



**VOLVO**

# WORKSHOP BULLETIN

## CARS

RE: B 18 B ENGINE	PRODUCT P
	GROUP 20
DATE October, 1969	NO. 7

Replaces previous WB, P - 20 - 7, of April, 1968.

### Cylinder head gaskets for B 18 B engines

A thicker cylinder head gasket is recommended for use on B 18 B engines on markets which supply fuel with octane rating lower than ROT (Research Method) 100. The rubber rings for water pump should be replaced with higher types at the same time.

The part Nos. concerned are contained in the following table:

Octane rating	ROT 90 - 95	ROT 95-100
Ignition setting B.T.D.C. at 1500 r.p.m.	14 - 19°	17 - 19°
Cylinder head gasket, part No.	418867	419688
Thickness, off-load	2.5 mm (0.10")	1.6 mm (0.064")
Rubber rings for water pump, part No.	419781 419782	418656 418658

After the engine has been run warm, these thicker gaskets subside slightly. This reduces the torque in the cylinder head bolts. The valve clearance is also altered.

To remedy this, final-tightening should be carried out after running the engine warm. The cylinder head should be fitted according to the following method:

Tighten the cylinder head bolts to a torque of 8.5 - 9.5 kgm (61-69 lb.ft.) and in accordance with the tightening sequence given in the service manual.

Adjust the valve clearance to 0.60 - 0.65 mm (0.023 - 0.026"). This concerns both the exhaust and inlet valves.

Then run the engine warm.

Re-tighten the cylinder head bolts within 20 minutes after running the engine warm. Tighten to a torque of 8.5 - 9.0 kgm (61 - 65 lb.ft.)

Final-adjustment of the valve clearance to 0.50 - 0.55 mm (0.020 - 0.022") is then carried out.

For other engine types, our recommendations specified in the workshop bulletin concerning ignition setting (P - 34 - 1, of January, 1966) apply.