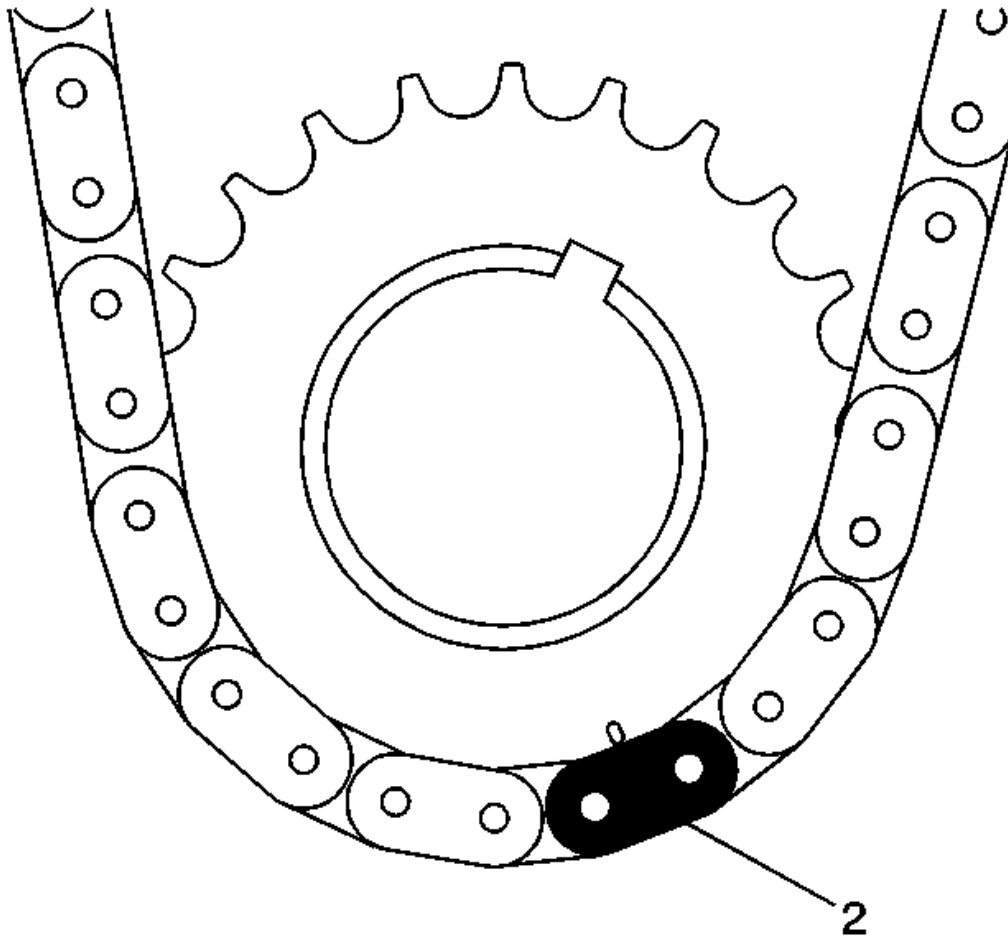


Fig. 478: Identifying Timing Chain Colored Link & Crankshaft Sprocket Timing Mark
Courtesy of GENERAL MOTORS CORP.

4. Route the timing chain around the crankshaft sprocket and line up the first matching colored link (2) with the timing mark on the crankshaft sprocket, in approximately the 5 o'clock position.

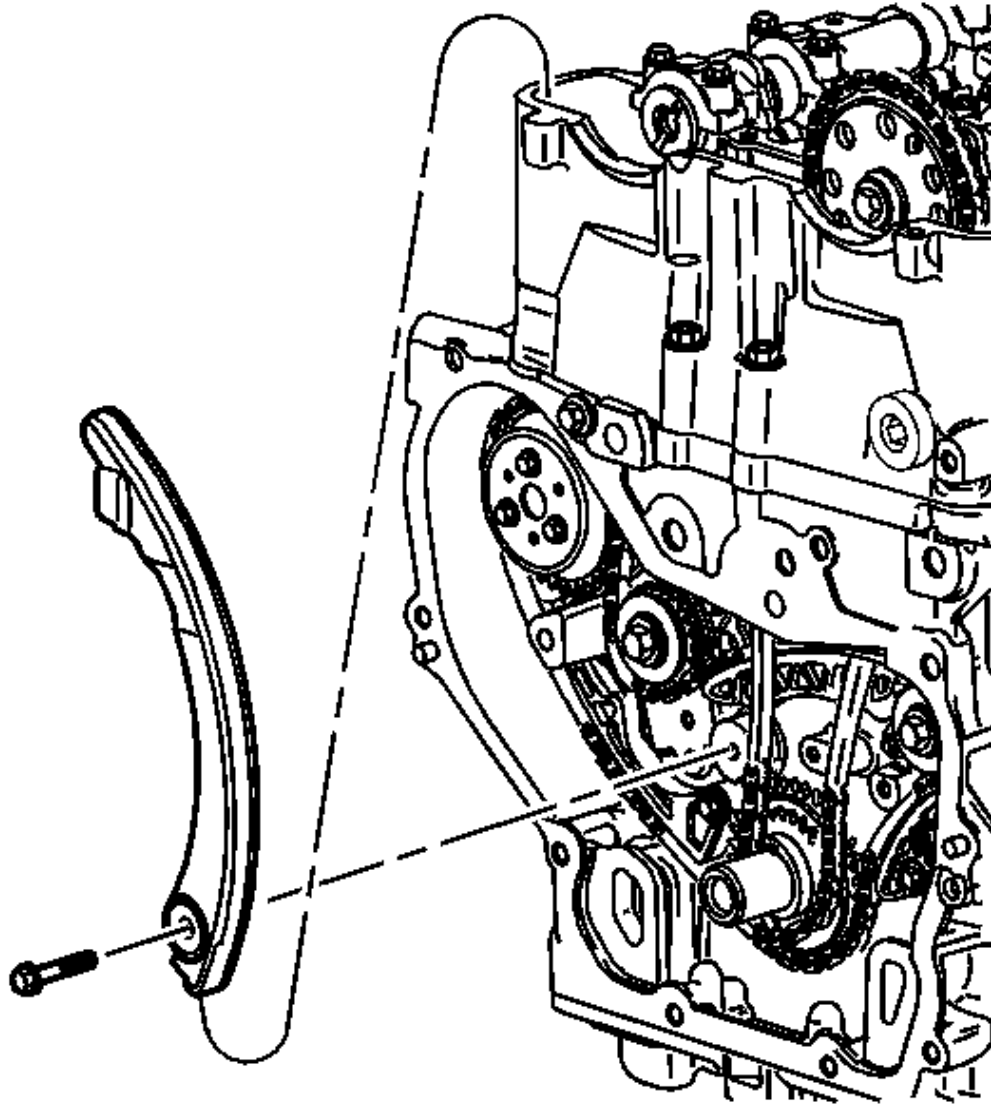


Fig. 479: View Of Timing Chain Tensioner Guide
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to FASTENER NOTICE .

5. Install the adjustable timing chain guide through the opening in the cylinder head and install the adjustable timing chain bolt.

Tighten: Tighten the adjustable timing chain guide bolt to 10 N.m (89 lb in).

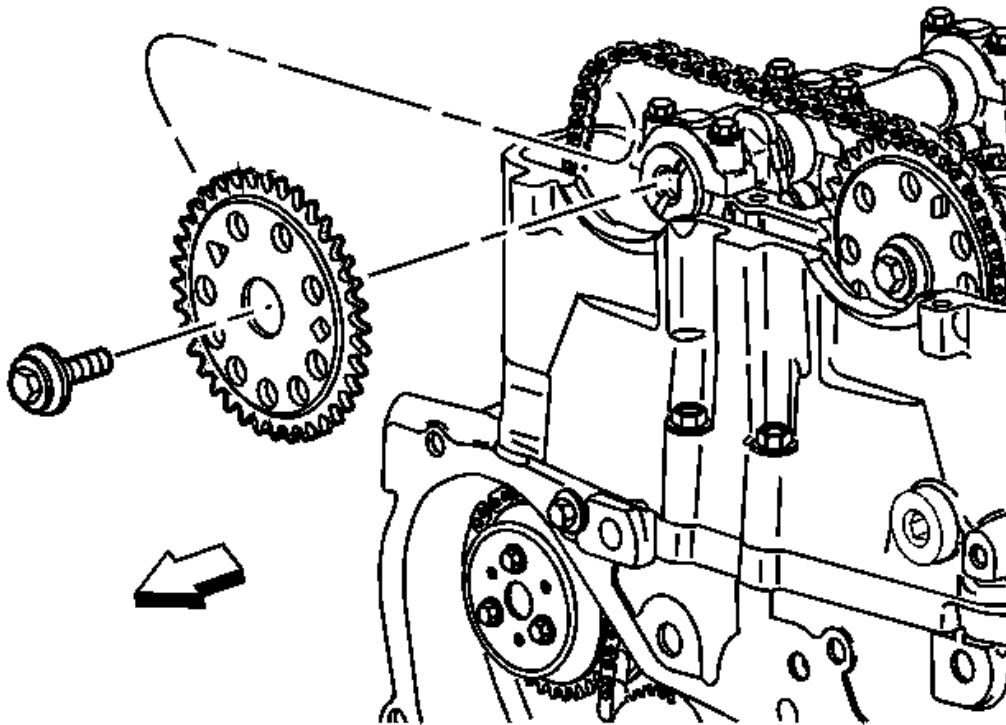


Fig. 480: Identifying Exhaust Camshaft Sprocket
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Always install new sprocket bolts.

6. Install the exhaust camshaft sprocket and a new bolt loosely onto the exhaust camshaft.

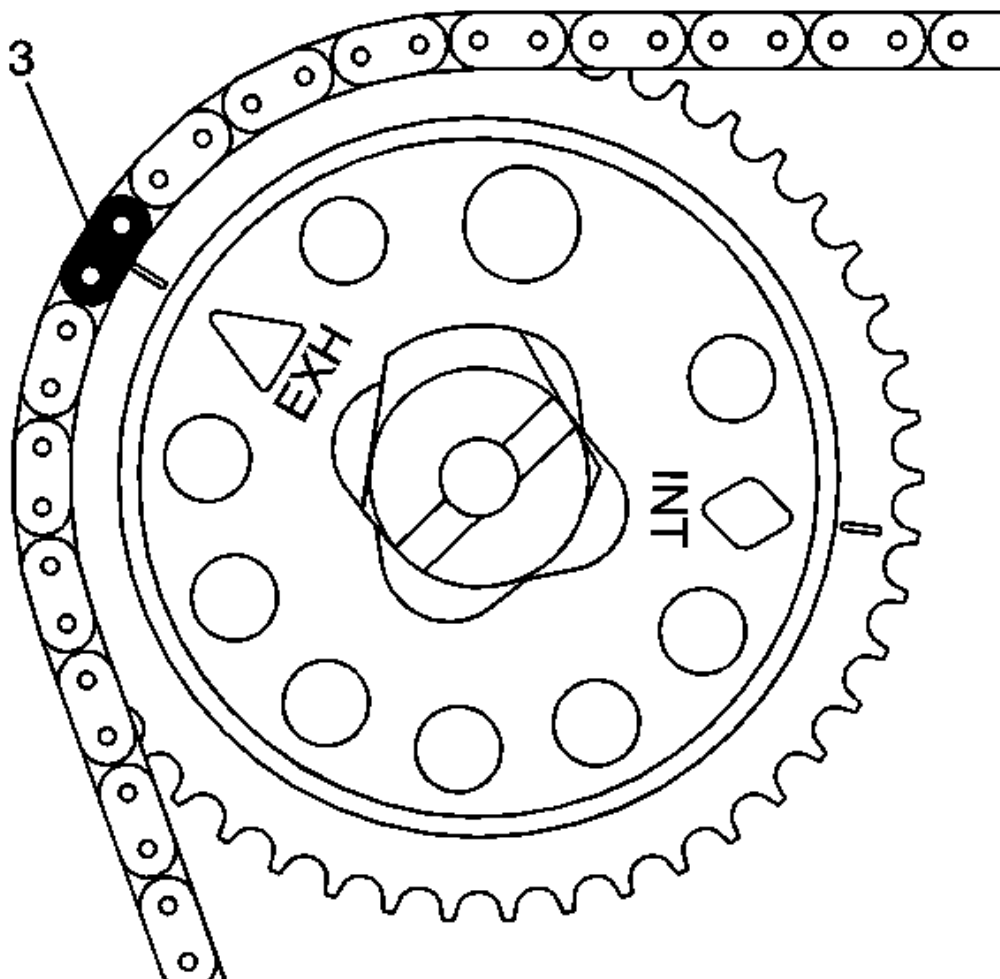


Fig. 481: Aligning Timing Chain Link & Exhaust Timing Mark
Courtesy of GENERAL MOTORS CORP.

7. Align the timing mark on the sprocket with the last matching colored link (3). Install the bolt finger tight.

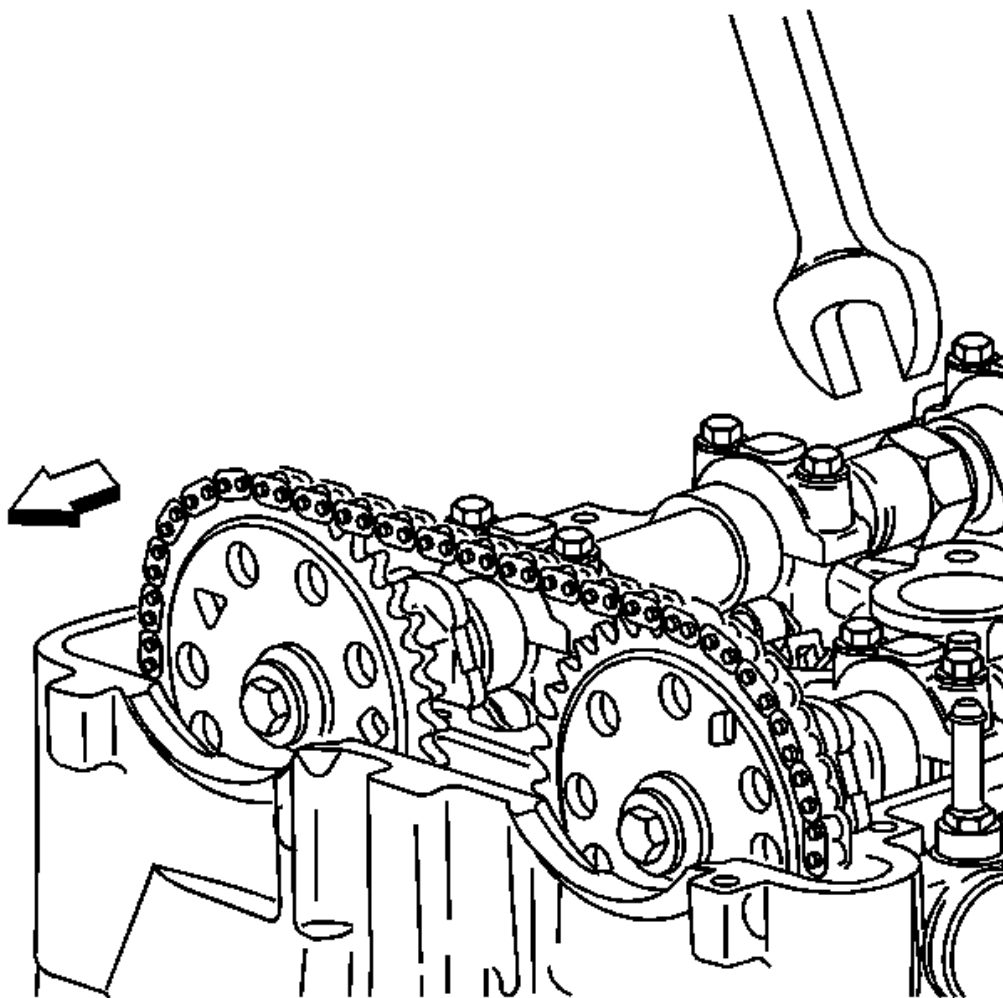


Fig. 482: Using 24 mm Wrench To Align Camshaft
Courtesy of GENERAL MOTORS CORP.

NOTE: Do not rotate either camshaft more than half turn in either direction with crankshaft at top dead center (TDC). To do so may cause valve to piston contact resulting in a damaged valve and/or a damaged piston.

8. If the camshaft is 180 degrees out of time, use the following procedure to re-align the cam.

Using a 24 mm wrench, first turn the intake camshaft until the alignment feature on the back of the camshaft sprocket seats in the notch in the front of the intake camshaft.

1. Turn the crankshaft 45 degrees in either direction.
2. Turn the intake cam to the appropriate location.
3. Turn the crankshaft back to top dead center.
9. When the sprocket seats on the cam, tighten the sprocket bolt hand tight.

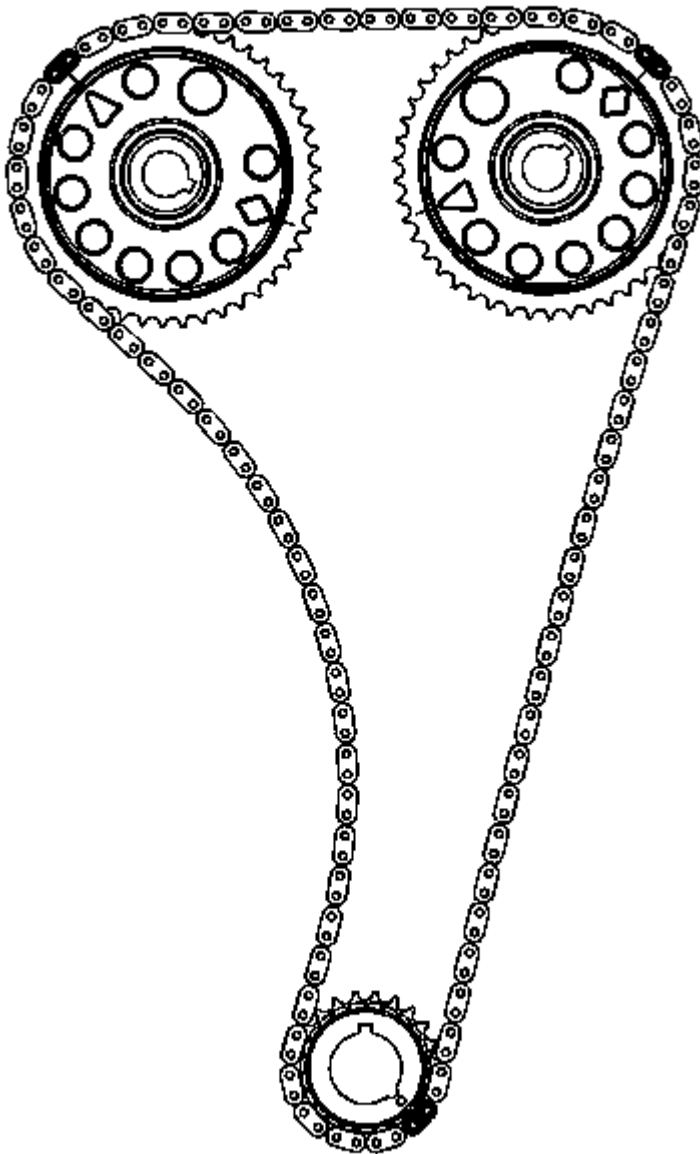


Fig. 483: View Of Sprockets And Timing Chain

Courtesy of GENERAL MOTORS CORP.

10. Verify that all of the colored links and the appropriate timing marks are still aligned. If they are not, repeat the portion of the procedure necessary to align the timing marks.

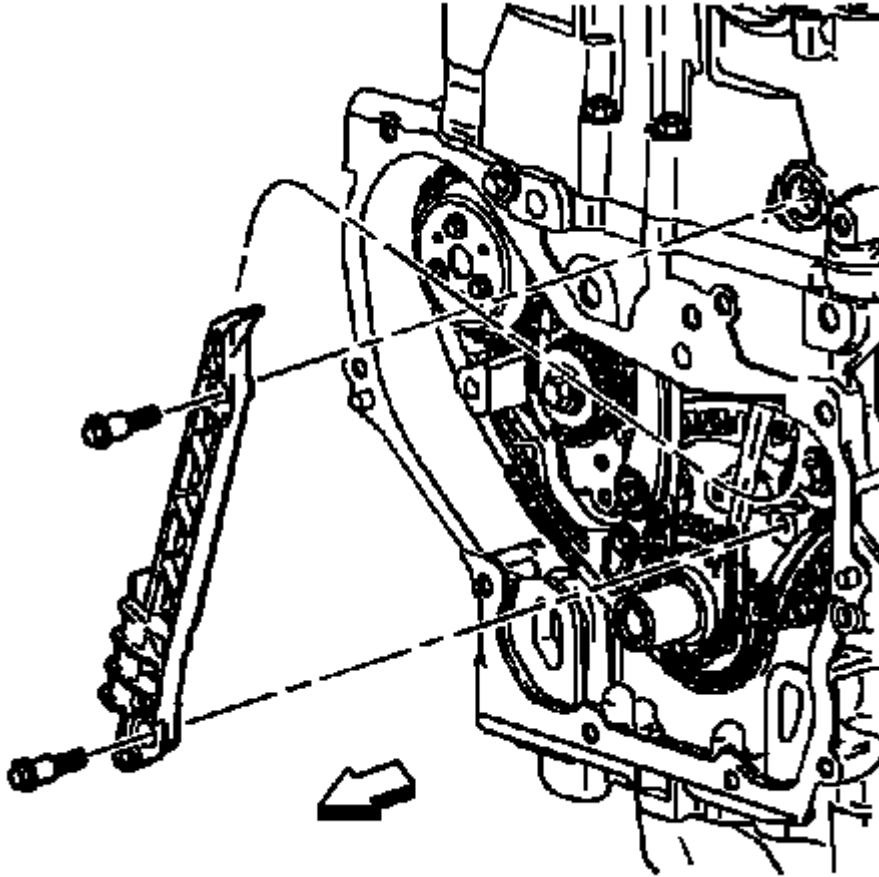


Fig. 484: View Of Fixed Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

11. Install the fixed timing chain guide.

Tighten: Tighten the fixed timing chain guide bolts to 15 N.m (11 lb ft).

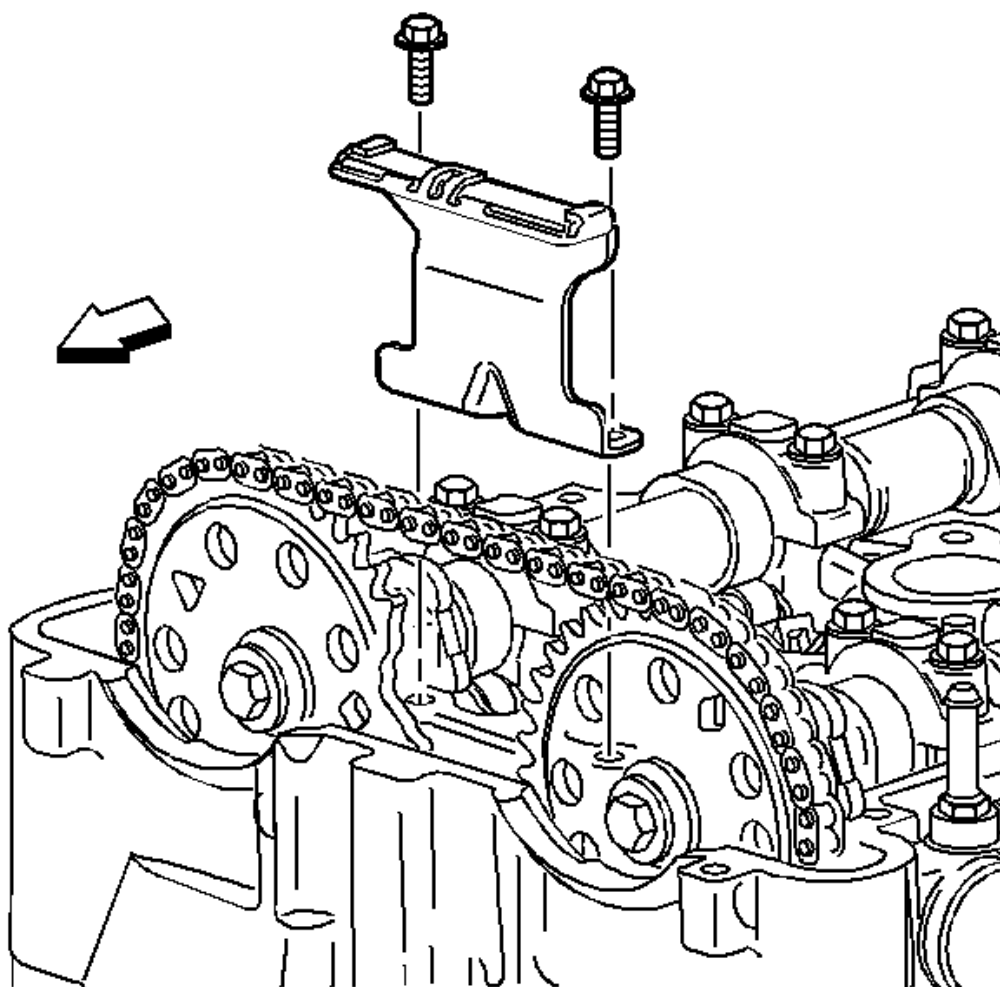


Fig. 485: View Of Upper Timing Chain Guide
Courtesy of GENERAL MOTORS CORP.

12. Install the upper timing chain guide.

Tighten: Tighten the upper timing chain guide bolts to 10 N.m (89 lb in).

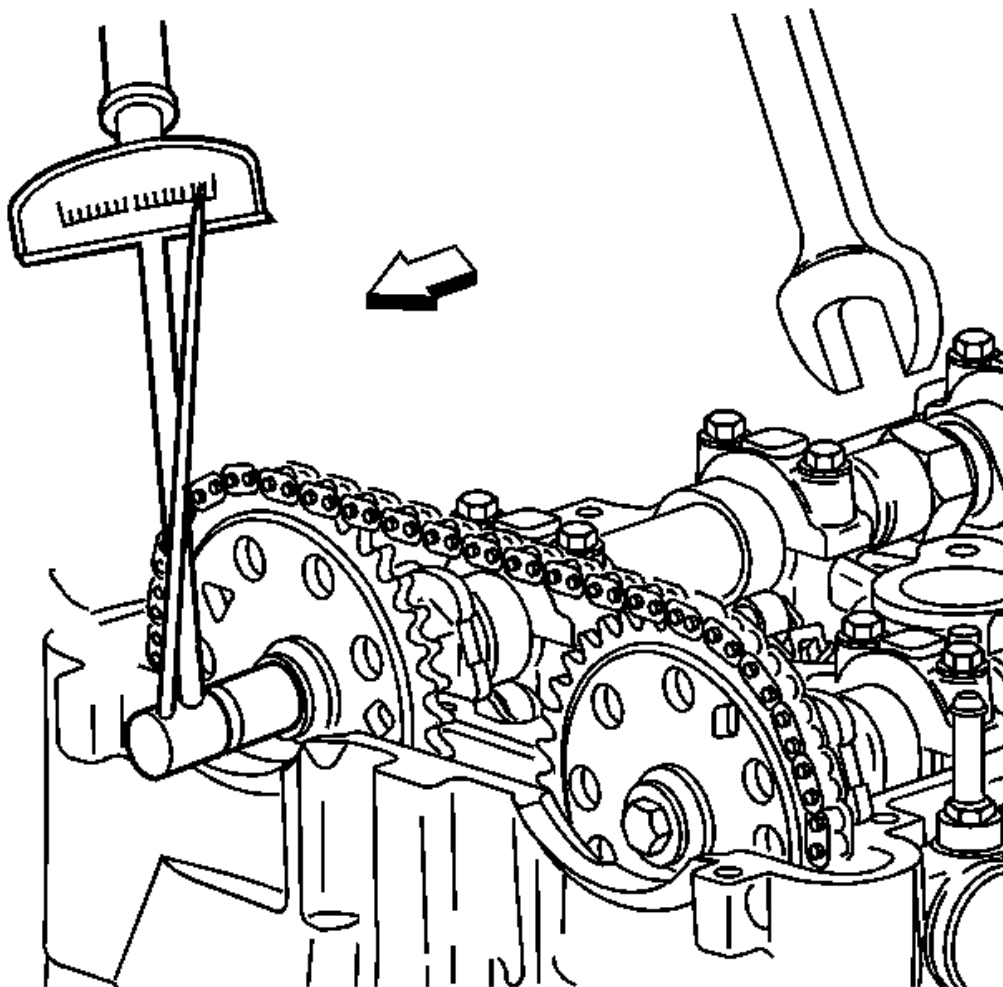


Fig. 486: Holding Camshaft Stationary With Wrench On Hex Casting On Camshaft
 Courtesy of GENERAL MOTORS CORP.

13. Using a 24 mm wrench, engage the hex on the intake camshaft and using a torque wrench, tighten the camshaft sprocket bolt.

Tighten: Tighten the intake camshaft sprocket bolt to 85 N.m (63 lb ft), plus 30 degrees using the **J 45059**.

14. Using a 24 mm wrench, engage the hex on the exhaust camshaft and using a torque wrench, tighten the camshaft sprocket bolt.

Tighten: Tighten the exhaust camshaft sprocket bolt to 85 N.m (63 lb ft), plus 30 degrees using the **J**

45059 .

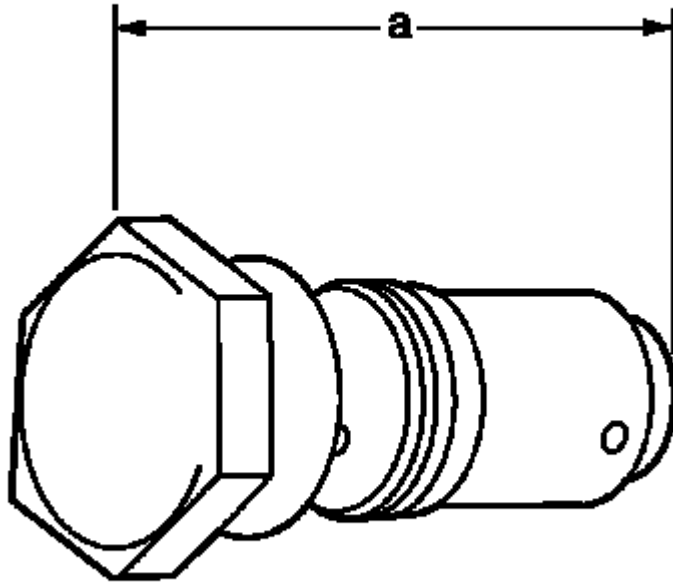


Fig. 487: Measuring Timing Chain Tensioner Assembly
Courtesy of GENERAL MOTORS CORP.

15. Inspect the timing chain tensioner seal. If the timing chain tensioner seal is damaged, replace the timing chain tensioner seal.
16. Measure the timing chain tensioner assembly from end to end.

A new tensioner should be supplied in the fully compressed non-active state. A tensioner in the compressed state will measure 72 mm (2.83 in) (a) from end to end. A tensioner in the active state will measure 85 mm (3.35 in) (a) from end to end.

17. If the timing chain tensioner is not in the compressed state, simply push in, twist, and lock by hand.

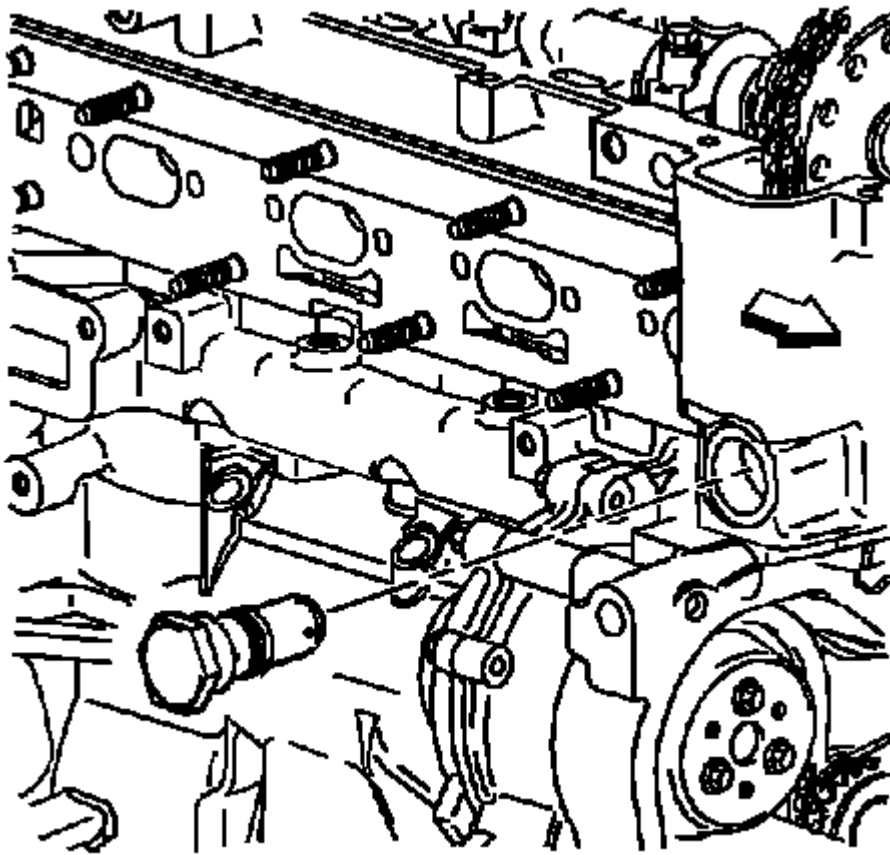


Fig. 488: Identifying Timing Chain Tensioner
Courtesy of GENERAL MOTORS CORP.

18. Inspect to ensure all dirt and debris is removed from the timing chain tensioner threaded hole in the cylinder head.

IMPORTANT: Make sure the timing chain tensioner seal is centered throughout the torque procedure to eliminate the possibility of an oil leak.

19. Install the new timing chain tensioner assembly.

Tighten: Tighten the timing chain tensioner to 75 N.m (55 lb ft).

20. The timing chain tensioner is released by compressing it 2 mm (0.079 in) which will release the locking mechanism in the ratchet. To release the timing chain tensioner, use a suitable tool with a rubber tip on the end. Feed the tool down through the cam drive chest to rest on the cam chain. Then give a sharp jolt diagonally downwards to release the tensioner.

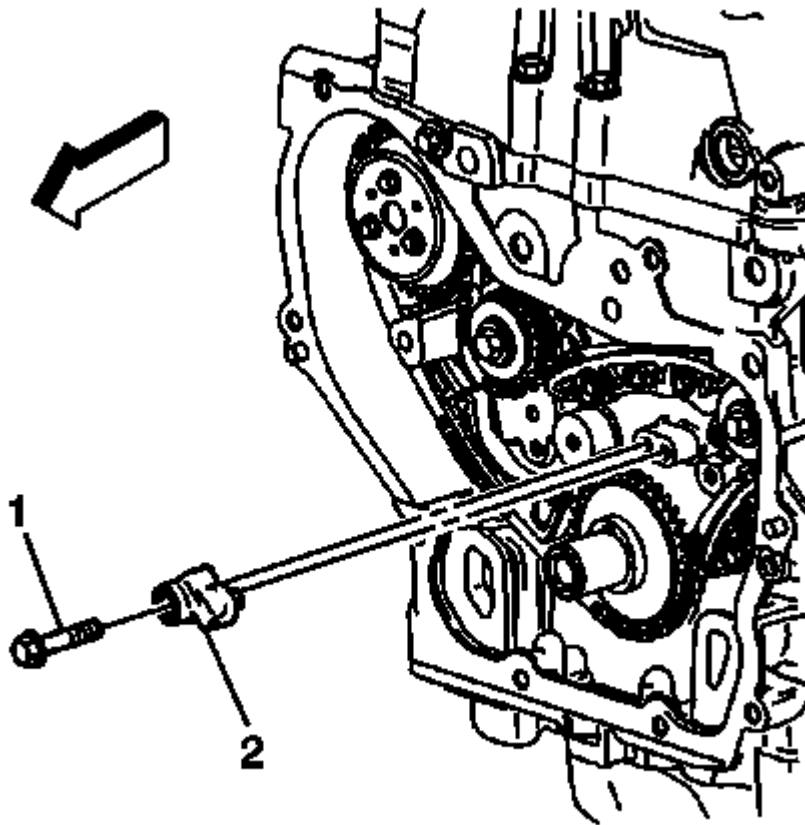


Fig. 489: View Of Oil Nozzle & Bolt
Courtesy of GENERAL MOTORS CORP.

21. Install the timing chain oiling nozzle.

Tighten: Tighten the timing chain oiling nozzle bolt to 10 N.m (89 lb in).

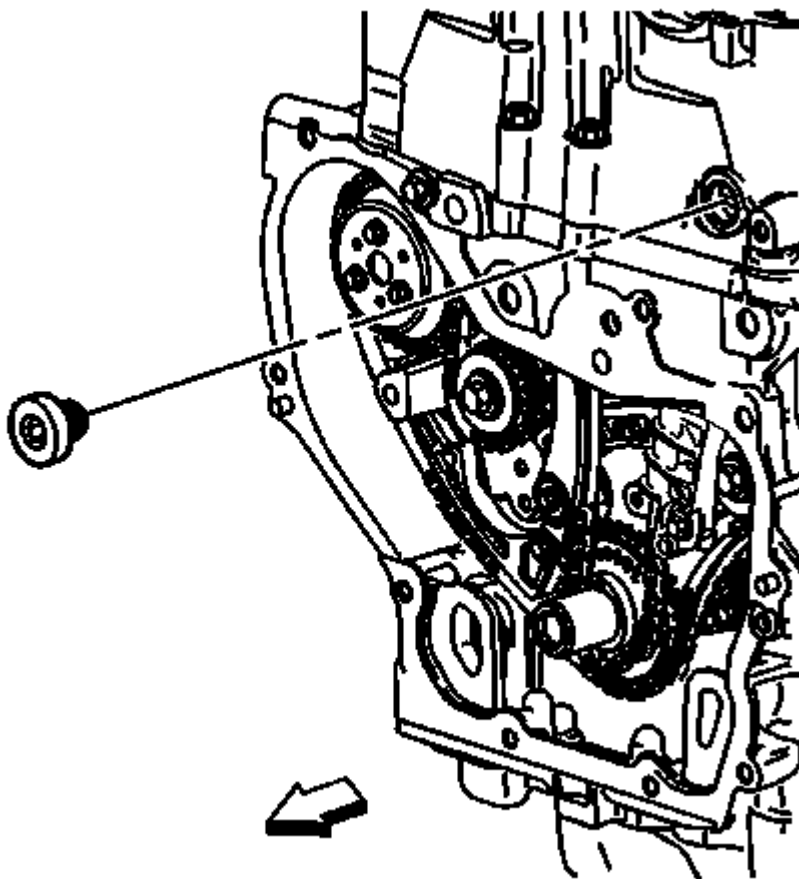


Fig. 490: View Of Fixed Timing Chain Guide Access Plug
Courtesy of GENERAL MOTORS CORP.

22. Apply sealant GM P/N 12345382 (Canadian P/N 10953489) or equivalent to the thread, and install the timing chain guide bolt access hole plug.

Tighten: Tighten the access hole plug to 90 N.m (66 lb ft).

CRANKSHAFT FRONT OIL SEAL INSTALLATION

Tools Required

J 35268-A Camshaft/Front Main Seal Installer. See Special Tools.

Installation Procedure

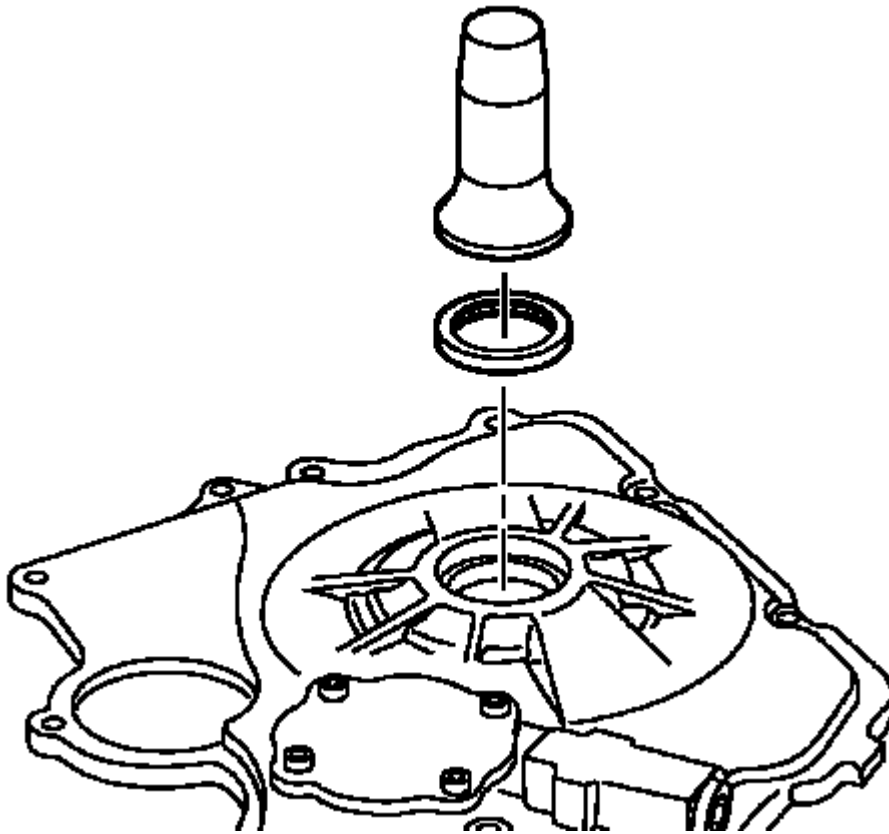


Fig. 491: Installing Crankshaft Front Oil Seal
Courtesy of GENERAL MOTORS CORP.

1. Install the seal into the front cover using the **J 35268-A** . See **Special Tools**.
2. Ensure that the engine front cover is properly supported when installing the seal.

ENGINE FRONT COVER AND OIL PUMP INSTALLATION

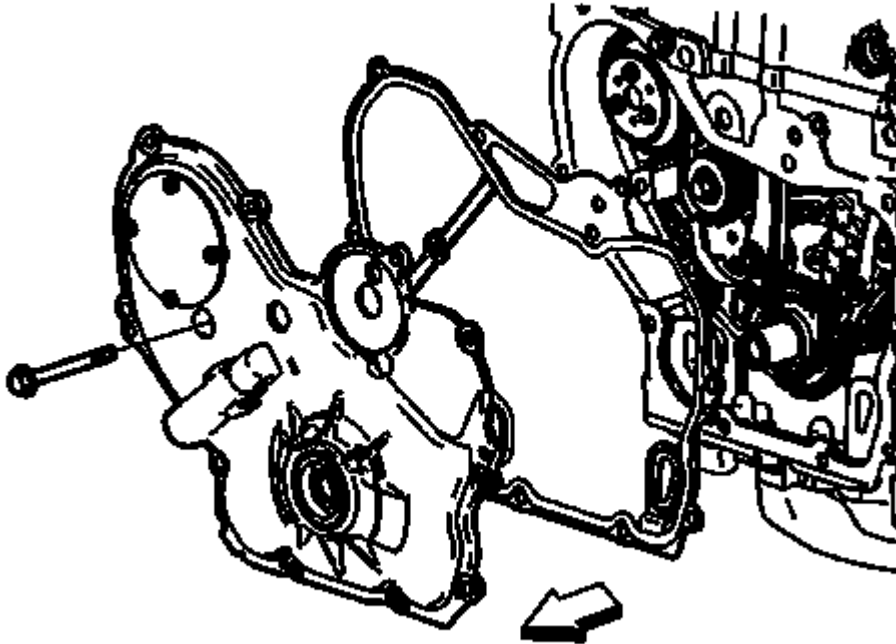


Fig. 492: View Of Engine Front Cover
Courtesy of GENERAL MOTORS CORP.

1. Install the engine front cover with a new gasket.

NOTE: Refer to FASTENER NOTICE .

2. Install the long water pump bolt.

Tighten: Tighten the water pump bolt to 25 N.m (18 lb ft).

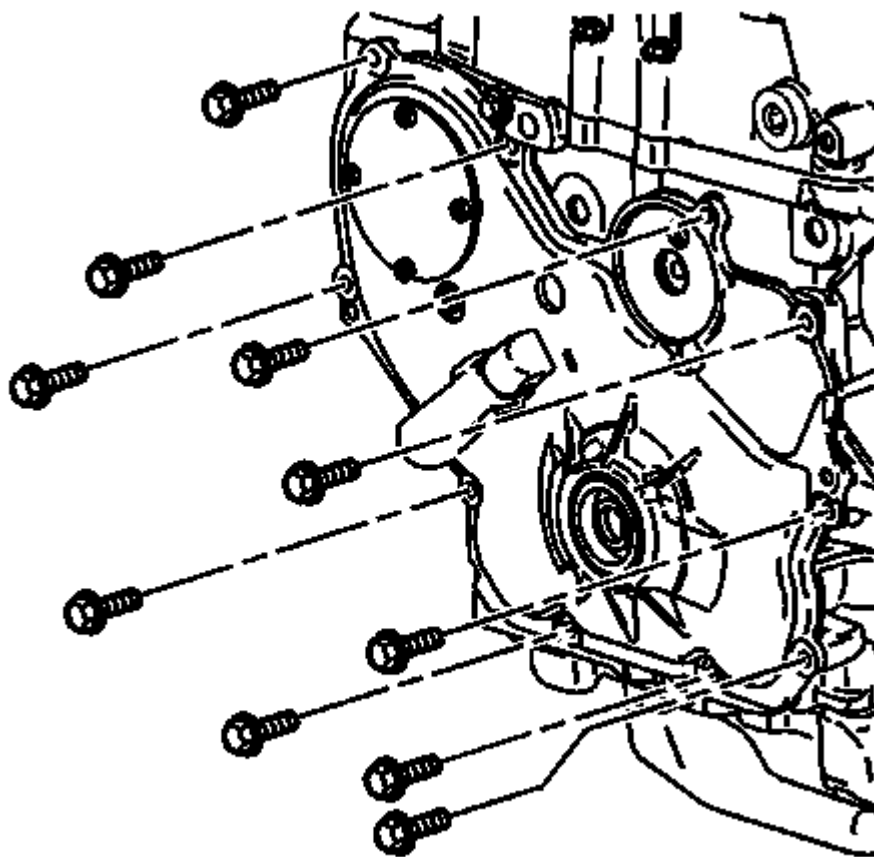


Fig. 493: View Of Engine Front Cover Bolts
Courtesy of GENERAL MOTORS CORP.

3. Install the engine front cover bolts.

Tighten: Tighten the engine front cover bolts to 25 N.m (18 lb ft).

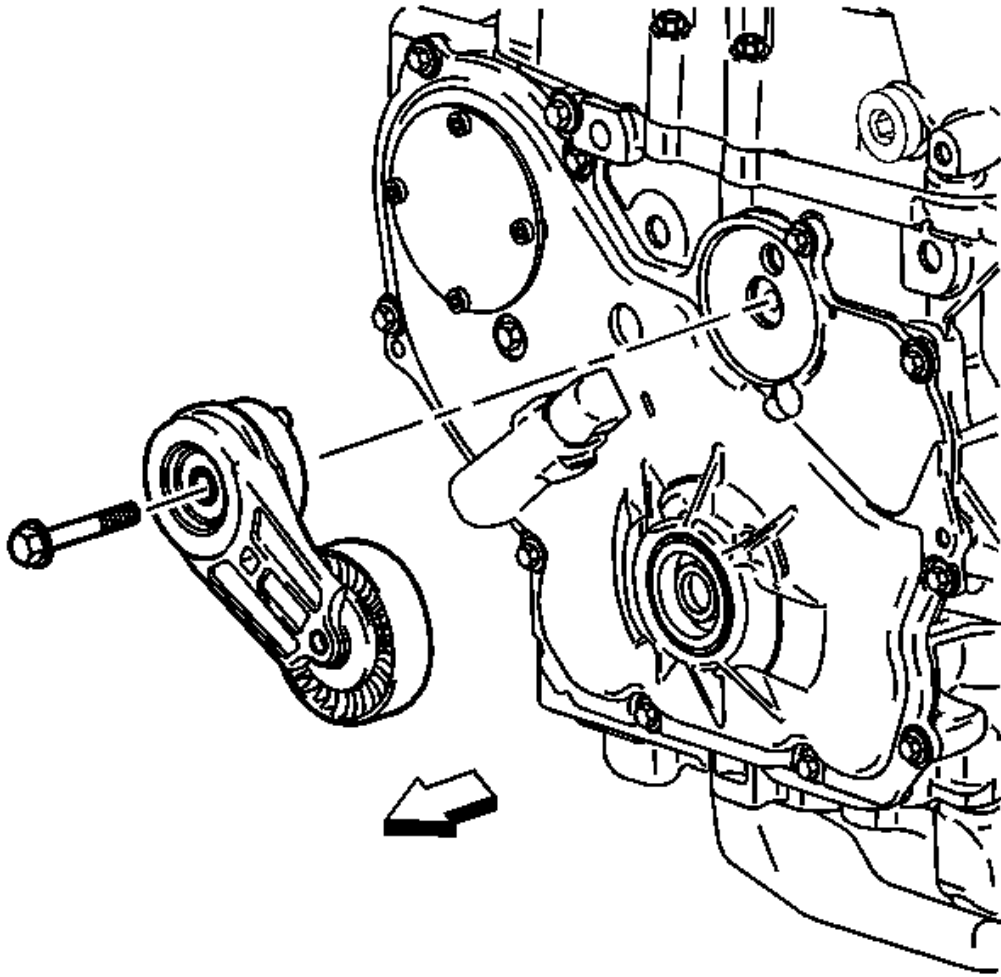


Fig. 494: View Of Drive Belt Tensioner
Courtesy of GENERAL MOTORS CORP.

4. Install the accessory drive belt tensioner.
5. Install the accessory drive belt tensioner bolt.

Tighten: Tighten the bolt to 45 N.m (33 lb ft).

CAMSHAFT COVER INSTALLATION

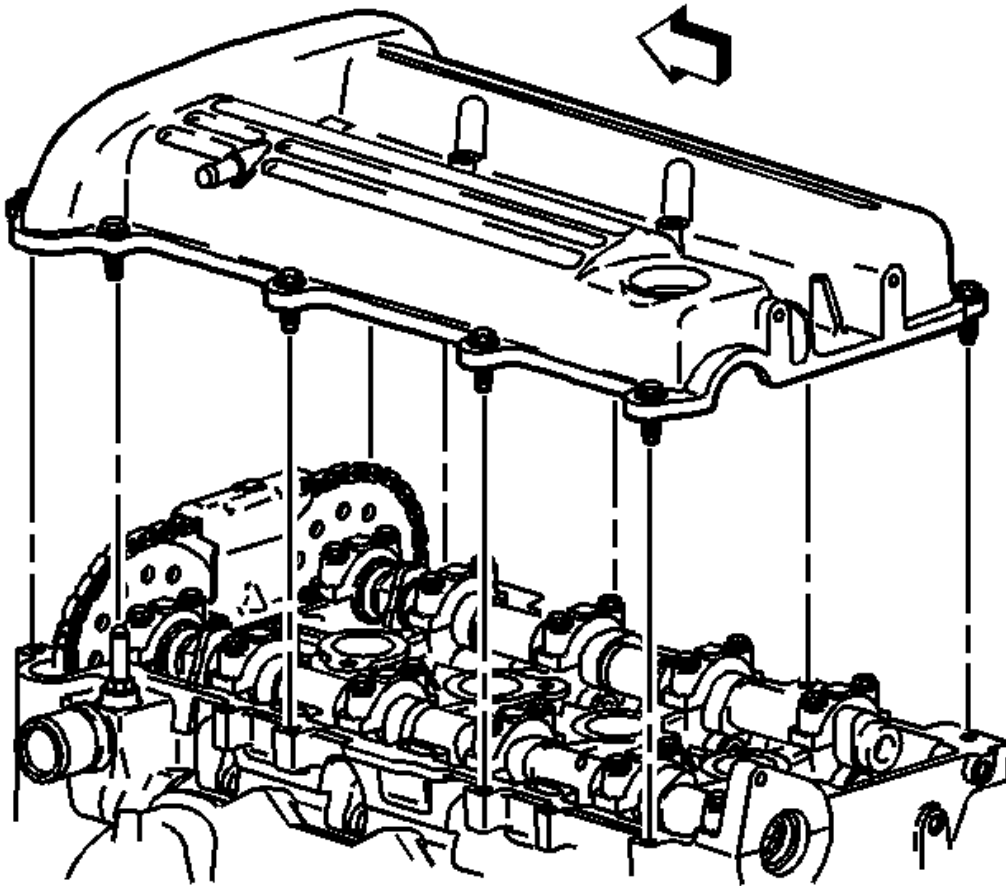


Fig. 495: View Of Camshaft Cover
Courtesy of GENERAL MOTORS CORP.

1. Assemble the camshaft cover and gasket. Ensure that the gasket is located in the retaining groove in the camshaft cover.

NOTE: Refer to **FASTENER NOTICE** .

2. Install the cover on the cylinder head and hand start the bolts.

Tighten: Tighten the camshaft cover bolts to 10 N.m (89 lb in).

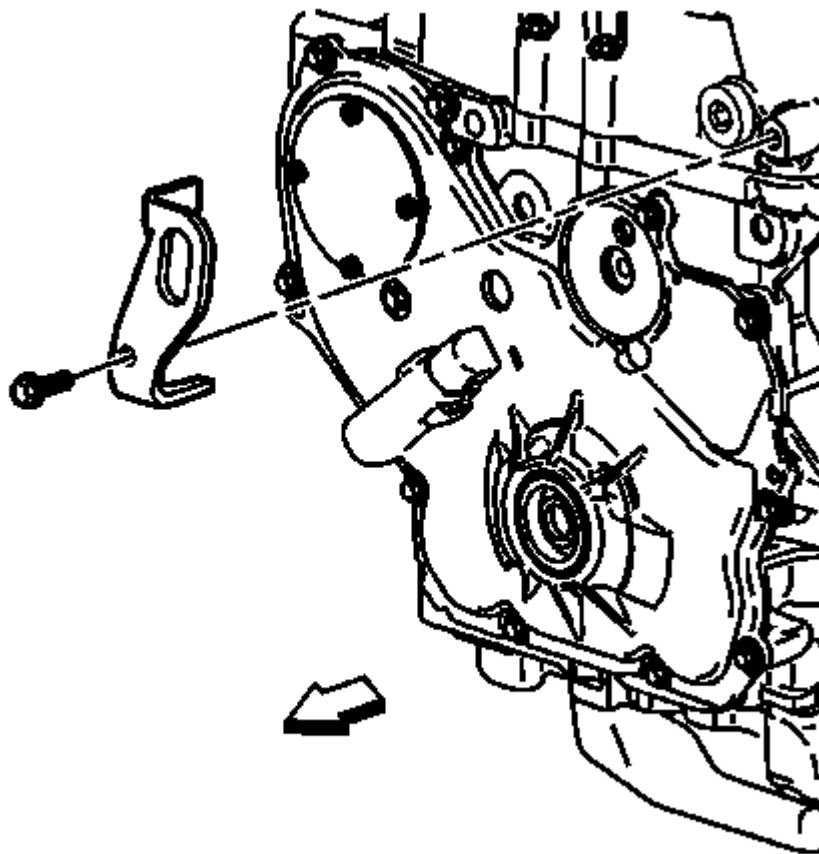


Fig. 496: View Of Front Lift Bracket
Courtesy of GENERAL MOTORS CORP.

3. Install the front lift bracket.

Tighten: Tighten the front lift bracket bolt to 25 N.m (18 lb ft).

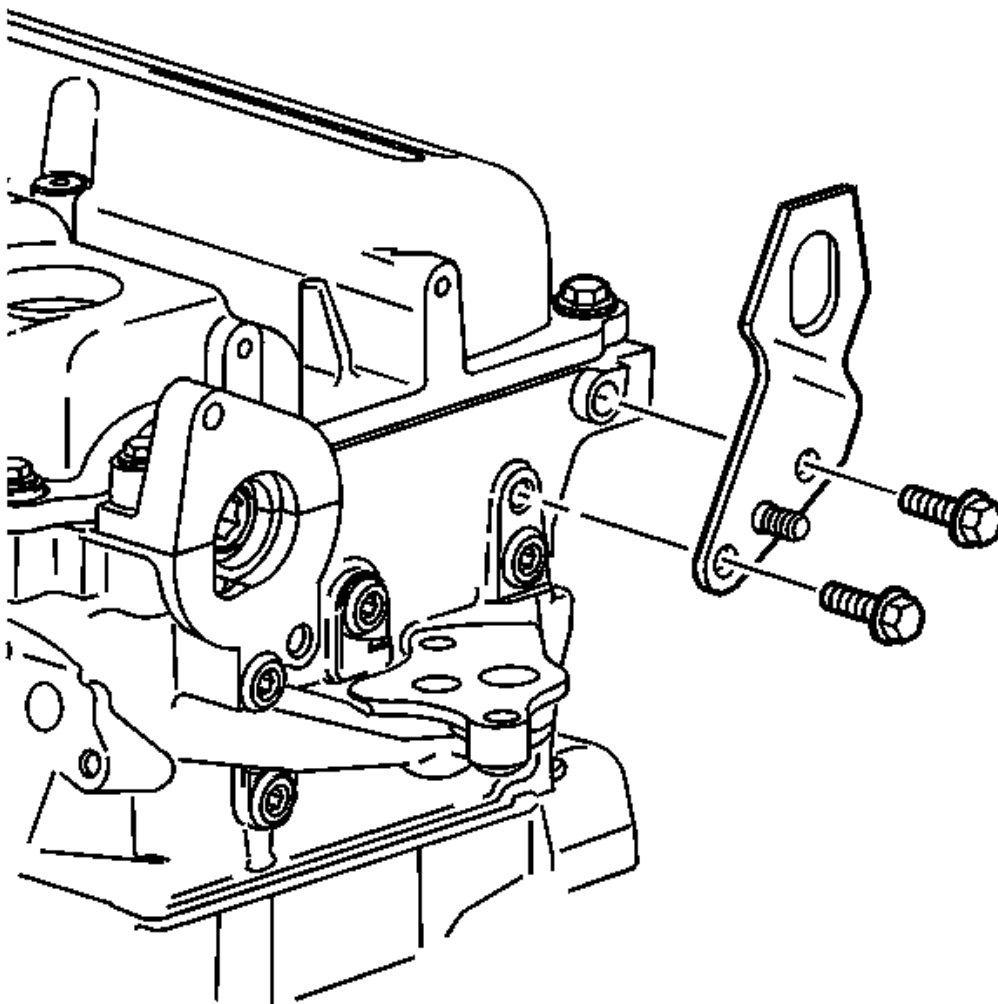


Fig. 497: View Of Rear Lift Bracket
Courtesy of GENERAL MOTORS CORP.

4. Install the rear lift bracket.

Tighten: Tighten the rear lift bracket bolts to 25 N.m (18 lb ft).

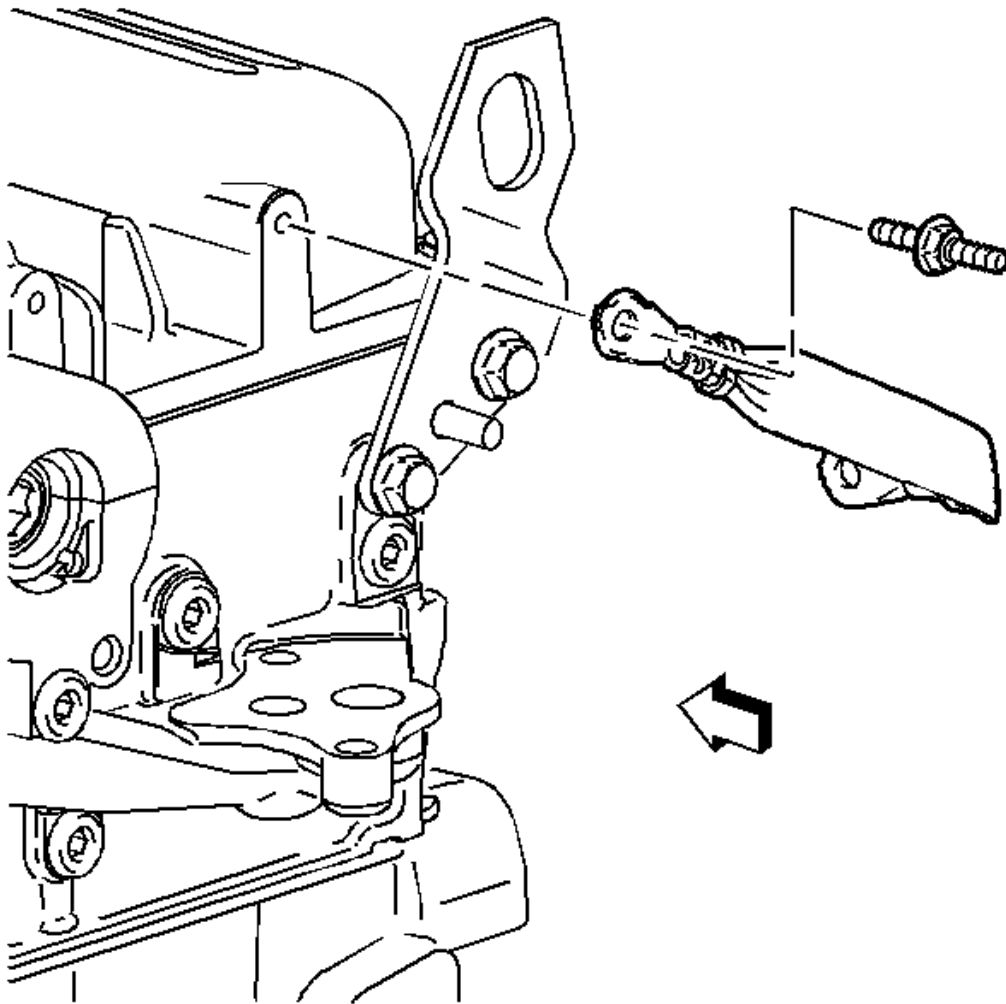


Fig. 498: View Of Camshaft Cover Ground Strap
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **FASTENER NOTICE** .

5. Install the ground strap.

Tighten: Tighten the camshaft cover ground strap bolts to 10 N.m (89 lb in).

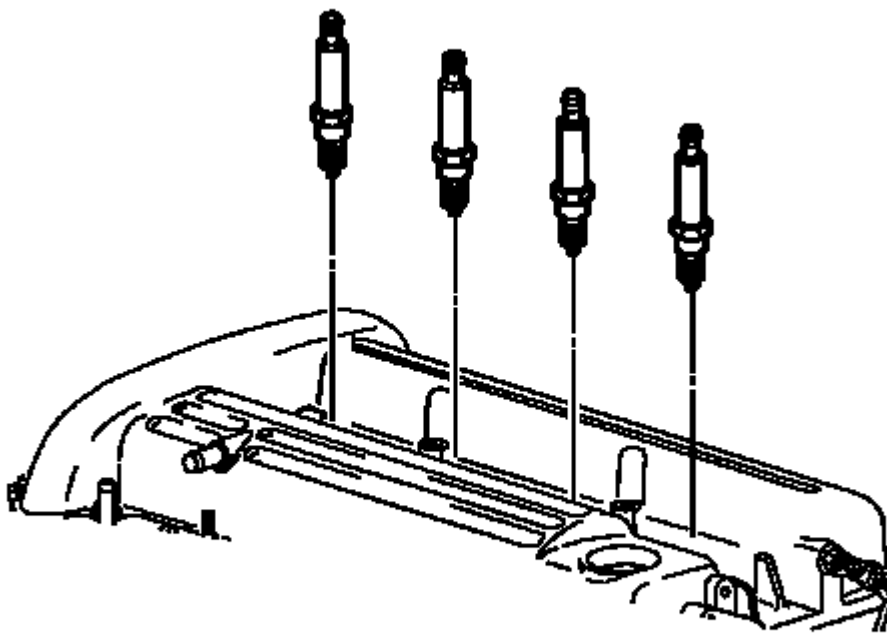


Fig. 499: View Of Spark Plugs
Courtesy of GENERAL MOTORS CORP.

6. Install the spark plugs.

Tighten: Tighten the spark plugs to 20 N.m (15 lb ft).

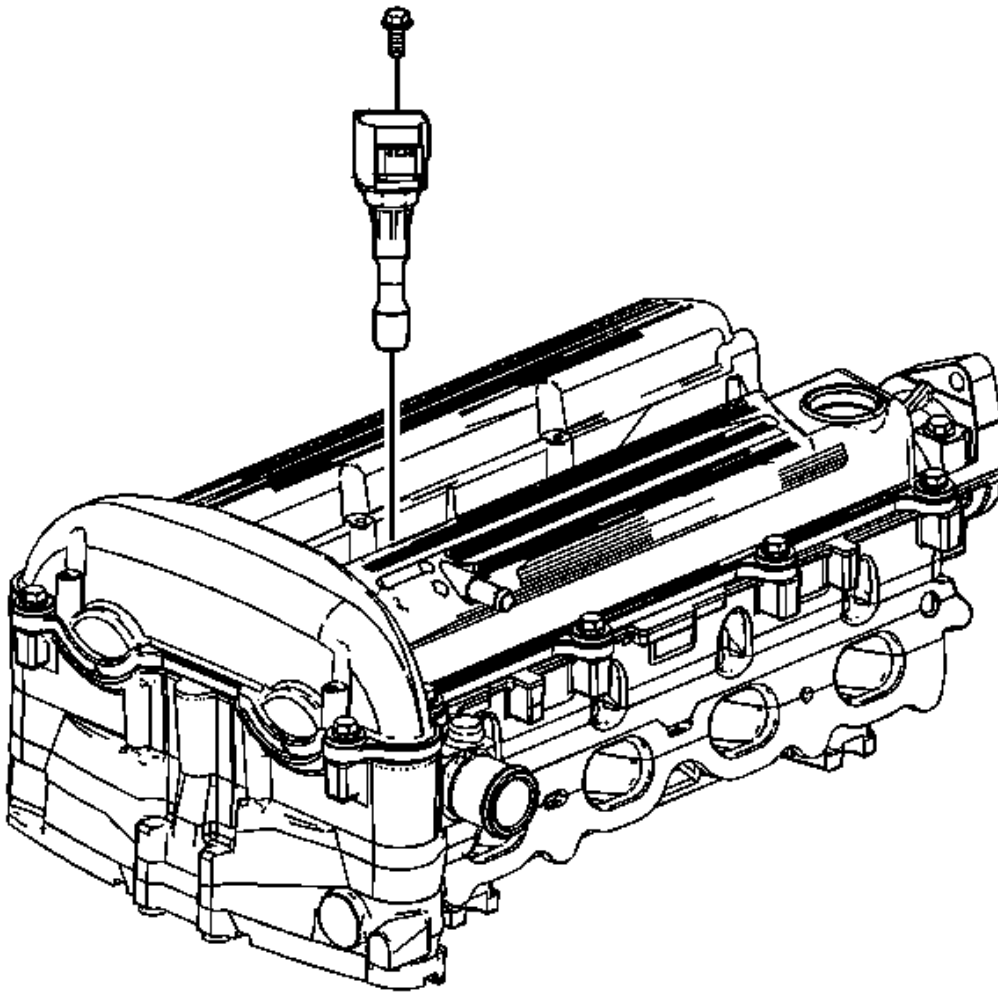


Fig. 500: View Of Ignition Coil And Mounting Bolt
Courtesy of GENERAL MOTORS CORP.

7. Install the ignition coil.
8. Install the ignition coil bolts.

Tighten: Tighten the ignition coil bolts to 10 N.m (89 lb in).

OIL PAN INSTALLATION

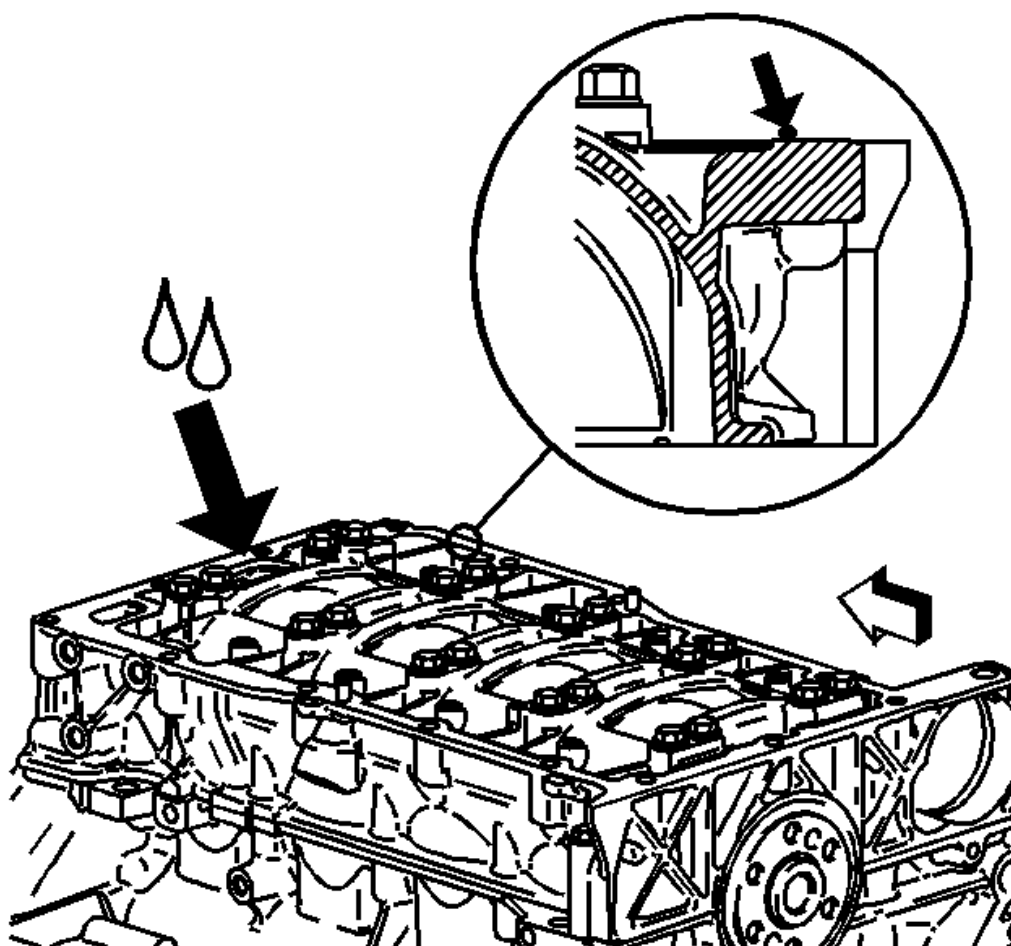


Fig. 501: Applying RTV Around Perimeter Of Oil Pan & Oil Suction Port Opening
Courtesy of GENERAL MOTORS CORP.

1. Make sure that the oil pan and mounting surface on the lower crankcase are free of all oil and debris.
2. Apply a 3.5 mm bead of GM P/N 12378521 (Canadian P/N 88901148) or equivalent around the perimeter of the oil pan and the oil suction port opening.

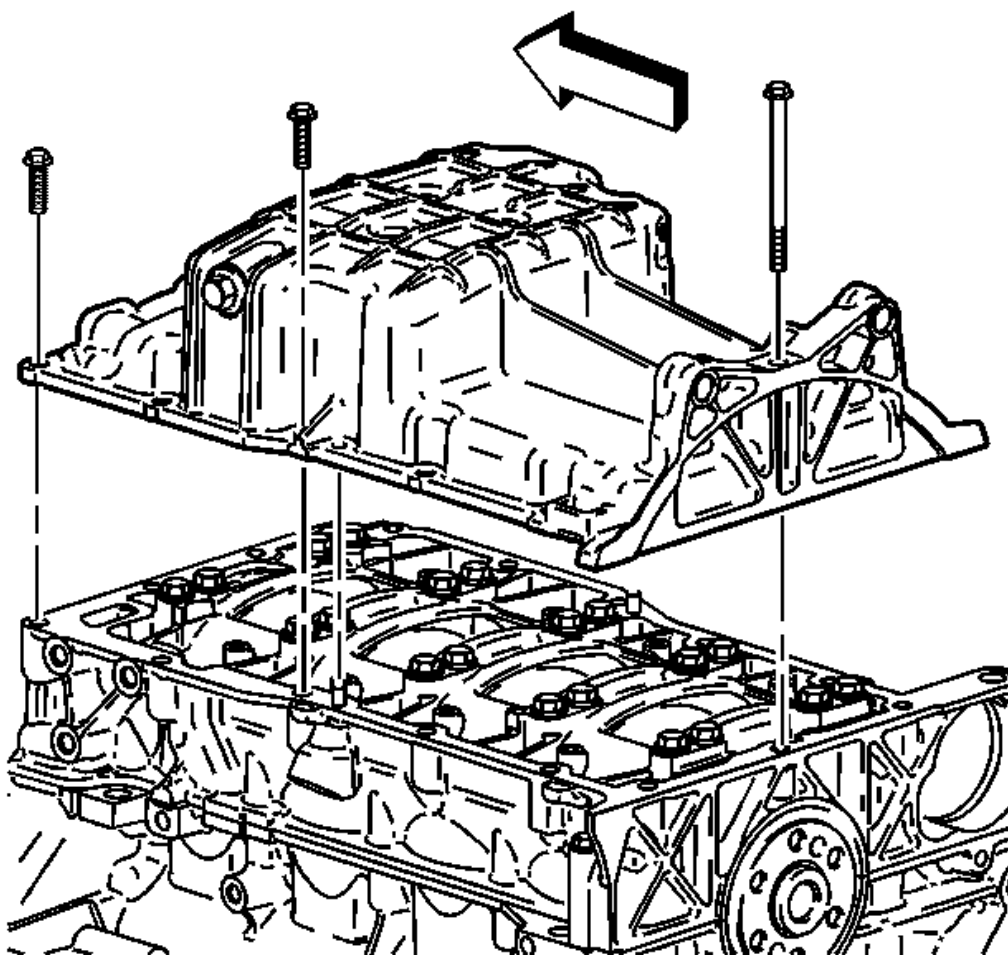


Fig. 502: Installing Oil Pan

Courtesy of GENERAL MOTORS CORP.

3. Install the oil pan.

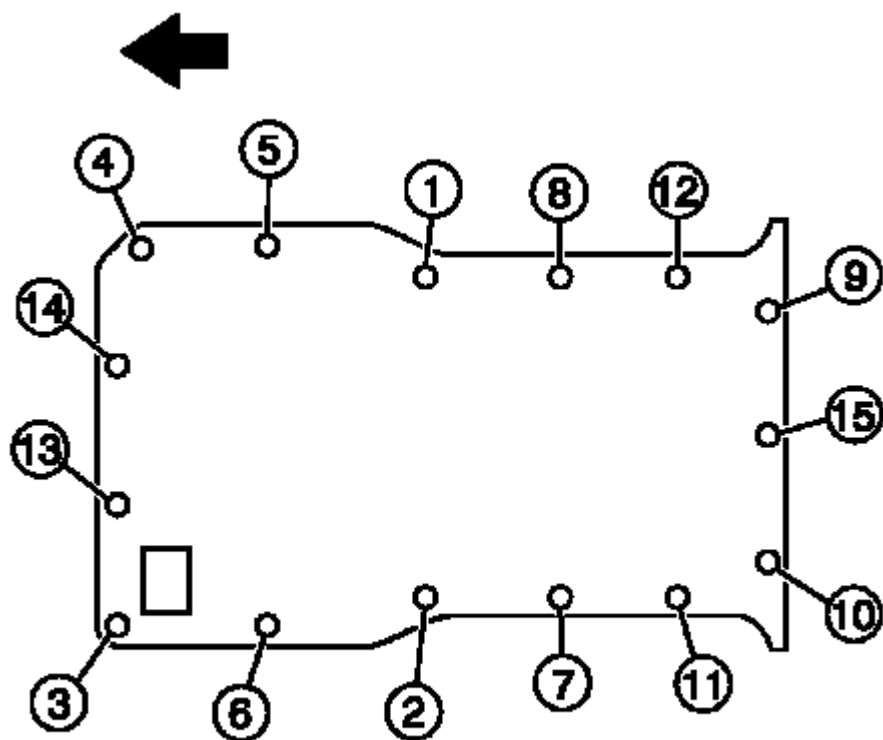


Fig. 503: Identifying Oil Pan Bolts Removal & Tightening Sequence
 Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to FASTENER NOTICE .

4. Install the oil pan bolts.

Tighten: Tighten the oil pan bolts to 25 N.m (18 lb ft) in sequence.

CRANKSHAFT BALANCER INSTALLATION

Special Tools

- **EN-48585** Crankshaft Balancer Guide
- **J 38122-A** Crankshaft Balancer Holder. See Special Tools.
- **J 45059** Angle Meter

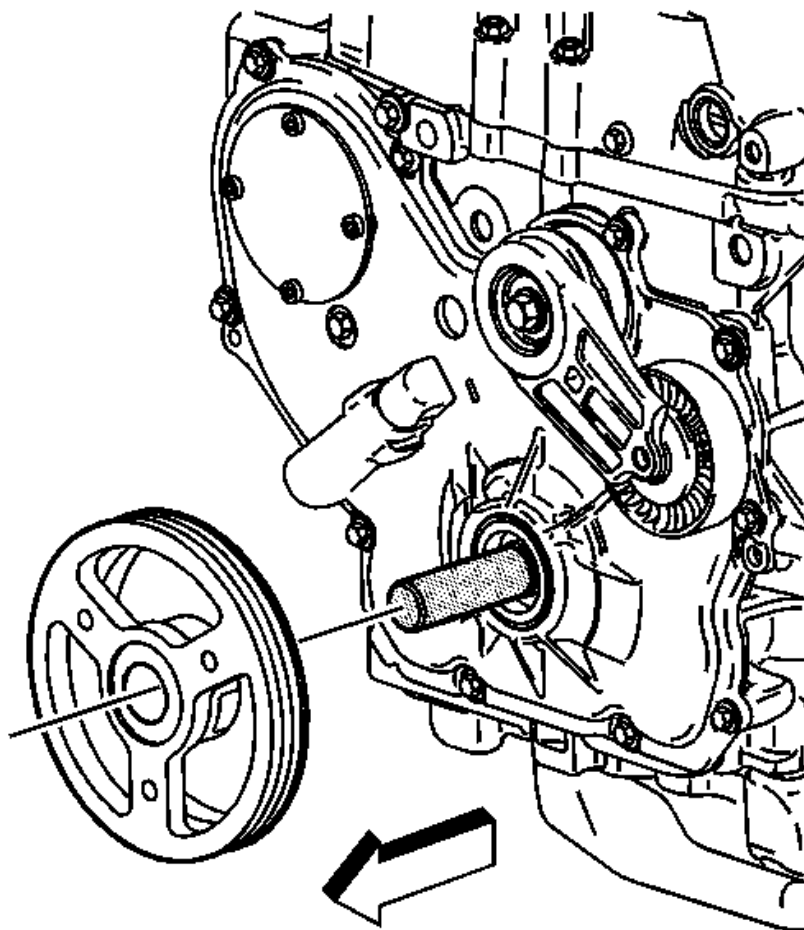


Fig. 504: View Of Crankshaft Balancer
Courtesy of GENERAL MOTORS CORP.

NOTE: Ensure both components are aligned correctly or serious engine damage will occur.

1. Install the **EN-48585** into the end of the crankshaft.
2. Install the balancer onto the **EN-48585** . Use care to properly align the keyway and flats on the balancer with the oil pump drive.

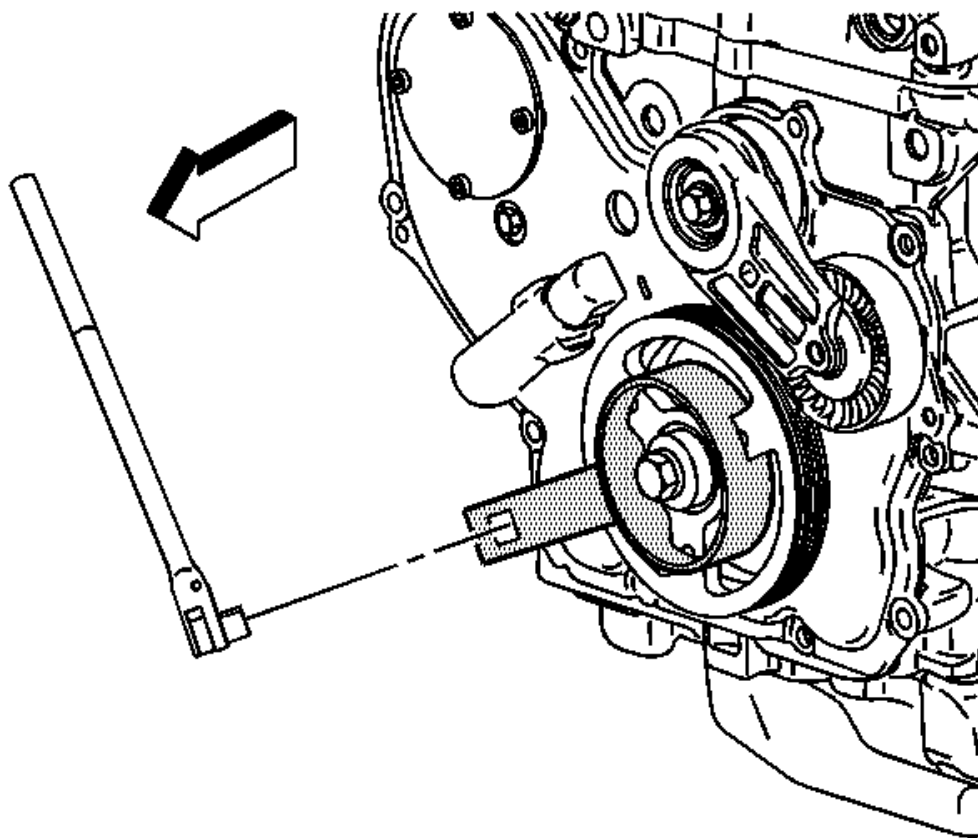


Fig. 505: View Of Harmonic Balancer Holder J38122-A
Courtesy of GENERAL MOTORS CORP.

3. Install the J 38122-A . See Special Tools.

NOTE: Refer to FASTENER NOTICE .

IMPORTANT: Always install a new crankshaft balancer retaining bolt and washer.

4. Install a new retaining bolt and washer. Use the J 38122-A and a breaker bar to prevent the crankshaft from rotating when tightening the bolt. See Special Tools.

Tighten: Tighten the bolt to 100 N.m (74 lb ft) plus 125 degrees using the J 45059 .

OIL FILTER ADAPTER INSTALLATION

Tools Required

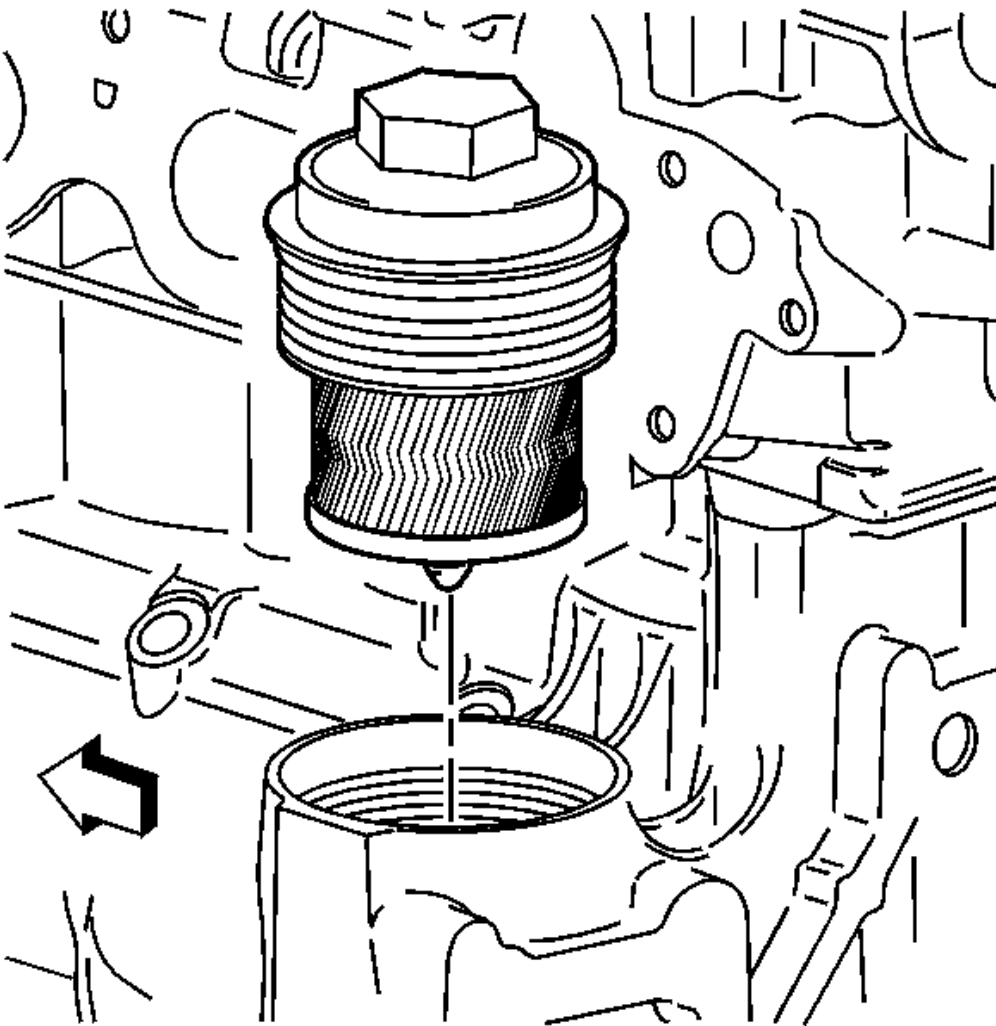
J 44887 Oil Filter Wrench**Installation Procedure**

Fig. 506: Identifying Oil Filter Housing
Courtesy of GENERAL MOTORS CORP.

1. Install a new oil filter on the oil filter cap.
2. Lubricate the O-ring on the oil filter cap with 5W30 engine oil.

NOTE: Refer to **FASTENER NOTICE** .

3. Use **J 44887** to install the oil filter adapter.

Tighten: Tighten the oil filter adapter to 22 N.m (16 lb ft).

INTAKE MANIFOLD INSTALLATION

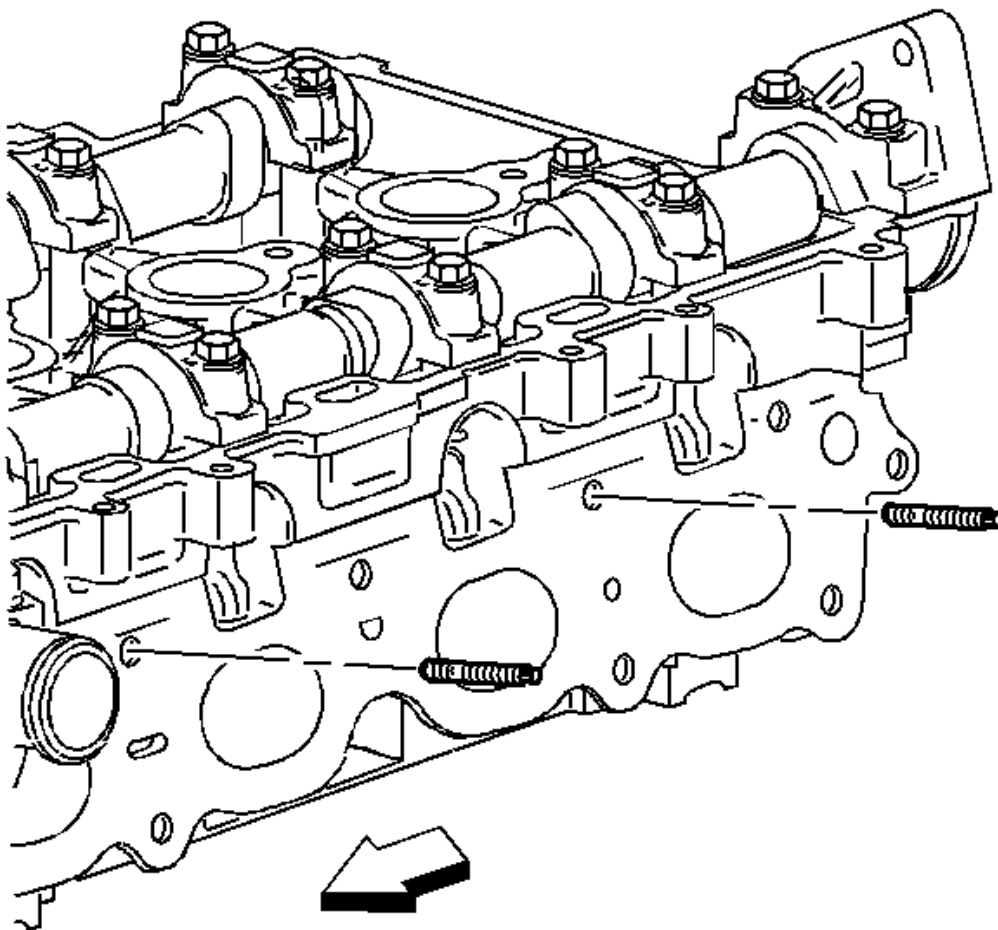


Fig. 507: View Of Intake Manifold Studs
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to **Fastener Notice** .

1. Install the intake manifold studs in the manifold face.

Tighten: Tighten the intake manifold studs to 6 N.m (60 lb in).

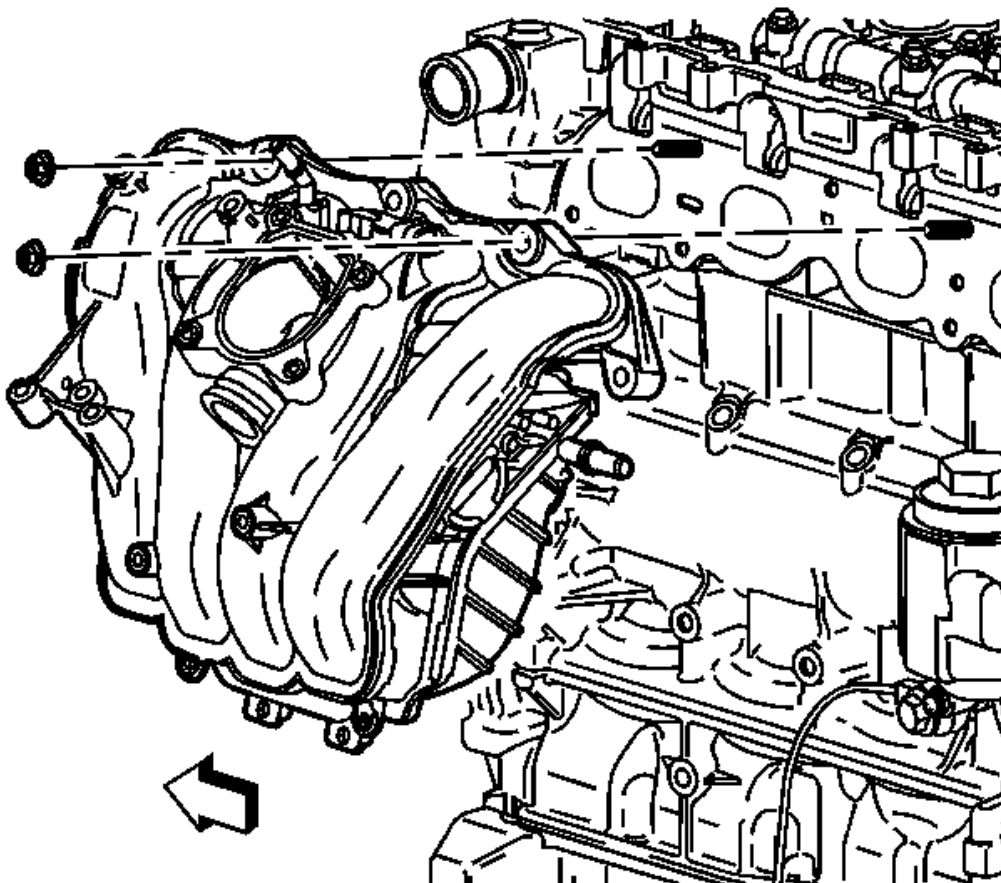


Fig. 508: Installing Intake Manifold
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Gaskets must be clean. Swollen gaskets should be replaced.

2. Install a NEW intake manifold gasket on the intake manifold, if necessary.
3. Install the intake manifold.
4. Install the intake manifold bolts and nuts. Follow the tightening sequence.

Tighten: Tighten the bolts and nuts to 10 N.m (89 lb in).

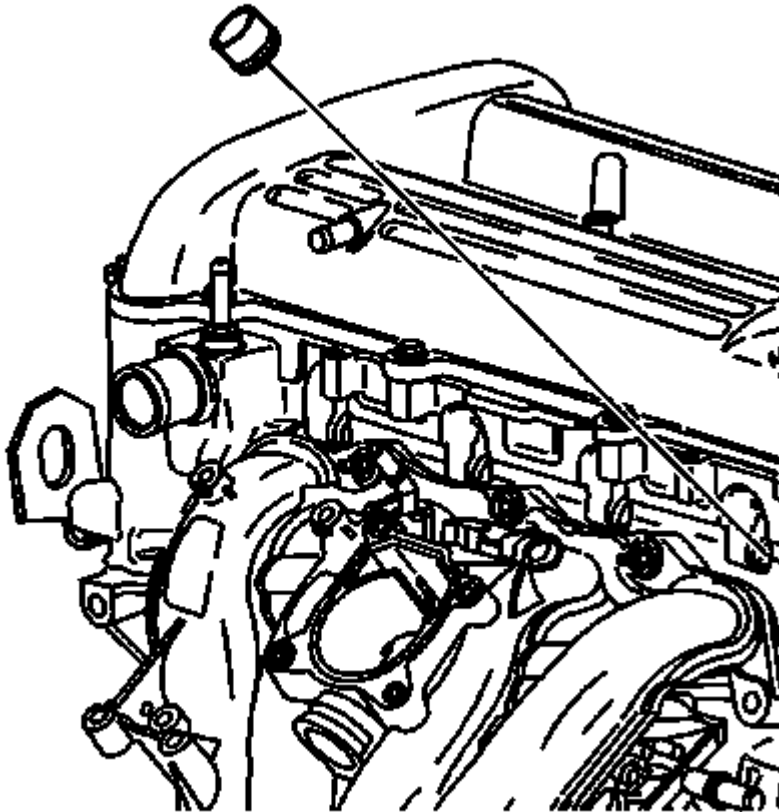


Fig. 509: View Of Fuel Injector Tip Insulators
Courtesy of GENERAL MOTORS CORP.

5. Lubricate NEW fuel injector tip insulators with engine oil.
6. Install the NEW fuel injector tip insulators.

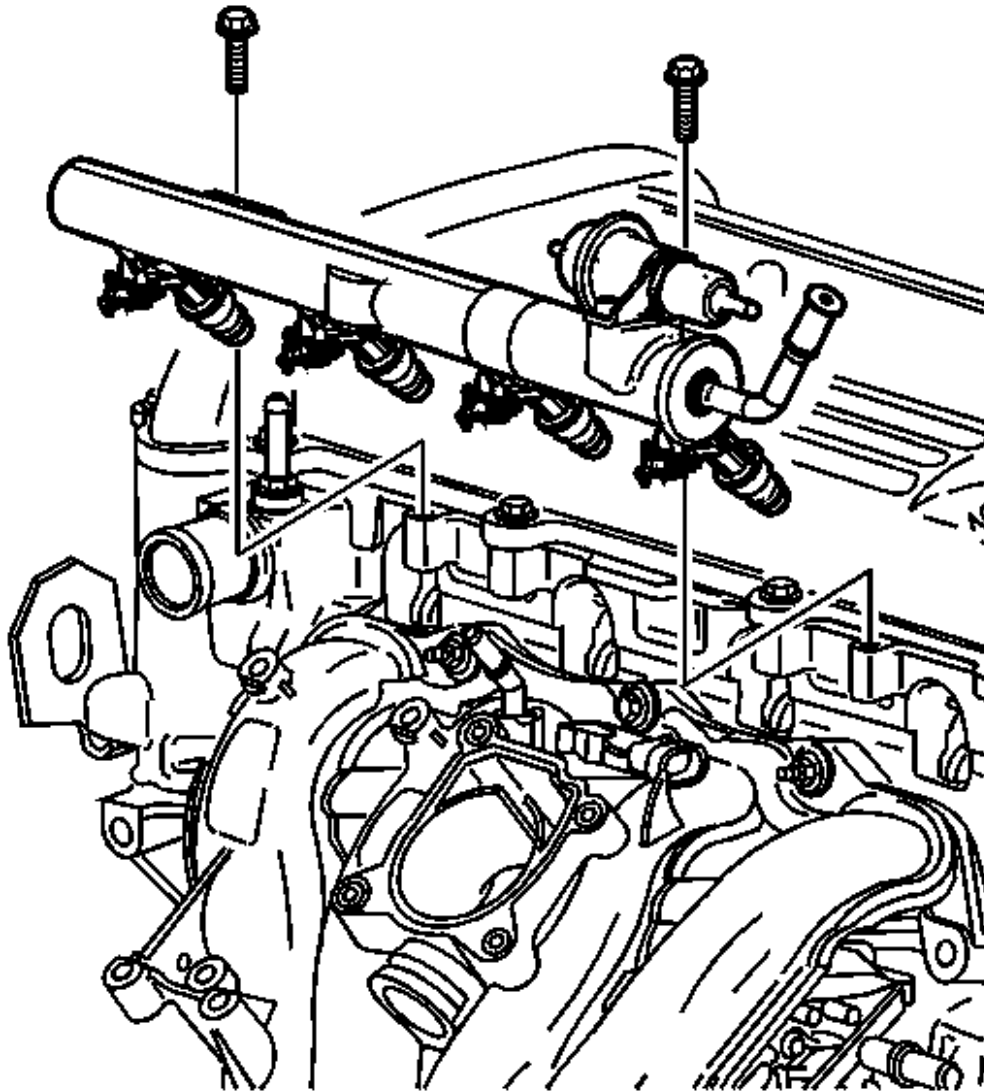


Fig. 510: Identifying Fuel Rail Assembly
Courtesy of GENERAL MOTORS CORP.

7. Install the fuel rail assembly.
8. Install the fuel rail bolts.

Tighten: Tighten the bolts to 10 N.m (89 lb in).

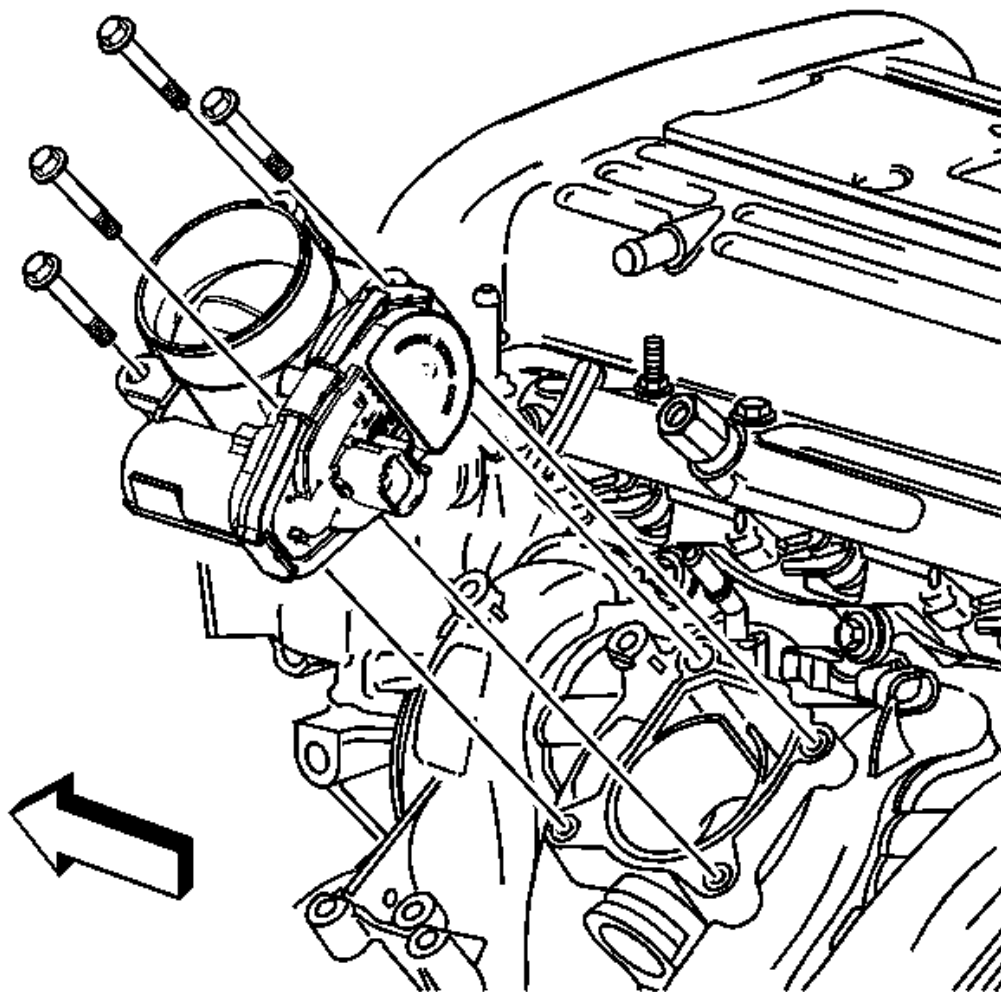


Fig. 511: View Of Throttle Body & Bolts
Courtesy of GENERAL MOTORS CORP.

9. Install the throttle body and bolts.

Tighten: Tighten the bolts to 10 N.m (89 lb in).

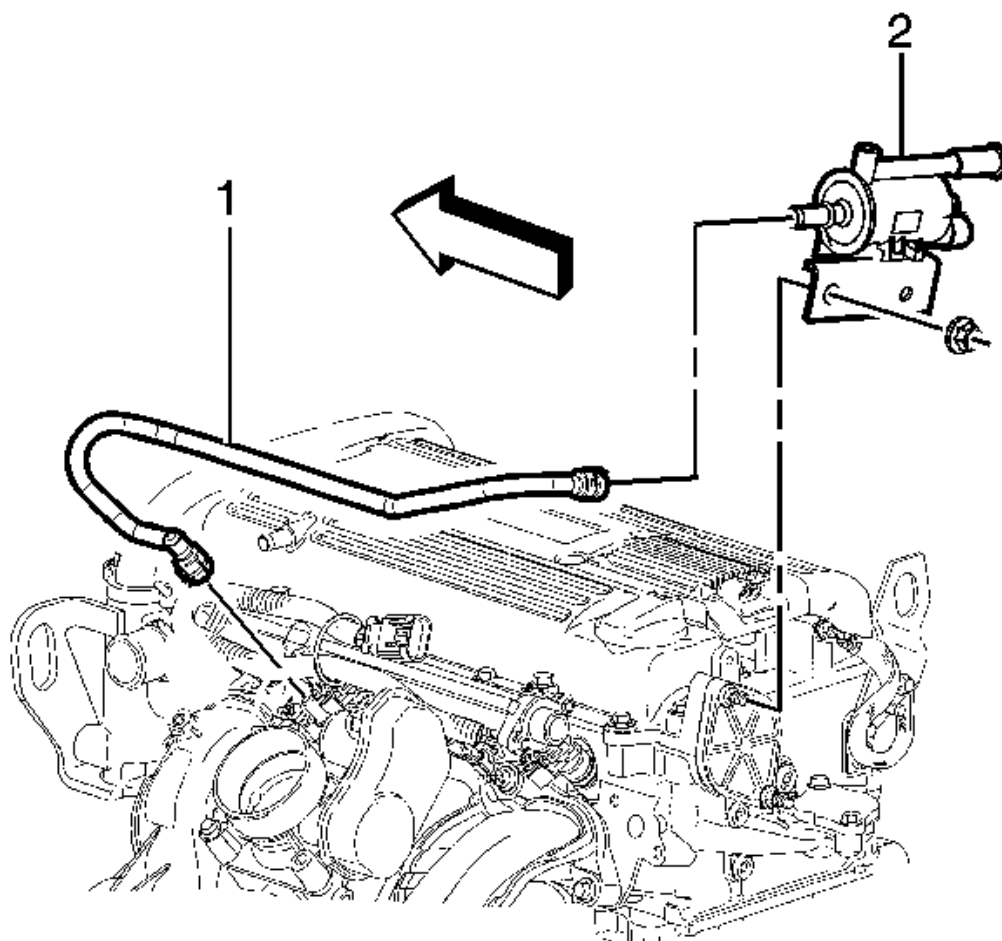


Fig. 512: View Of EVAP Emission Canister Valve & Tube
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: Ensure that the rear metal tab of the evaporative emission (EVAP) canister valve is resting on the power steering pump metal body.

10. Install the EVAP canister valve (2).

Tighten: Tighten the EVAP canister valve nut to 18 N.m (13 lb ft).

11. Install the EVAP canister valve tube (1).

EXHAUST MANIFOLD INSTALLATION

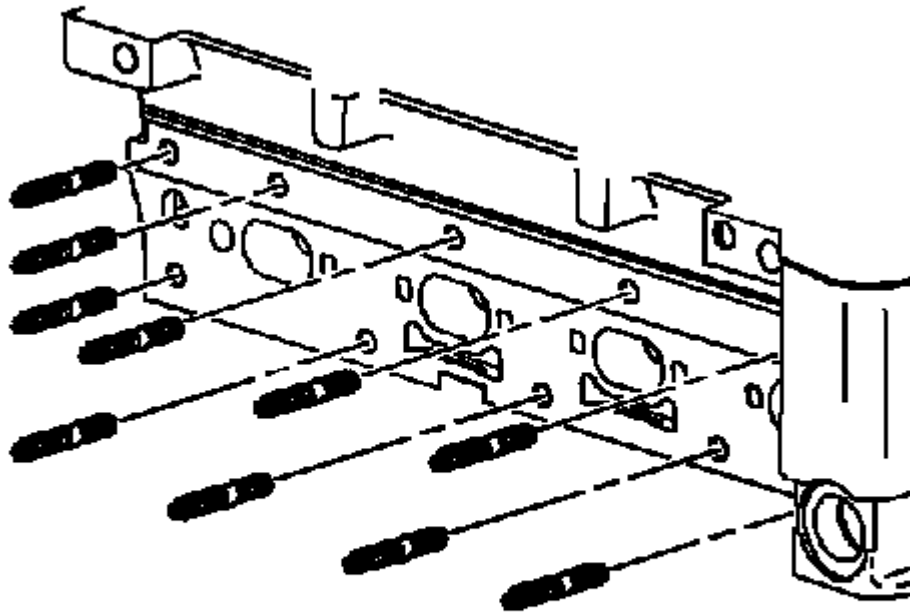


Fig. 513: View Of Exhaust Manifold Studs
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice .

1. Install NEW exhaust manifold studs, if necessary.

Tighten: Tighten the studs to 10 N.m (89 lb in).

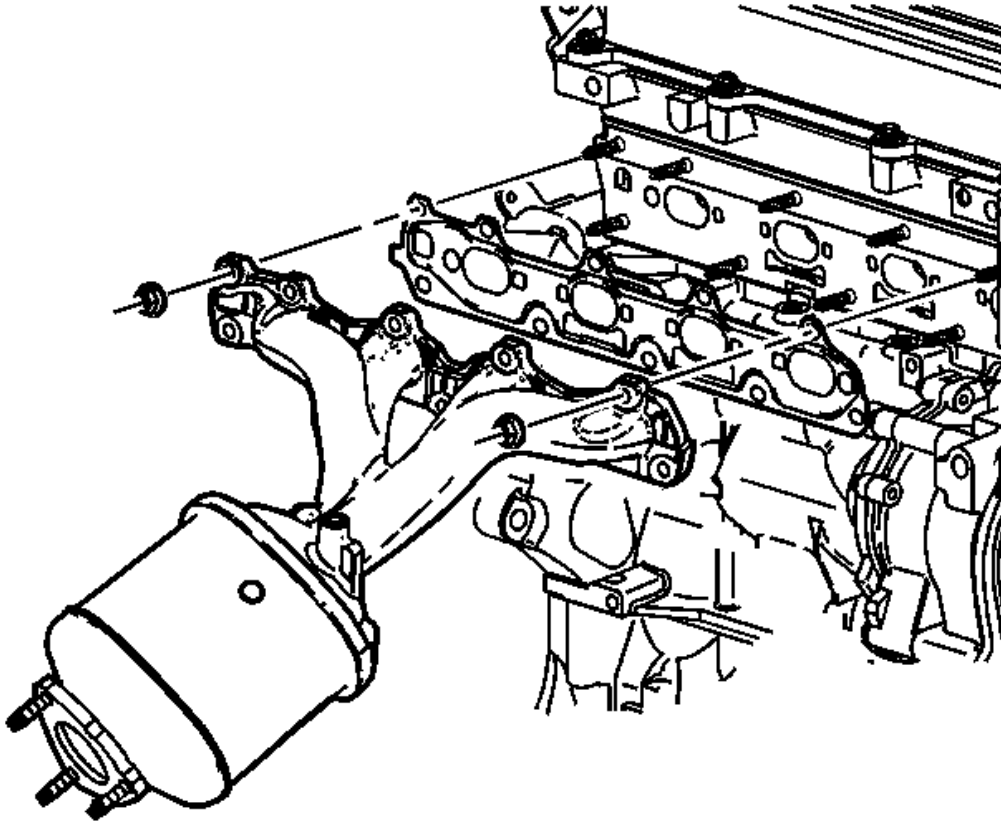


Fig. 514: View Of Exhaust Manifold And Catalytic Converter Assembly
Courtesy of GENERAL MOTORS CORP.

2. Install the exhaust manifold gasket.
3. Install the exhaust manifold and catalytic converter assembly to the cylinder head.
4. Install NEW exhaust manifold to cylinder head retaining nuts finger tight.

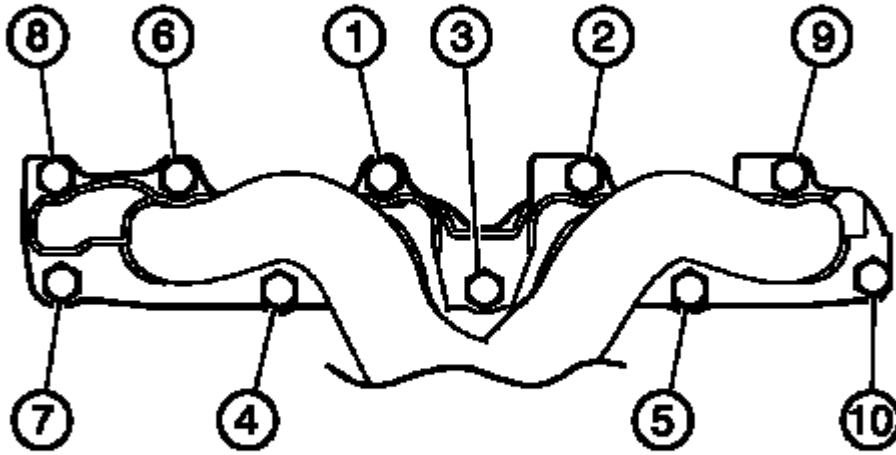


Fig. 515: Exhaust Manifold Bolt Tightening Sequence
 Courtesy of GENERAL MOTORS CORP.

5. Tighten the NEW exhaust manifold cylinder head retaining nuts in sequence.

Tighten: Tighten the nuts a second time to 14 N.m (124 lb in).

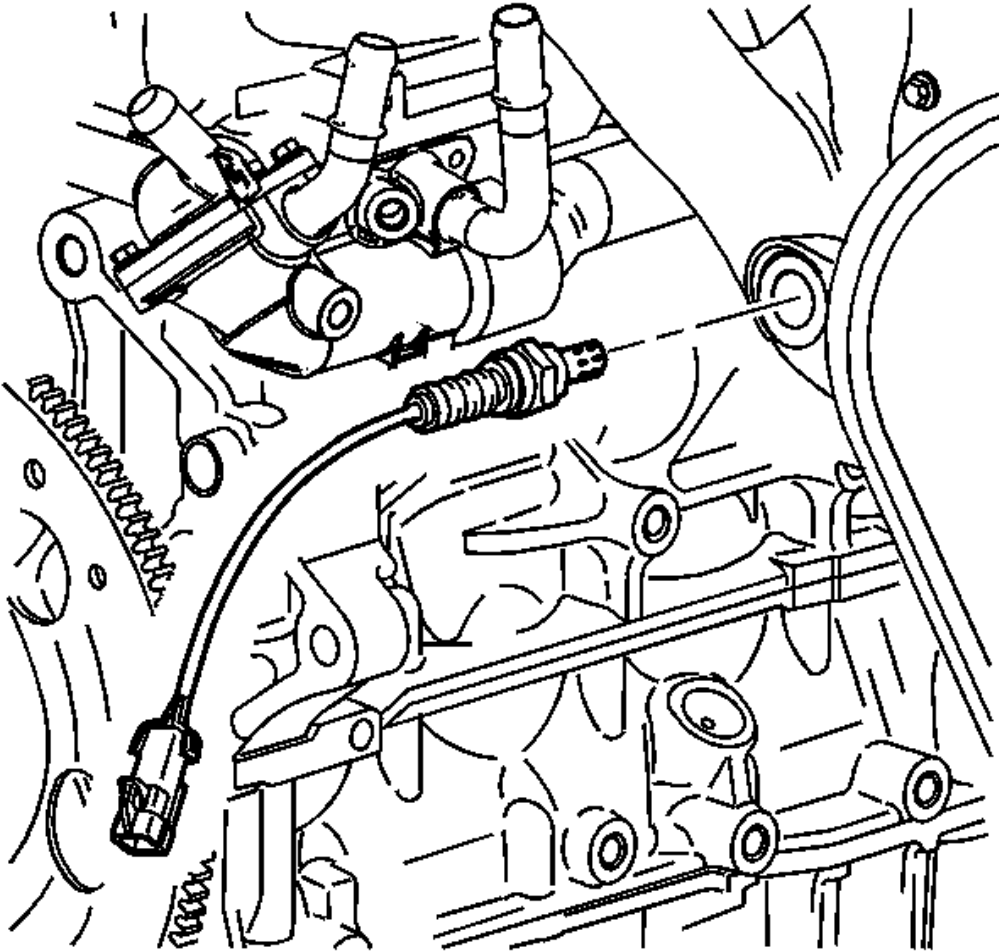


Fig. 516: View Of Oxygen Sensor
Courtesy of GENERAL MOTORS CORP.

6. Coat the threads of the oxygen sensor with anti-seize compound GM P/N 12397953.
7. Install the oxygen sensor.

Tighten: Tighten the oxygen sensor to 42 N.m (31 lb ft).

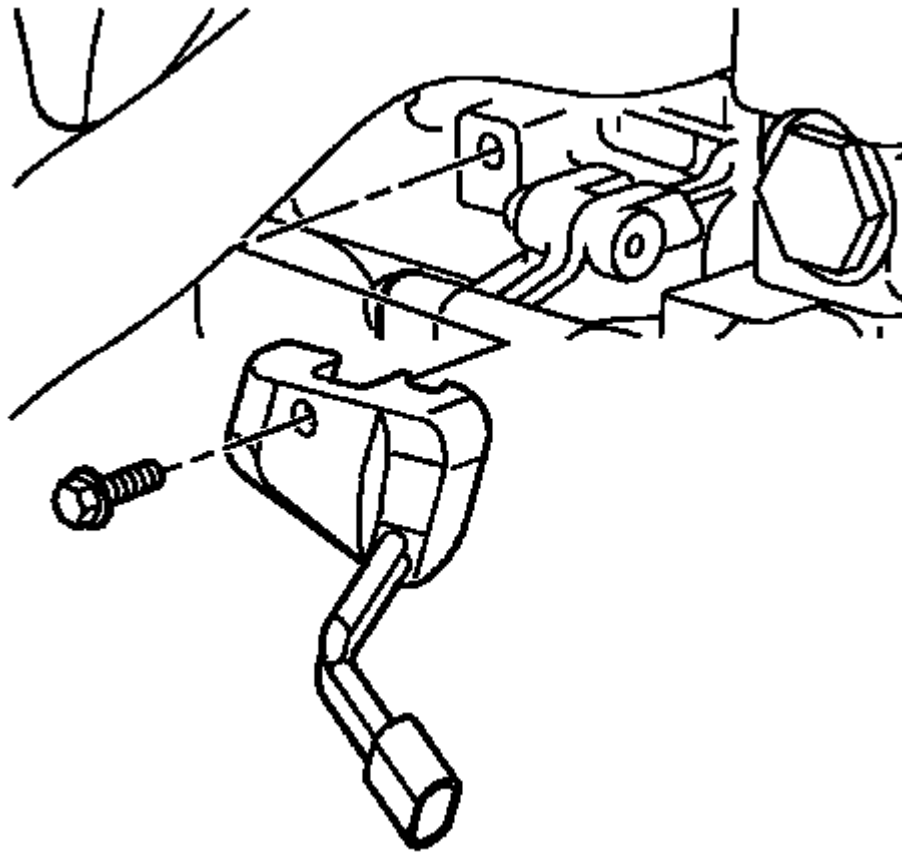


Fig. 517: View Of Block Heater
Courtesy of GENERAL MOTORS CORP.

8. Install the block heater and bolt, if equipped.

Tighten: Tighten the bolt to 10 N.m (89 lb in).

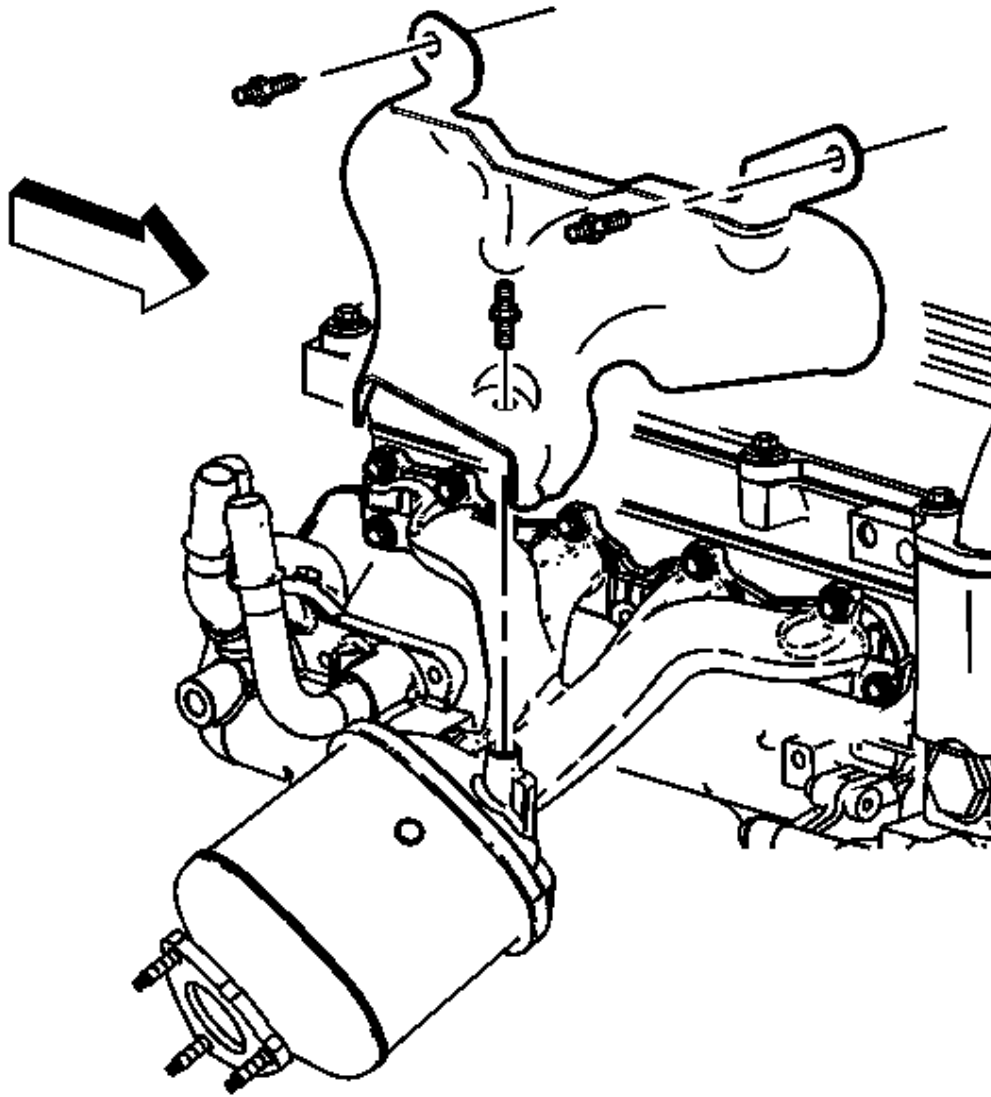


Fig. 518: View Of Exhaust Manifold Heat Shield
Courtesy of GENERAL MOTORS CORP.

9. Install the exhaust manifold heat shield.
10. Install the exhaust manifold heat shield bolts.

Tighten: Tighten the bolts to 23 N.m (17 lb ft).

OIL LEVEL INDICATOR AND TUBE INSTALLATION

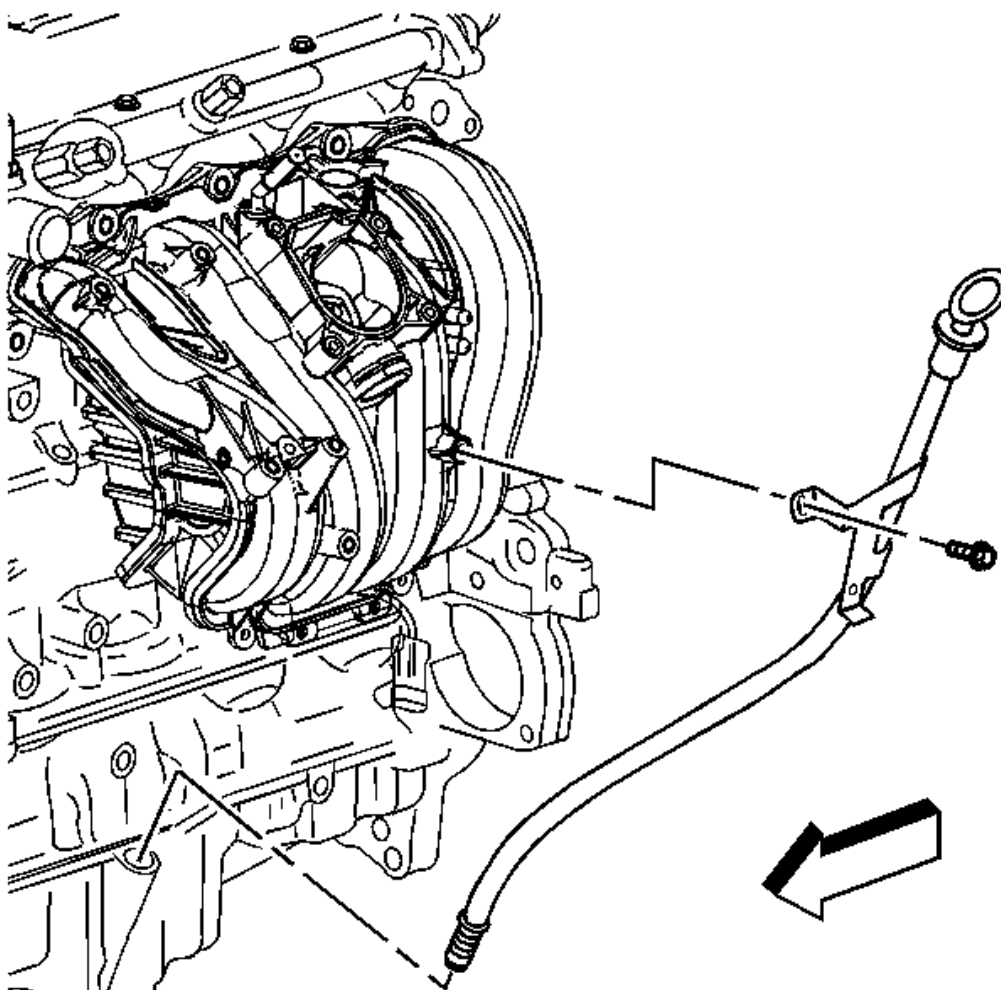


Fig. 519: View Of Oil Level Indicator
Courtesy of GENERAL MOTORS CORP.

1. Lubricate the oil level indicator tube O-ring with engine oil supplement.
2. Install the oil level indicator and the oil level indicator tube into the oil pan.

NOTE: Refer to Fastener Notice .

3. Install the oil level indicator tube bracket to the intake manifold bolt.

Tighten: Tighten the bolt to 10 N.m (89 lb in).

4. Install the electrical wiring harness to the oil level indicator tube.
5. Install the knock sensor wiring clip into the oil level indicator tube.

ENGINE FLYWHEEL INSTALLATION

Tools Required

- **J 38122-A** Crankshaft Balancer Holder. See Special Tools.
- **J 45059** Angle Meter

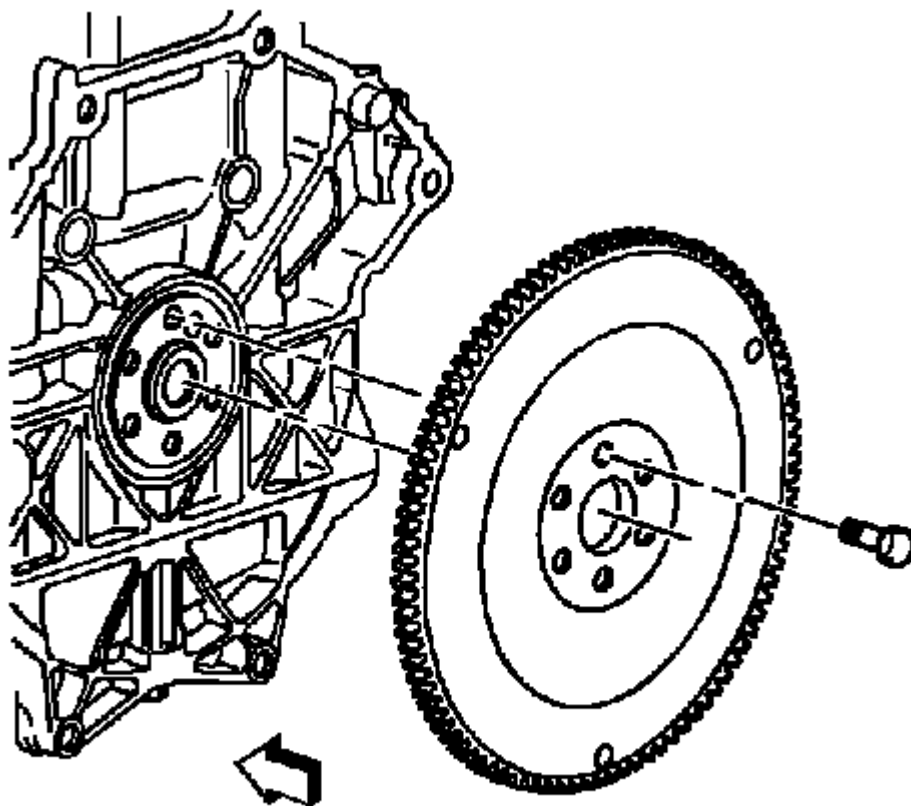


Fig. 520: View Of Flywheel

Courtesy of GENERAL MOTORS CORP.

1. Install the flywheel.
2. Install the NEW bolts.

NOTE: Refer to FASTENER NOTICE .

3. Holding the crankshaft balancer with the **J 38122-A** , tighten the bolts evenly. See Special Tools.

Tighten: Tighten the bolts to 53 N.m (39 lb ft), plus 25 degrees using the **J 45059** .

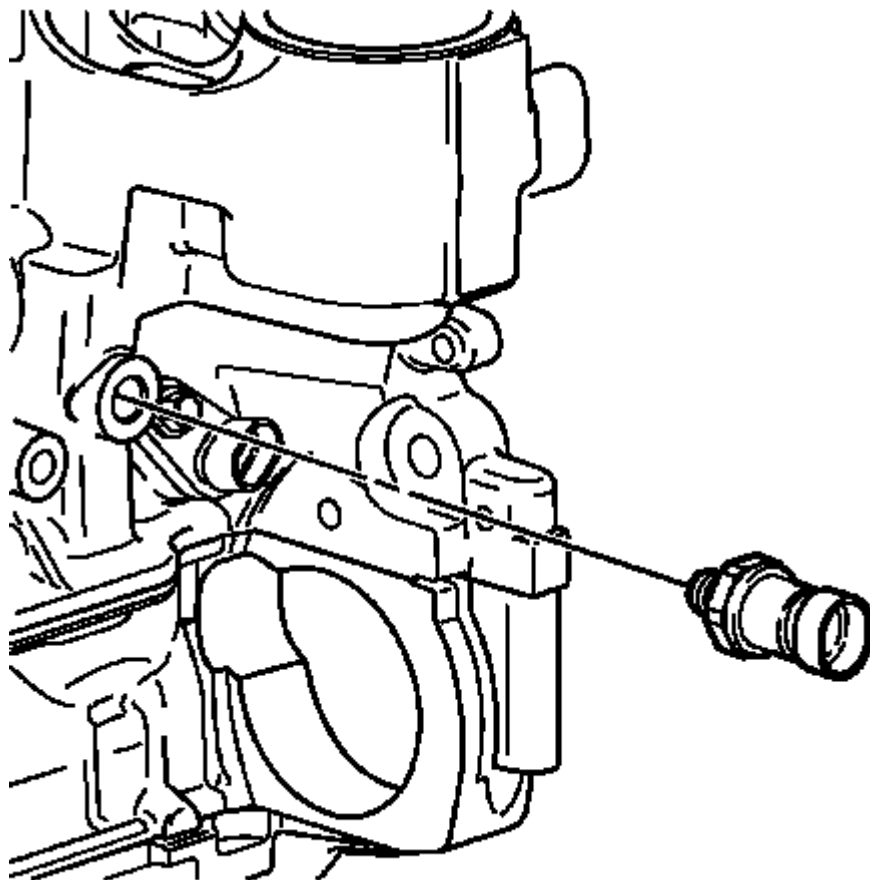
ENGINE PRELUBING**Tools Required****J 45299** Engine Preluber**Prelubing Procedure**

Fig. 521: View Of Engine Oil Pressure Sensor
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: A constant and continuous flow of clean engine oil is required in order to properly prime the engine. Ensure an approved engine oil is used, as specified in the owners manual.

1. Remove the oil pressure switch.
2. Install the M12 x 1.75 adapter P/N 509376.

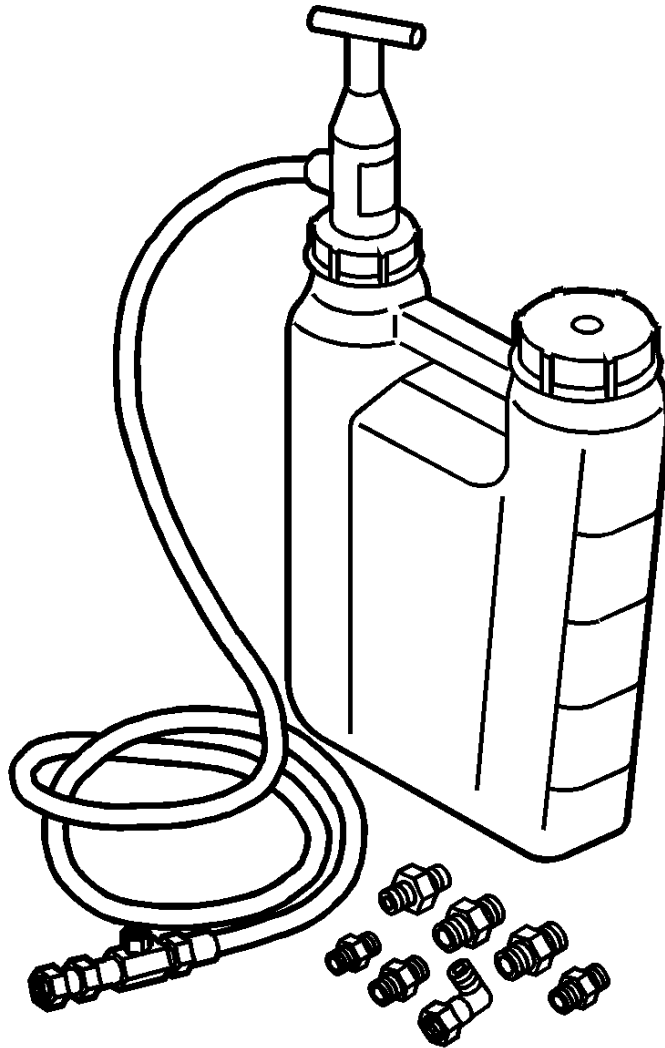


Fig. 522: Identifying Engine Preluber J 45299
Courtesy of GENERAL MOTORS CORP.

3. Install the flexible hose to the adapter and open the valve.
4. Pump the handle on the **J 45299** in order to flow a minimum of 1-1.9 liters (1-2 quarts) of engine oil. Observe the flow of engine oil through the flexible hose and into the engine assembly.
5. Close the valve and remove the flexible hose and adapter from the engine.

NOTE: Refer to Fastener Notice .

6. Install the oil pressure switch to the engine.

Tighten: Tighten the oil pressure switch to 22 N.m (16 lb ft).

7. Top-off the engine oil to the proper level.

DESCRIPTION AND OPERATION

CRANKCASE VENTILATION SYSTEM DESCRIPTION

General Description

A crankcase ventilation system is used to consume crankcase vapors in the combustion process instead of venting them to atmosphere. Fresh air from the intake system is supplied to the crankcase, mixed with blow by gases and then passed through a calibrated orifice into the intake manifold.

Operation

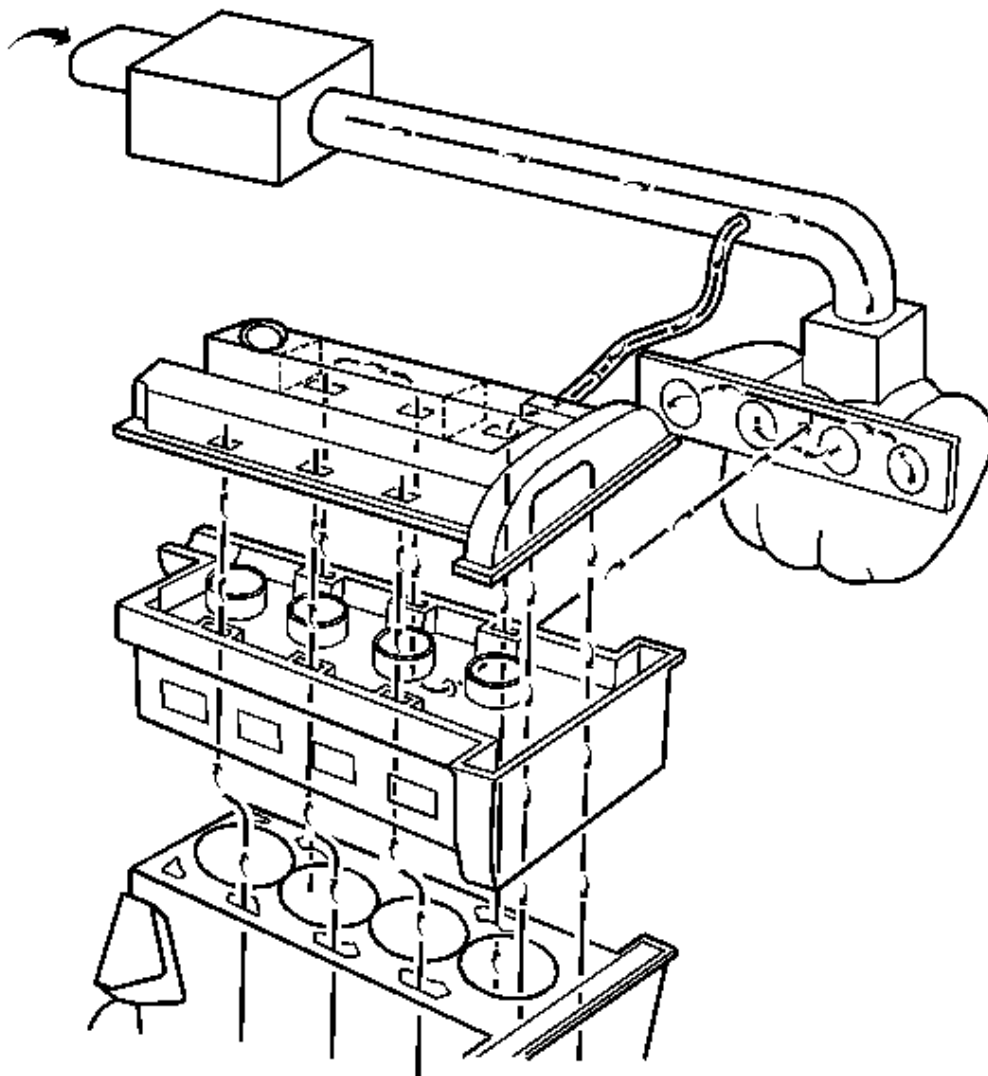


Fig. 523: Crankcase Ventilation System
Courtesy of GENERAL MOTORS CORP.

The primary control is through the positive crankcase ventilation (PCV) orifice which meters the flow at a rate depending on inlet vacuum. The PCV orifice is an integral part of the camshaft cover. If abnormal operating conditions occur, the system is designed to allow excessive amounts of blow by gases to back flow through the crankcase vent into the intake system to be consumed by normal combustion.

Results of Incorrect Operation

A plugged orifice may cause the following conditions:

- Rough idle
- Stalling or slow idle speed
- Oil leaks
- Sludge in engine

A leaking orifice may cause the following conditions:

- Rough idle
- Stalling
- High idle speed

DRIVE BELT SYSTEM DESCRIPTION

The drive belt system consists of the following components:

- The drive belt
- The drive belt tensioner
- The crankshaft balancer pulley
- The accessory drive components
 - The generator
 - The A/C compressor, if equipped

The drive belt is thin so that it can bend backwards and has several ribs to match the grooves in the pulleys. The drive belts are made of different types of rubbers (chloroprene or EPDM) and have different layers or plys containing either fiber cloth or cords for reinforcement.

Both sides of the drive belt may be used to drive the different accessory drive components. When the back side of the drive belt is used to drive a pulley, the pulley is smooth.

The drive belt is pulled by the crankshaft balancer pulley across the accessory drive component pulleys. The spring loaded drive belt tensioner keeps constant tension on the drive belt to prevent the drive belt from slipping. The drive belt tensioner arm will move when loads are applied to the drive belt by the accessory drive components and the crankshaft.

The drive belt system may have an idler pulley, which is used to add wrap to the adjacent pulleys. Some systems use an idler pulley in place of an accessory drive component when the vehicle is not equipped with the accessory.

ENGINE COMPONENT DESCRIPTION

Engine Description

Cylinder Block

The cylinder block is lost foam cast aluminum with four cylinders arranged in-line. The cylinders have pressed in place iron liners. The block has five crankshaft bearings with the thrust bearing located on the second bearing from the front of the engine. The cylinder block incorporates a bedplate design that forms an upper and lower crankcase. This design promotes cylinder block rigidity and reduced noise and vibration.

Crankshaft

The crankshaft is cast nodular iron with eight counterweights. The number eight counterweight is also the ignition system reluctor wheel. The main bearing journals are cross-drilled, and the upper bearings are grooved. The crankshaft has a slip fit balance shaft drive sprocket. Number two main bearing is the thrust bearing. A crankshaft balancer is used to control torsional vibration.

Connecting Rod and Piston

The connecting rods are powdered metal. The connecting rod incorporates the floating piston pin. The pistons are cast aluminum. The piston rings are of a low tension type to reduce friction. The top compression ring is ductile iron with a molybdenum facing and phosphate coated sides. The second compression ring is gray iron. The oil ring is a 3-piece spring construction with chromium plating.

Oil Pan

The oil pan is die cast aluminum. The oil pan includes an attachment to the transmission to provide additional structural support.

Balance Shaft Assembly

There are two block mounted balance shafts located on each side of the crankcase at the bottom of the cylinder bores. The balance shafts are driven by a single roller chain that also drives the water pump. The chain is tensioned by a hydraulic tensioner that is supplied pressure by the engine oil pump. This design promotes the maximum effectiveness of the balance shaft system and reduces noise and vibration.

Cylinder Head

The cylinder head is a lost foam aluminum casting. Pressed-in powdered metal valve guides and valve seat insets are used. The fuel injection nozzle is located in the intake port. The cylinder head incorporates camshaft journals and camshaft caps.

Valves

There are two intake and two exhaust valves per cylinder. Rotators are used on all of the intake valves. The rotators are located at the bottom of the valve spring to reduce valve train reciprocating mass. Positive valve stem seals are used on all valves.

Camshaft

Two camshafts are used, one for all intake valves, the other for all exhaust valves. The camshafts are cast iron. The intake camshaft had a pressed-in hex insert. The hex inset is used to drive the direct drive power steering pump.

Valve Lifters

The valve train uses a roller finger follower acted on by a hydraulic lash adjuster. The roller finger follower reduces friction and noise.

Camshaft Cover

The camshaft cover has a steel crankcase ventilation baffling incorporated. The camshaft cover has mounting locations for the ignition system.

Camshaft Drive

A single row roller chain is used for camshaft drive. There is a tensioner and active guide used on the slack side of the chain to control chain motion and noise. The chain drive promotes long valve train life and low maintenance.

Intake and Exhaust Manifold

The intake manifold is made of composite plastic. The exhaust manifold is cast iron. The intake manifold incorporates a distribution and control system for PCV gases. The exhaust manifold is a dual plane design that promotes good low end torque and performance.

LUBRICATION DESCRIPTION

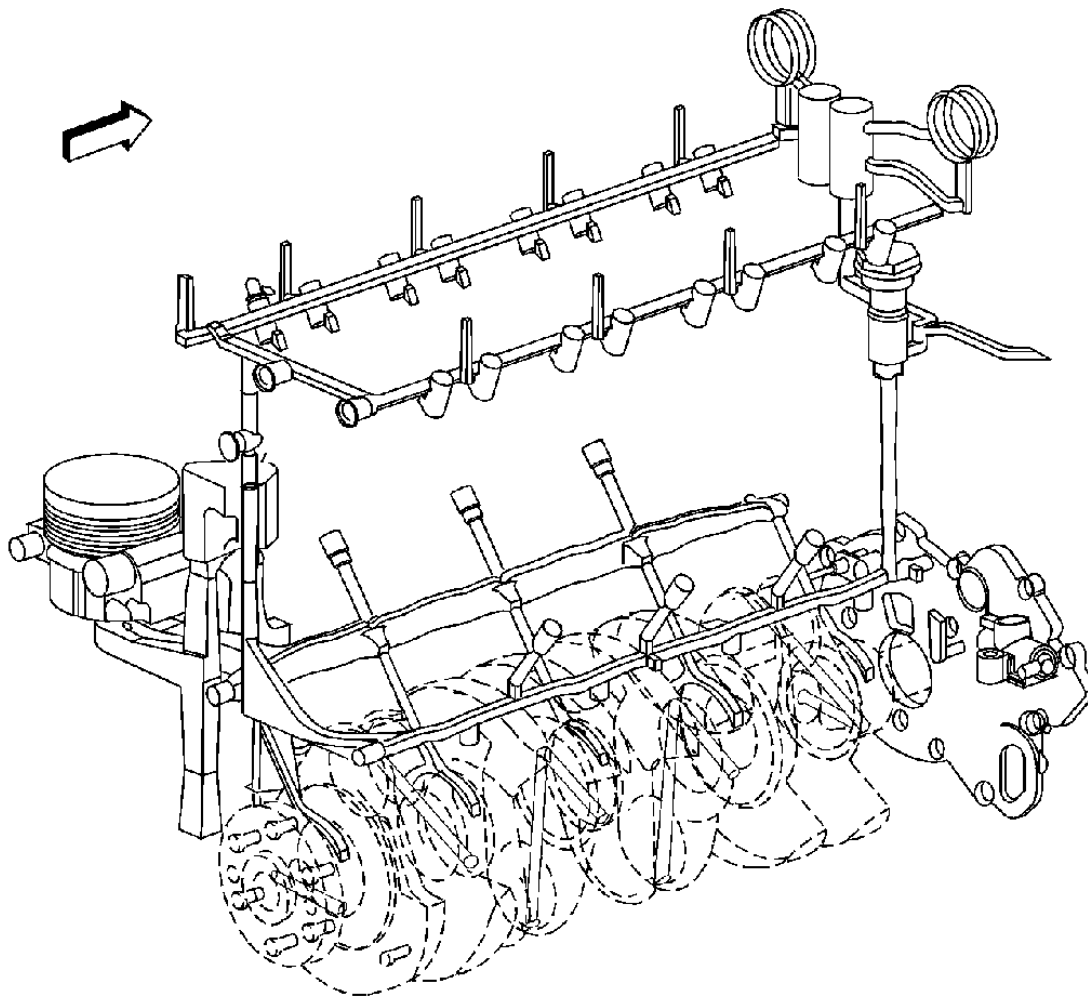


Fig. 524: Cutaway View Of Lubrication System
Courtesy of GENERAL MOTORS CORP.

Oil is applied under pressure to the crankshaft, connecting rods, balance shaft assembly, camshaft bearing surfaces, valve lash adjusters and timing chain hydraulic tensioner. All other moving parts are lubricated by gravity flow or splash. Oil enters the gerotor type oil pump through a fixed inlet screen. The oil pump is driven by the crankshaft. The oil pump body is within the engine front cover. The pressurized oil from the pump passes through the oil filter. The oil filter is located on the right (front) side of the engine block. The oil filter is housed in a casting that is integrated with the engine block. The oil filter is a disposable cartridge type. A by-pass valve in the filter cap allows continuous oil flow in case the oil filter should become restricted. Oil then enters the gallery where it is distributed to the balance shafts, crankshaft, camshafts and camshaft timing chain oiler nozzle. The connecting rod bearings are oiled by constant oil flow passages through the crankshaft connecting the main journals to the rod journals. A groove around each upper main bearing furnishes oil to the drilled crankshaft passages. The pressurized oil passes through the cylinder head restrictor orifice into the cylinder head and then into each camshaft feed gallery. Cast passages feed each hydraulic element adjuster and drilled passages feed each camshaft bearing surface. An engine oil pressure switch or sensor is installed at the end. Oil returns to the oil pan through passages cast into the cylinder head. The timing chain lubrication drains directly into the oil pan.

CLEANLINESS AND CARE

An automobile engine is a combination of many machined, honed, polished, and lapped surfaces with tolerances that are measured in ten thousandths of an inch. When any internal engine parts are serviced, care and cleanliness are important. A liberal coating of engine oil should be applied to friction areas during assembly to protect and lubricate the surfaces during initial operation. Throughout this section, it should be understood that proper cleaning and protection of machined surfaces and friction areas are part of the repair procedure. This is considered standard shop practice even if not specifically stated.

When valve train components are removed for service, they should be retained in order. At the time of installation, they should be installed in the same locations and with the same mating surfaces as when removed.

SEPARATING PARTS

IMPORTANT:

- **Disassembly of the piston, press fit design piston pin, and connecting rod may create scoring or damage to the piston pin and piston pin bore. If the piston, pin, and connecting rod have been disassembled, replace the components as an assembly.**
- **Many internal engine components will develop specific wear patterns on their friction surfaces.**
- **When disassembling the engine, internal components **MUST** be separated, marked, or organized in a way to ensure installation to their original location and position.**

Separate, mark, or organize the following components:

- Piston and the piston pin
- Piston to the specific cylinder bore
- Piston rings to the piston
- Connecting rod to the crankshaft journal
- Connecting rod to the bearing cap

A paint stick or etching/engraving type tool are recommended. Stamping the connecting rod or cap near the bearing bore may affect component geometry.

- Crankshaft main and connecting rod bearings
- Camshaft and valve lash adjusters
- Valve lash adjusters, lash adjuster guides, pushrods and rocker arm assemblies
- Valve to the valve guide
- Valve spring and shim to the cylinder head location
- Engine block main bearing cap location and direction
- Oil pump drive and driven gears

REPLACING ENGINE GASKETS

Tools Required

J 28410 Gasket Remover. See Special Tools.

Gasket Reuse and Applying Sealants

- Do not reuse any gasket unless specified.
- Gaskets that can be reused will be identified in the service procedure.
- Do not apply sealant to any gasket or sealing surface unless called out in the service information.

Separating Components

- Use a rubber mallet to separate components.
- Bump the part sideways to loosen the components.
- Bumping should be done at bends or reinforced areas to prevent distortion of parts.

Cleaning Gasket Surfaces

- Remove all gasket and sealing material from the part using the **J 28410** or equivalent. See Special Tools.
- Care must be used to avoid gouging or scraping the sealing surfaces.
- Do not use any other method or technique to remove sealant or gasket material from a part.
- Do not use abrasive pads, sand paper, or power tools to clean the gasket surfaces.
 - These methods of cleaning can cause damage to the component sealing surfaces.
 - Abrasive pads also produce a fine grit that the oil filter cannot remove from the oil.
 - This grit is abrasive and has been known to cause internal engine damage.

Assembling Components

- When assembling components, use only the sealant specified or equivalent in the service procedure.
- Sealing surfaces should be clean and free of debris or oil.
- Specific components such as crankshaft oil seals or valve stem oil seals may require lubrication during assembly.
- Components requiring lubrication will be identified in the service procedure.
- When applying sealant to a component, apply the amount specified in the service procedure.
- Do not allow the sealant to enter into any blind threaded holes, as it may prevent the bolt from clamping properly or cause component damage when tightened.
- Tighten bolts to specifications. Do not overtighten.

USE OF ROOM TEMPERATURE VULCANIZING (RTV) AND ANAEROBIC SEALANT**Pipe Joint Compound**

IMPORTANT: Three types of sealer are commonly used in engines. These are RTV sealer, anaerobic gasket eliminator sealer, and pipe joint compound. The correct

sealer and amount must be used in the proper location to prevent oil leaks. DO NOT interchange the three types of sealers. Use only the specific sealer or the equivalent as recommended in the service procedure.

- Pipe joint compound is a pliable sealer that does not completely harden. This type sealer is used where two non-rigid parts (such as the oil pan and the engine block) are assembled together.
- Do not use pipe joint compound in areas where extreme temperatures are expected. These areas include: exhaust manifold, head gasket, or other surfaces where gasket eliminator is specified.
- Follow all safety recommendations and directions that are on the container.

To remove the sealant or the gasket material, refer to **Replacing Engine Gaskets** .

- Apply the pipe joint compound to a clean surface. Use a bead size or quantity as specified in the procedure. Run the bead to the inside of any bolt holes. Do not allow the sealer to enter any blind threaded holes, as it may prevent the bolt from clamping properly or cause component damage when the bolt is tightened.
- Apply a continuous bead of pipe joint compound to one sealing surface. Sealing surfaces to be resealed must be clean and dry.
- Tighten the bolts to specifications. Do not overtighten.

RTV Sealer

- Room Temperature Vulcanizing (RTV) sealant hardens when exposed to air. This type sealer is used where two rigid parts (such as the lower crankcase and the engine block) are assembled together.
- Do not use Room Temperature Vulcanizing (RTV) sealant in areas where extreme temperatures are expected. These areas include: exhaust manifold, head gasket, or other surfaces where a gasket eliminator is specified.
- Follow all safety recommendations and directions that are on the container.

To remove the sealant or the gasket material, refer to **Replacing Engine Gaskets** .

- Apply RTV to a clean surface. Use a bead size as specified in the procedure. Run the bead to the inside of any bolt holes. Do not allow the sealer to enter any blind threaded holes, as it may prevent the bolt from clamping properly or cause damage when the bolt is tightened.
- Assemble components while RTV is still wet (within 3 minutes). Do not wait for RTV to skin over.
- Tighten bolts to specifications. Do not overtighten.

Anaerobic Sealer

- Anaerobic gasket eliminator hardens in the absence of air. This type sealer is used where two rigid parts (such as castings) are assembled together. When two rigid parts are disassembled and no sealer or gasket is readily noticeable, the parts were probably assembled using a gasket eliminator.
- Follow all safety recommendations and directions that are on the container.

To remove the sealant or the gasket material, refer to **Replacing Engine Gaskets** .

- Apply a continuous bead of gasket eliminator to one flange. Surfaces to be resealed must be clean and dry.
- Spread the sealer evenly with your finger to get a uniform coating on the sealing surface.
- Do not allow the sealer to enter any blind threaded holes, as it may prevent the bolt from clamping properly or cause damage when tightened.

IMPORTANT: Anaerobic sealed joints that are partially torqued and allowed to cure more than five minutes may result in incorrect shimming and sealing of the joint.
Do not allow the sealer to enter any blind threaded holes, as it may prevent the bolt from seating properly or cause damage when the bolt is tightened.

- Tighten bolts to specifications. Do not overtighten.
- After properly tightening the fasteners, remove the excess sealer from the outside of the joint.

TOOLS AND EQUIPMENT

Special tools are listed and illustrated throughout this section with a complete listing at the end of the section. These tools, or their equivalents, are specially designed to quickly and safely accomplish the operations for which they are intended. The use of these special tools will also minimize possible damage to engine components. Some precision measuring tools are required for inspection of certain critical components. Torque wrenches and a torque angle meter are necessary for the proper tightening of various fasteners.

To properly service the engine assembly, the following items should be readily available:

- Approved eye protection and safety gloves
- A clean, well lit, work area
- A suitable parts cleaning tank
- A compressed air supply
- Trays or storage containers to keep parts and fasteners organized
- An adequate set of hand tools
- Approved engine repair stand
- An approved engine lifting device that will adequately support the weight of the components

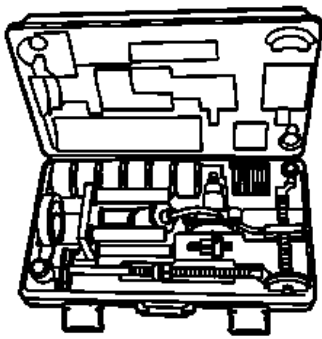
SPECIAL TOOLS AND EQUIPMENT

SPECIAL TOOLS

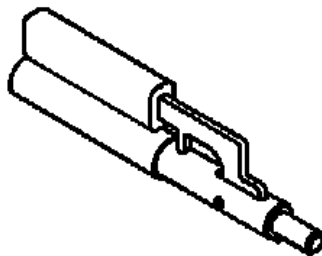
Illustration	Tool Number/Description

2008 Pontiac G5

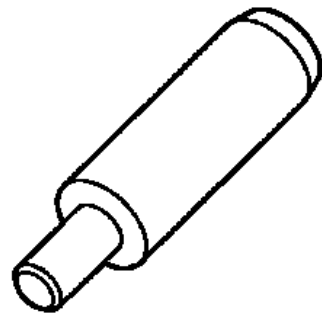
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



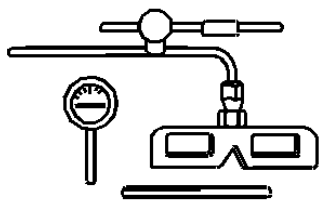
EN 45680-850
Cylinder Sleeve Removal and Installation Kit



EN 46745
Piston Pin Clip Remover and Installer



EN 48585
Crankshaft Balancer Guide

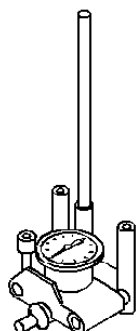
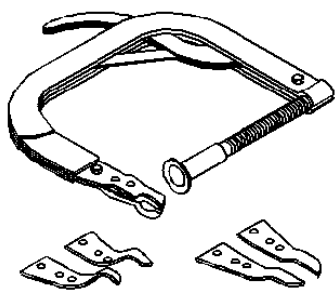


J 7872
Magnetic Base Dial Indicator

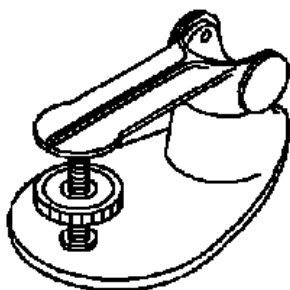
J 8062
Valve Spring Compressor - Head Off

2008 Pontiac G5

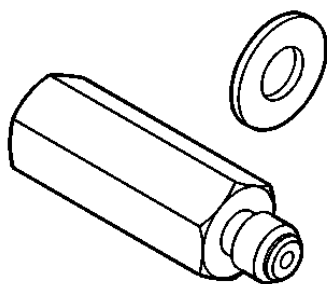
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



J 8087
Cylinder Bore Gage



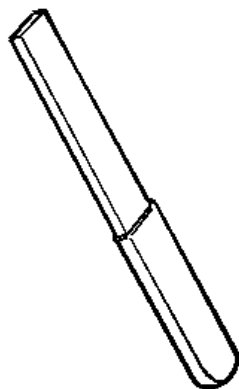
J 9666
Valve Spring Tester



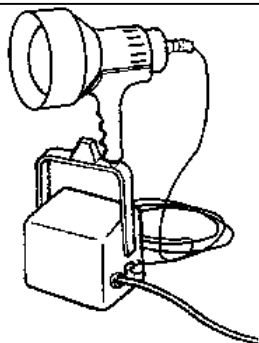
J 21867-850
Oil Pressure Gage Adapter

2008 Pontiac G5

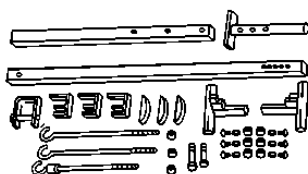
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



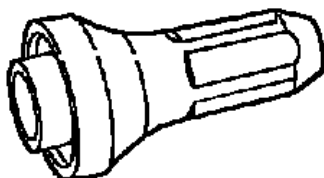
J 28410
Gasket Remover



J 28428-E
High Intensity Black Light Kit



J 28467-B
Universal Engine Support Fixture



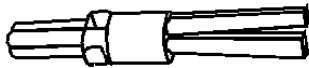
J 35268-A
Front Crankshaft Seal Installer

2008 Pontiac G5

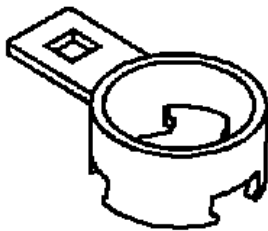
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



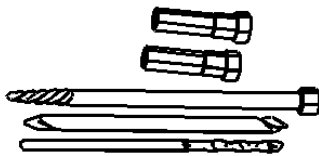
J 35667-A
Cylinder Head Leakdown Tester



J 36017
Valve Guide Seal Remover



J 38122-A
Crankshaft Balancer Holder

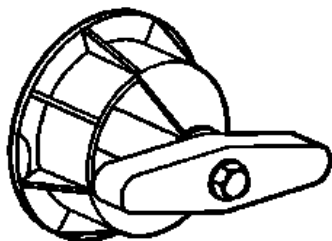
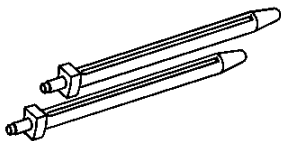


J 38188
Cylinder Head Broken Bolt Extractor Kit

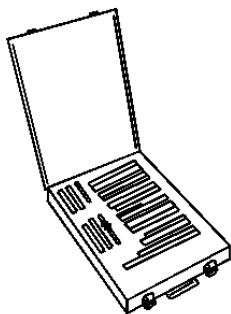
J 41742
Connecting Rod Guide Pin

2008 Pontiac G5

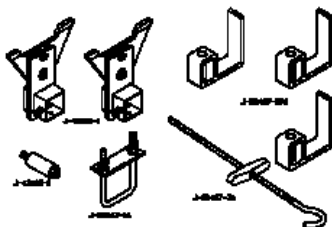
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



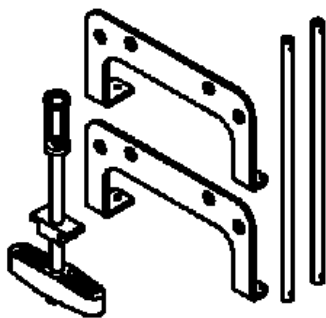
J 42067
Rear Main Seal Installer



J 42385-850
Thread Repair Kit



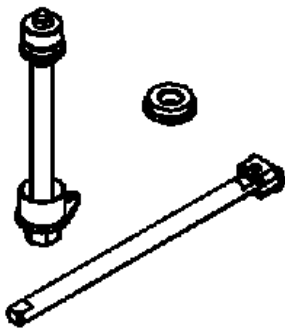
J 43405
Engine Support Fixture Adapter



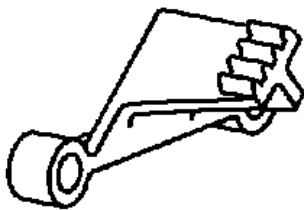
J 43649
Valve Spring Compressor

2008 Pontiac G5

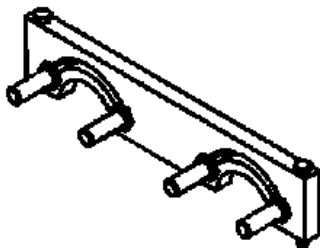
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



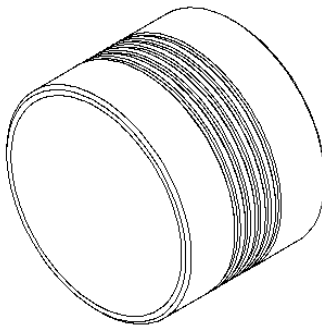
J 43650
Balance Shaft Bearing Remover/Installer



J 43653
Flywheel Holding Tool



J 43655
Sprocket Holding Tool

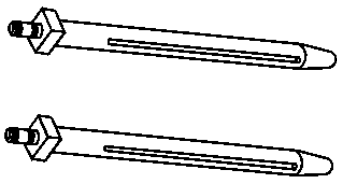
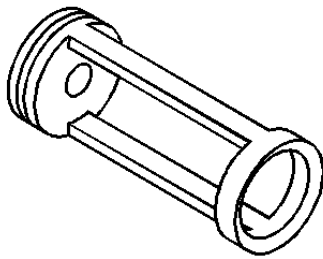


J 43953
Ring Compressor

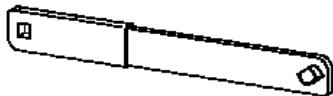
J 43963
Valve Spring Compressor (off car)

2008 Pontiac G5

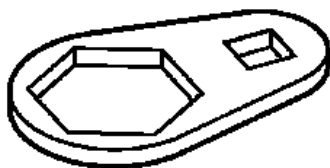
2008 ENGINE Engine Mechanical - 2.2L (L61) - Cobalt & G5



J 43966-1
Connecting Rod Guides



J 44811
Accessory Belt Tensioner Unloader

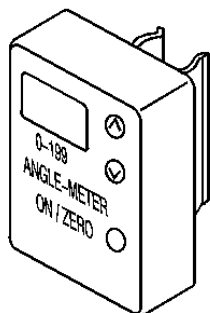
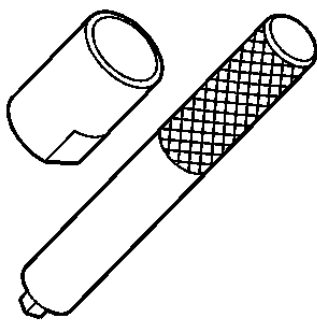


J 44887
Oil Filter Wrench

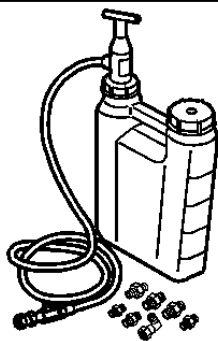
J 45027
Tensioner Tool

2008 Pontiac G5

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J 45059
Angle Meter



J 45299
Engine Pre-Luber