

lease clutch and turn engine until hole in pto shaft coupling aligns with hole in transmission input shaft sleeve. See Fig. 14. Install 5 inch bolt through overdrive housing, input shaft sleeve and pto coupling and thread square head plug into overdrive housing. Tighten 5 inch bolt to 20 ft.-lbs.

NOTE: If pto coupling hole is not aligned with other aligning holes, use 5 inch bolt to move coupling rearward against pto spacer spring pressure. If forward movement of coupling is required, move engine forward slightly.

Use a block or other suitable means to support clutch housing and Hydraul Shift unit, then slide engine forward and lift from front frame.

19. Prior to reinstalling engine, remove clutch housing and Hydraul Shift assembly and reinstall on rear of engine. Reinstall engine by reversing removal procedure. Be sure to renew "O" ring on transmission input shaft bearing retainer and lubricate thoroughly. Bleed power steering and fuel systems.

CYLINDER HEADS

Models 2-135 and 2-155

20. **REMOVE AND REINSTALL.** To remove cylinder heads, remove muffler, precleaner, hood side panels, hood and air cleaner. Drain cooling system. Disconnect coolant temperature gage sending unit. Remove intake and exhaust manifolds. Remove breather tube and adapter. Remove thermostat housing, hoses and water manifolds. Remove injector high pressure lines and leak-off lines and cap all openings. Remove injectors. Remove valve covers, rocker arm assemblies and

push rods, then remove cylinder head stud nuts and lift cylinder heads from cylinder blocks.

When reinstalling cylinder heads, White Farm Equipment recommends that the cylinder head nut tightening operation be accomplished in four steps. Refer to Fig. 15 for sequence, then make initial tightening to 40 ft.-lbs., second tightening to 80 ft.-lbs., third tightening to 130 ft.-lbs., and fourth tightening to 160 ft.-lbs.

Operate engine for two hours, retorquer cylinder head nuts and readjust valve clearance. Use White special tools STA-176 and STA-177 to tighten cylinder head stud nuts when rocker arm assemblies are installed.

VALVES, GUIDES AND SEATS

Models 2-135 and 2-155

21. Both intake and exhaust valves have a face and seat angle of 45 degrees. Valve stem diameter for intake valves is 0.4361-0.4369 with a minimum diameter of 0.4356. Valve stem diameter for exhaust valves is 0.4344-0.4352 with a minimum allowable diameter of 0.4339. Maximum allowable valve face run-out is 0.002. Operating clearance of intake valves in guides is 0.0019-0.0033 with a maximum allowable clearance of 0.0045. Operating clearance of exhaust valves in guides is 0.0036-0.0050 with a maximum allowable clearance of 0.0062. Renew valves and/or guides when these clearances are exceeded.

22. The cast iron valve guides are a straight type and renewable. Drive or press old guides out of cylinder head. Install new guides from top side of cylinder head and if using guide driver

(White ST-178 and a 0.50 spacer), guide is correctly installed when driver bottoms on cylinder head. If driver ST-178 and spacer is not available, guide is correctly installed when top of guide is 1.269 inch above counterbore in cylinder head. Bore diameter of new guide is 0.4388-0.4394 with a maximum allowable diameter of 0.4406.

23. Valve seat inserts are used for all valves and when renewing seat inserts, shrink them with dry ice prior to installation. Valve seat angle is 45 degrees and seat width is 1/8-inch for intake valves and 7/64-inch for exhaust valves. Valve seat should contact center of valve face and run-out should not exceed 0.002. Seats can be narrowed using 20 and 60 degree stones.

Adjust valve clearance cold to 0.010 for intake valves and 0.025 for exhaust valves. Recheck valve clearance after cylinder head has been retorqued.

VALVE ROTATORS

Models 2-135 and 2-155

24. Exhaust valves are equipped with a positive type rotator. While these rotators cannot be serviced, they should be observed while engine is running to be sure that valve rotates slightly each time valve opens. Renew rotator of any valve which fails to rotate.

VALVE SPRINGS

Models 2-135 and 2-155

25. All valves use two valve springs each and outer springs are wound with damper coils. Outer springs are installed with damper coils next to cylinder head.

Free length of outer spring is 2.610 inches and spring should test 153.7-167.7 pounds when compressed to a length of 1.67 inches.

Free length of inner spring is 2.110 inches and spring should test 81.5-91.5 pounds when compressed to a length of 1.33 inches. Renew any spring which does not meet specifications, has ends that are not square, is discolored by heat, or shows any signs of fractures.

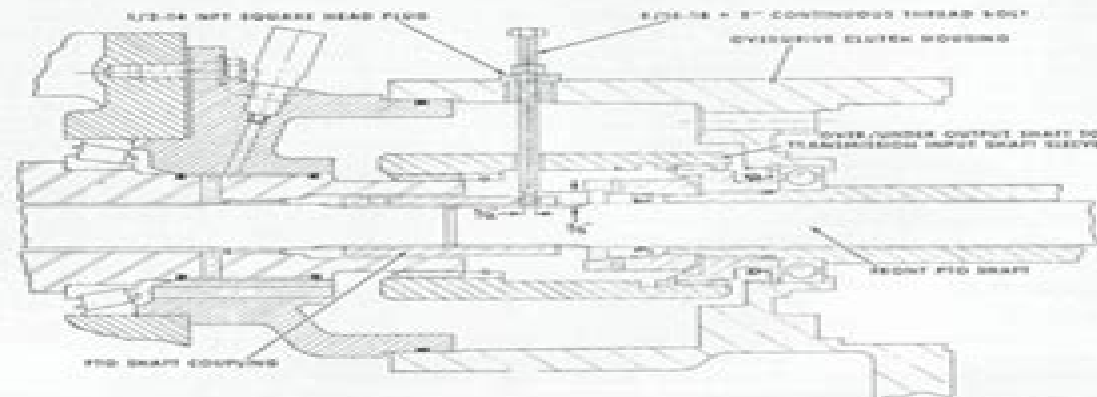


Fig. 14—Use special tool fabricated to dimensions shown when removing engine. Refer to text for procedure.

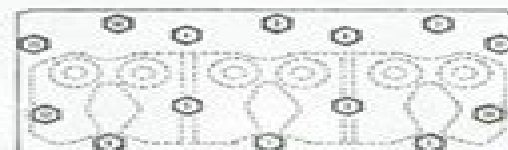


Fig. 15—Tighten cylinder head stud nuts in sequence shown. Four steps are required in tightening operation. Refer to text.

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