

Installation Guide

Haldex

L31271W Rev. 10/11

75mm Single Cylinder-WABCO Head Replacement Instructions

Disassembly

1. Remove the four head bolts (M8,13mm). **Do not reuse the original bolts.** (Do not remove the small screws).
2. Remove the old head and save the core. (Note the position of the ports with respect to the crankcase for accurate reassembly).
3. Remove and discard the original gasket.
4. Save the air and coolant fittings and reuse them.

Cleaning

1. Rotate the crankshaft until the piston is at the top of the cylinder bore. Remove any carbon or varnish by carefully scraping and using a light application of solvents. Avoid getting debris and solvents in the cylinder bore. Do not use abrasive products because the abrasive grit will shorten the life of the air compressor.

Reassembly

1. Ensure the sliding valve is in place.
2. Ensure the guide pins are in the correct direction to enter the larger diameter holes in the valve body and crankcase.
3. Position the mounting gasket and head assembly.
4. Insert four new head bolts in locations A, B, C and D. (You should find five cover bolts loosely holding the head together.)
5. Use a torque wrench and tighten the bolts in sequence A, B, C, D, E and F as shown in the photo below.

Bolt Tightening Sequence

Step	Bolt	Torque Number	Rotation Degrees
1	A	15 ± 1.5 Nm	
2	B	15 ± 1.5 Nm	
3	C	15 ± 1.5 Nm	
4	D	15 ± 1.5 Nm	
5	A	25 ± 2 Nm	
6	B	25 ± 2 Nm	
7	C	25 ± 2 Nm	
8	D	25 ± 2 Nm	
9	A		180° ± 10
10	B		270° ± 10
11	C		180° ± 10
12	D		180° ± 10
13	E	6 ± 0.6 Nm	
14	F	6 ± 0.6 Nm	
15	E		90° +15 -5
16	F		90° +15 -5

