



INTERSTATE-McBEE



NT/N14 LPF Cylinder Liner Installation Instructions

1. Proper liner protrusion for this application is .004" - .007" (0.10mm-0.18mm). To achieve this protrusion specification the correct thickness liner flange seal ring must be used.
2. Make sure the cylinder block deck, counter bore, lower receiving bore, liner seal ring and the cylinder liner are clean and dry.
3. Install the counter bore seal ring (shim) into the cylinder block counter bore.
Warning: Do not use any type of sealant.
4. Install the wide crevice seal in the top liner groove.
5. Install the two black O-rings in the center and bottom liner grooves. Verify neither O-ring is twisted.
6. Lubricate the crevice seal and the O-rings with vegetable oil. **Warning: Do not use engine oil.**
7. Lubricate the lower packing bore area of the cylinder block with vegetable oil.
8. Place the liner into the cylinder bore taking care not to allow any oil to touch the counter bore or seal ring.
9. Use hand pressure push the liner into the cylinder block.
10. Use a proper liner installation tool to press the liner to its final installed position. Before removing the installation tool check the liner protrusion with a dial indicator at four locations 90° apart. The protrusion must be .004" - .007" (0.10mm-0.18mm) at all four points.
11. If the specified protrusion is not attained the liner must be removed and the procedure repeated. If the protrusion is correct remove the installation tool and proceed to step 12.
12. Check the liner bore with a dial bore gauge. The bore must not be out of round more than .003" (.08mm) at the top 1 inch of the liner bore and not more than .002" (.05mm) out of round in the balance of the liner bore.



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