

# Rebuilding

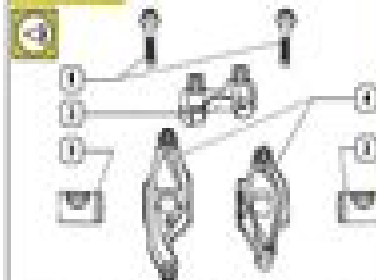
Figure 30



The central hole of the piston pin must show no sign of wear. When the pin is inserted into the piston, the hole must show no sign of wear. If the hole shows wear, the pin must be replaced.

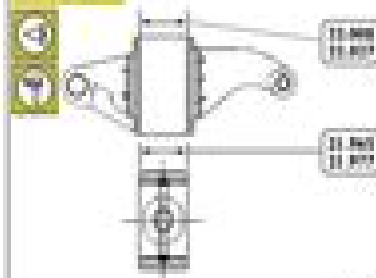
Inspect and adjust valve pistons. See the relevant section for details.

Figure 31



1. Piston pin - 2. Piston - 3. Piston pin

Figure 32



Check that the piston pin surface is not excessively worn or damaged.

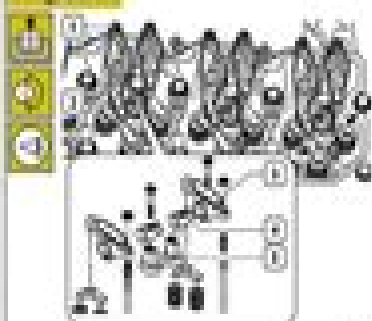
Figure 33



Re-use pistons (2).

Remove pistons (2) on valves with marks (a) facing the exhaust manifold.

Figure 34



Check that the piston pin (1) is correctly seated in the hole when fitting the piston pin assembly.

Then, with the piston pin assembly consisting of the support (2), piston pin (3) and shaft (4), and secure them to the cylinder head by tightening the retaining screw (5) to the torque indicated in the table.

Ref.	No.	Description	Tightening torque
(5)	8	M16x20	30 N·m (22 lbf·ft)

Figure 35



Adjust the clearance between piston pin and valve through Allen screw (2), lock screw (3) and feeler gauge (4).

The opening clearance is:

□ 0.25 to 0.30 mm for the intake valve

□ 0.30 to 0.35 mm for the exhaust valve

Tighten the piston pin (5) to the torque indicated in the table.

Ref.	No.	Description	Tightening torque
(5)	8	M16x20	20 N·m (15 lbf·ft)

**NOTE** To carry out clearance adjustment of the valve - piston pin assembly more quickly, proceed as follows:

□ Install feeler M16x20 (both prior M16x20) on the feeler.

□ Rotate the camshaft, adjust the valve of cylinder no. 1 and adjust the valve marked with an asterisk as shown in the table below.

Cylinder no.	1	2	3	4
Intake	-	-	-	*
Exhaust	-	*	-	*

□ Rotate the camshaft, adjust the valve of cylinder no. 4 and adjust the valve marked with an asterisk as shown in the table below.

Cylinder no.	1	2	3	4
Intake	*	*	-	-
Exhaust	*	-	*	-

Re-use the electroinjector using support as described in the relevant section.

Re-use the piston cover as described in the relevant section.

## ELECTRO-INJECTION REMOVAL/RESETTING

### Removal

Remove the piston cover as described in the relevant section.

Remove the electroinjector using support as described in the relevant section.

Remove the roller pin assembly as described in the relevant section.

Remove a suitable container to collect any fuel when you leak fuel.

Figure 36



Unscrew the plug (1, 2) and remove the high pressure fuel lines from the common rail to the electroinjector manifold.

Ref.	No.	Description
(1)	4	M16x1.5
(2)	4	M16x1.5

Figure 37



Unscrew the nuts (2) and remove the electroinjector manifold (1).

Ref.	No.	Description
(2)	4	M16x1.5

Unscrew the electroinjector retaining screws (3).

Ref.	No.	Description
(3)	4	M16x1.5

# Iveco Technical Manual

**Beverage Industry**



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