

CITROEN CARS LIMITED,
TRADING ESTATE,
SLOUGH, BUCKS.

TECHNICAL NOTE NO: 566

9th March, 1953.

BOLTING DOWN CYLINDER HEADS ON
15h.p. (11) AND 6-CYLINDER (15-Six).

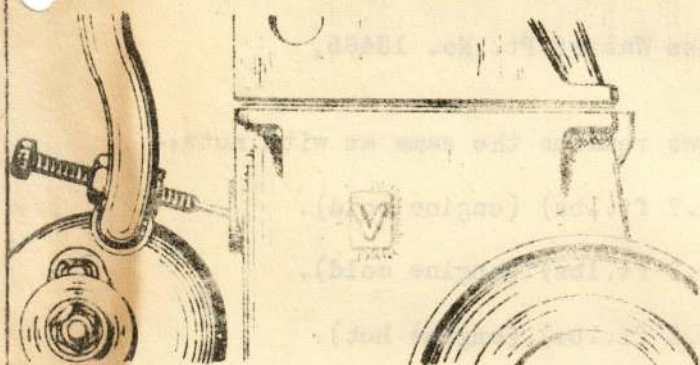


Fig. 1

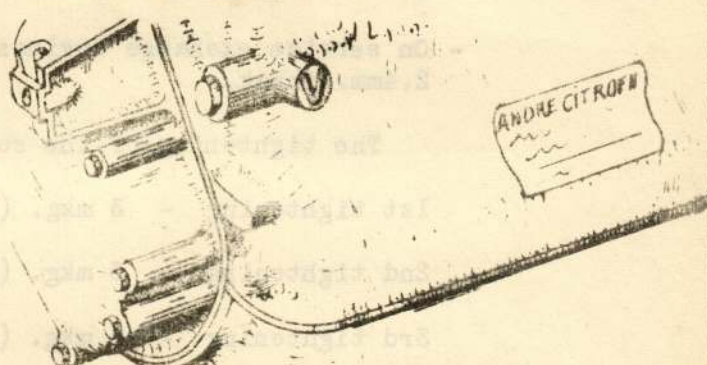


Fig. 2

The studs holding the cylinder head on the 15h.p. (11) and 6-Cylinder (15-Six) engines will in future be replaced by screws.

It is not possible to fit screws to a cylinder block intended to receive studs or vice versa.

To prevent any errors in reassembling engines, the cylinder blocks have been marked. There are two sorts of these marks:-

1st case:- A letter "V" is punched on the cylinder block.

15h.p. ("11") engines, all types - on the round boss for the old outlet for oil to the rocker shaft, rear right hand side of the engine (see fig.2).
6-Cylinder ("15-Six") engine - on the rectangular boss at the front of the cylinder block (see fig.1).

2nd case:- A letter "V" is cast on the block.

15h.p. ("11") engines, all types - on the right hand side of the cylinder block, 20mm. to the right of the LEMAIRE bracket fixing.
6-Cylinder ("15-Six") engines - on the left hand side of the cylinder block, 40mm. to the right of the makers plate.

In servicing, engines not bearing one or other of these marks must necessarily be fitted with the old studs.

Engines marked "V" will be fitted with the following screws:-

621,009 - 15h.p. ("11") engines, all types.

621,015 - 6-Cylinder ("15-Six") engines.

Washers are fitted between the head of the screws and the cylinder head. There are two sorts of washers, of different thicknesses. On engines reconditioned at the factory, the faces of the cylinder head and of the block being ground true, it is necessary to use the thick washer.

- On new engines use Washer Pt. No. 89860, 1.5mm. thick.
- On service exchange engines use Washer Pt. No. 18485, 2.4mm. thick.

The tightening of the screws remains the same as with nuts:-

1st tightening - 3 mkg. (21.7 ft.lbs) (engine cold).

2nd tightening - 5 mkg. (36.2 ft.lbs) (engine cold).

3rd tightening - 5 mkg. (36.2 ft.lbs) (engine hot).

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