

► **TASK** Assemble engine block.

**MAST**  
1C14

**CDX Tasksheet Number: C731**

Time off	_____
Time on	_____
Total time	_____

**NOTE** Due to the differences in assembly procedures and specifications, it is recommended that the specified procedure and specifications be printed out and followed exactly.

**NOTE** Most measurements were taken during the engine disassembly process to determine the necessary actions. Now that the engine is ready to be reassembled, all measurements need to be repeated to verify that parts are within their specified tolerances. Use the Engine Build Sheet to record all of your measurements. When provided to customers, it lends a touch of professionalism to the job.

1. **Reassemble the engine block following all manufacturer specifications and procedures. List the specifications in the CDX Engine Build/Spec Sheet. Be sure to verify the following information.**
  - a. **Make sure the camshaft turns freely. If not, check for proper installation of the cam bearings.**
  - b. **Check all oil gallery plugs, and make sure they are tightened/installed properly.**
  - c. **Check all water jacket soft plugs for proper installation.**
  - d. **Check crankshaft main journals for proper clearance, and record on the Engine Build/Spec Sheet.**
  - e. **Check crankshaft end play, and record on the Engine Build/Spec Sheet.**
  - f. **Clean and lubricate the cylinder walls. Lubricate the pistons and piston rings.**
  - g. **Install the pistons with the rings in the proper orientation.**
  - h. **Measure the connecting rod bearing clearance, and record on the Engine Build/Spec Sheet.**
  - i. **Pack the oil pump with the proper lubricant and install the pump.**
2. **Once the block is assembled, list any observation(s):**

3. Have your supervisor/instructor verify satisfactory completion of this procedure, any observations found, and any necessary action(s) recommended.

**NOTE** Once the block is assembled, return to the Cylinder Head Disassembly, Inspection, and Repair tasksheet to continue with the installation of the cylinder heads and valve timing components.

Performance Rating

CDX Tasksheet Number: C731

0

1

2

3

4

Supervisor/instructor signature \_\_\_\_\_ Date \_\_\_\_\_

© 2018 Jones & Bartlett Learning, LLC, an Ascend Learning Company