

TECHNICAL TIP

**Model/Derivative:**

K Series 4 Cylinder  
All Derivatives

**No:** TBX0513

**Date:** 1<sup>st</sup> December 2009

**Section:** Cooling System

**Title:**

**New Multi-layer steel head gasket kit      Part number ZUA 000530**

**Affected Range:**

**All Derivatives.**

**Description:**

This Technical is released to ensure that technicians understand the importance of fitting the three elements of this kit together i.e. the MLS gasket , the 10.9 grade long bolts and the revised lower oil rail and the need to use the revised torque settings when fitting the kit. **The warranty on this kit only applies when all three elements are fitted**

**Action Required :**

Technicians should always adopt the following procedure when investigating coolant loss and potential Head Gasket replacement.

- The root cause of any coolant loss should be sought out and rectified as part of the cylinder head gasket replacement process.
- The Technical Bulletin TB0068 should be read and understood by all Technical staff.
- Related parts should be checked and replaced if necessary as part of the repair process. Specifically inlet manifold gaskets, coolant pipes, pressure caps , distorted cylinder heads and manifolds .
- Cylinder liner heights must be checked.
- The repair process must utilise the pressure test and vacuum fill tools described in TB0068
- In addition the relevant Rave CD should be read to ensure a full understanding of the Repair Procedure.
- When using this kit only ,the cylinder head should be tightened in the normal sequence to **20nm** and then tightened a further **315** degrees in two parts. Tighten **180** degrees and then an other **135** degrees using the same sequence each time

**Parts Information:**

NB Cylinder Heads with damage beyond the engineering tolerance should be replaced

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