

Injector Sleeve Installation on Isuzu 4HK1 & 6HK1 Diesel Engines

The AERA Technical Committee offers the following information concerning the installation of injector sleeves for Isuzu 4HK1 & 6HK1 diesel engines. This information should be considered anytime the cylinder head is being worked on.

Obtaining special tool nozzle sleeve installer J-43266, shown below, is the first step in preparation for sleeve installation. Information on proper sleeve installation is not included with the packaging of a new injector sleeves, follow the illustrations and steps listed below. Before installing the new injector sleeves, clean them and the cylinder head with a fast drying alcohol cleaning agent.

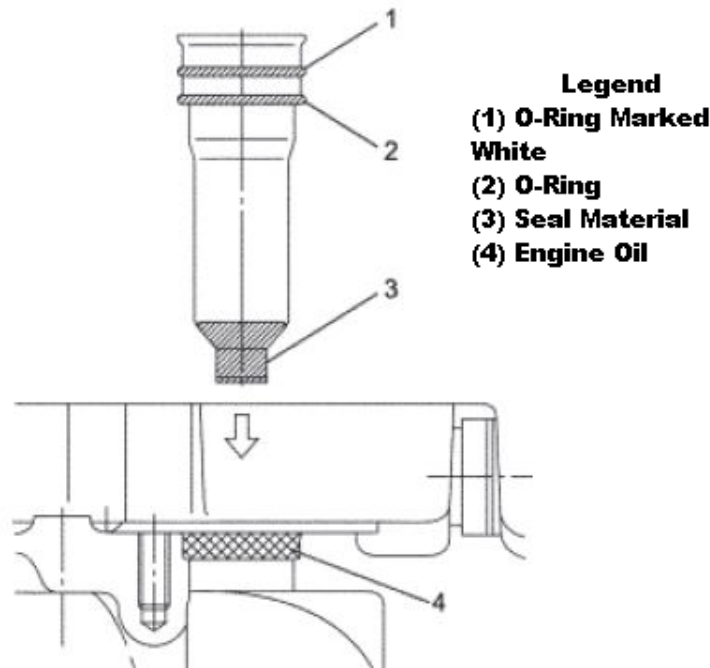


Figure 1. Cylinder Head & Injector Sleeve Detail

- Support the cylinder head on both ends so there is at least ½" clearance between the head deck and the bench below it.
- Install the O-rings on the nozzle sleeve, applying clean engine oil while doing so.
- Apply seal material (Loctite 290 or equivalent) on the taper section above 3.
- Apply lightly a limited amount of clean engine oil to area 4 in Figure 1.
- Install the nozzle sleeve on the cylinder head, insert the guide sleeve.
- Use the guide sleeve to push in so that the nozzle sleeve fully contacts with the under surface of the cylinder head.

- Insert the sleeve and secure it by tightening bracket bolt #6 shown in Figure 2.
- Insert the ball (bearing steel ball .375" (9.525 MM)) into the guide sleeve, attach the punch bar and drive the ball through the injector sleeve.

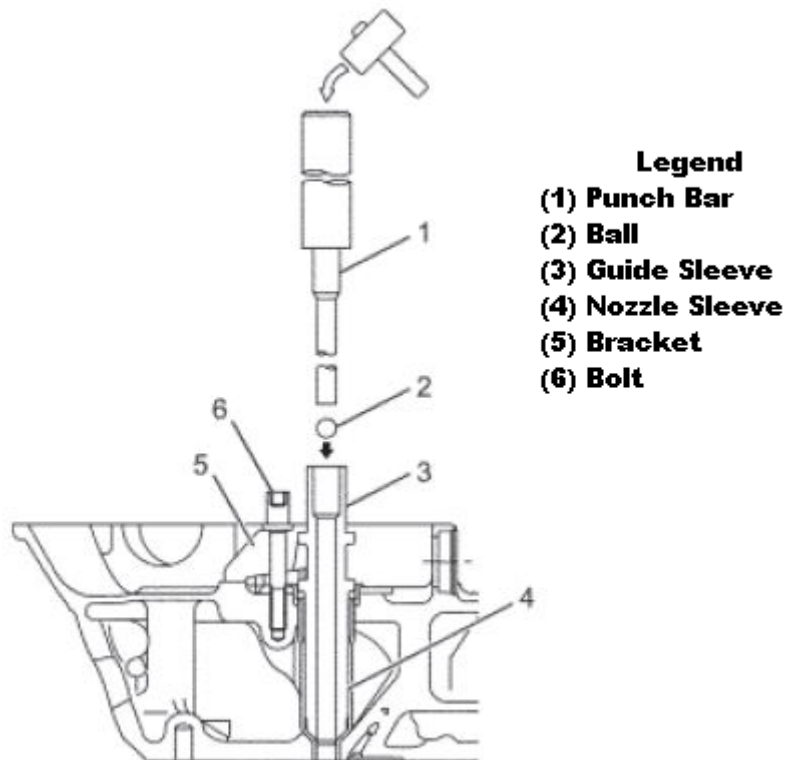


Figure 2. Tooling Detail