

Bulletin
Number 5025

Issue 1

Date 10.11.48

Sheet 1 of 1 Sheet

MODELS AFFECTED

1948-49 "60" and "75"
1948 Land-Rover

UNIT AFFECTED

ENGINE

COMPLAINT

SUBJECT

DECARBONISING AND VALVE GRINDING

Contrary to advice in the Car Instruction Manual and the first edition of the Land-Rover Operation Manual, experience has proved that the initial decarbonising and valve grinding operation should be carried out fairly early in the life of the engine, if possible as early as 2,000 miles (3,500 Km).

At this and every subsequent decarbonising operation, special attention should be given to the valve seats :

WIDTH OF VALVE SEATING should not be less than 1/16 in. (1,60 mm), nor more than 1/8 in. (3,20 mm). If the seat width proves to be outside these recommended dimensions, proceed as follows :

INLET VALVES.

Re-cut the inlet valve seats in the cylinder head to 30° ; face the valves to 30° and lap into their respective seats.

EXHAUST VALVES.

The exhaust valve seats, inserted in the cylinder block, are manufactured from "Brimochrome". This material cannot be cut in the normal way, but can be ground using "Vibro-centric" grinding equipment. The only suitable stone we have found for this operation is D1144E ; should difficulty be experienced in obtaining this stone, our Service Department will be able to help you.

Grind the insert seat to 45°. Should there be eccentricity between the valve seat and guide it may be necessary to grind to, or beyond the limit of 1/8 in. (3,20 mm) seat width on one side in order to obtain the minimum width of 1/16 in. (1,60 mm) diametrically opposite. If the 1/8 in. (3,20 mm) limit is exceeded at any point, grind back the 30° angle which forms the "crown" of the seat, so reducing the seat width on that side.

Face the exhaust valves to 45° and lap into their respective seats.

Further decarbonising should not again be necessary until there is a "fall off" in performance, but as this condition is not always readily detected, it may be advisable to depend on mileage as a guide and decarbonise at every 10,000 miles (15,000 Km), regrinding the valve seats as described, only where necessary.

This sheet replaces that already in your file which bears the SAME bulletin and sheet numbers, but of a LOWER issue number. The old copy should be removed and destroyed.