

2021 ENGINE

Engine Mechanical - 3.6L (LGZ) - Description and Operation - Canyon, Colorado

DESCRIPTION AND OPERATION

CRANKCASE VENTILATION SYSTEM DESCRIPTION

Crankcase Ventilation System Description

Crankcase vacuum draws fresh air from the air filter through check valves in each of the cam covers into the crankcase. The air travels through the crankcase, scavenging foul air, and then into a fine oil/air separator located in the valley of the cylinder block prior to being deposited into the cylinder head intake ports. Under positive crankcase conditions, the check valves close and all crankcase gas is routed directly into the fine oil/air separator and deposited to the intake ports. Under heavy flow/positive crankcase conditions, a (internal) check valve in the separator will open allowing the overflow gases to flow into the induction and consumed by the engine. The fresh air valve is tamper proof connected to the camshaft carrier.

DRIVE BELT SYSTEM DESCRIPTION

The drive belt system consists of the following components:

- The drive belt
- The drive belt tensioner
- The drive belt idler pulley
- The crankshaft balancer pulley
- The accessory drive component mounting brackets
- The accessory drive components
 - The power steering pump, if belt driven
 - The generator
 - The A/C compressor, if equipped
 - The engine cooling fan, if belt driven
 - The water pump, if belt driven
 - The vacuum pump, if equipped
 - The air compressor, if equipped

The drive belt system may use 1 belt or 2 belts. The drive belt is thin so that it can bend backwards and has several ribs to match the grooves in the pulleys. The drive belts are made of different types of rubbers, chloroprene or EPDM, and have different layers or plys containing either fiber cloth or cords for reinforcement.

Both sides of the drive belt may be used to drive the different accessory drive components. When the back side of the drive belt is used to drive a pulley, the pulley is smooth.

The drive belt is pulled by the crankshaft balancer pulley across the accessory drive component pulleys. The spring loaded drive belt tensioner keeps constant tension on the drive belt to prevent the drive belt from slipping. The drive belt tensioner arm will move when loads are applied to the drive belt by the accessory drive components and the crankshaft.

The drive belt system may have an idler pulley, which is used to add wrap to the adjacent pulleys. Some systems use an idler pulley in place of an accessory drive component when the vehicle is not equipped with the accessory.

ENGINE COMPONENT DESCRIPTION

The High Feature V6 (VIN Code Identifier "S") RPO LGZ is a 3.6 Liter VVT (Variable Valve Timing) engine with direct injection. The direct injection system places the high pressure injectors in the cylinder heads. This engine incorporates 2 intake and 2 exhaust valves per cylinder, and uses a dual overhead cam design with individual intake and exhaust camshafts. A camshaft position actuator is mounted on each camshaft. The cylinders are arranged in 2 banks of 3 with a 60 degree included angle. The right bank of cylinders are number 1-3-5 and the left bank of cylinders are 2-4-6, viewed from the flywheel end of the engine. The engine firing order is 1-2-3-4-5-6.

Active Fuel Management System (AFM)

The AFM consists of the camshafts, valves, the switching roller finger followers (SRFF), also known as the valve switching rocker arm, the dual feed hydraulic lash adjusters and the oil control valve (OCV) which is also known as the valve rocker arm oil control valve.

Depending on engine RPM, the ECM sends a signal to the OCV commanding it either ON or OFF.

With the AFM system ON, the OCV directs oil to the dual feed hydraulic lash adjuster unlatching the switching roller finger followers creating zero lift and not allowing the valves to open on cylinders two and five. AFM is active at this time.

With the AFM system off, the OCV is not active and no oil is directed to the dual feed hydraulic lash adjuster. The switching roller finger followers operate as a normal rocker arm and all valves open 11.5 mm of lift at 90B° BTDC. AFM is inactive at this time.

Camshaft Drive System

The camshaft drive system consists of two timing drive chains driven by the crankshaft which drives the respective cylinder head's intake and exhaust camshaft position actuators. Cushioned actuator chain sprockets have been added contributing to quieter engine operation.

The timing drive chains use moveable timing drive chain guides and a hydraulic-actuated tensioner. The tensioner minimizes timing drive chain noise and provides accurate valve action by keeping slack out of the timing drive chains and continuously adjusting for timing drive chain wear. The tensioner incorporates a plunger that adjusts out with wear allowing only a minimal amount of backlash. All tensioners are sealed to the head or block using a rubber coated steel gasket. The gasket traps an adequate oil reserve to ensure quiet start-up.

Camshaft Position Actuator System

The engine incorporates a camshaft position actuator for each intake and exhaust camshaft. Camshaft phasing changes valve timing as engine operating conditions vary. Dual camshaft phasing allows the further optimization of performance, fuel economy and emissions without compromising overall engine response and drivability. Variable valve timing also contributes to a reduction in exhaust emissions. It optimizes exhaust and inlet valve overlap and eliminates the need for an exhaust gas recirculation (EGR) system.

The camshaft position actuator is a hydraulic vane-type actuator that changes the camshaft lobe timing relative to the camshaft drive sprocket. Engine oil is directed by a camshaft position actuator oil control valve to the appropriate passages in the camshaft position actuator. Oil acting on the vane in the camshaft position actuator rotates the camshaft relative to the sprocket. At idle, both camshafts are at the default or "home" position. At this position, the exhaust camshaft is fully advanced and the intake is fully retarded to minimize valve overlap for smooth idle. In addition, this engine has intermediate park technology, which incorporates an intermediate-lock intake variable valve timing cam phaser, allowing the cams to be parked at the most favorable position for cold starting. Under other engine operating conditions, the camshaft position actuator is controlled by the engine control module (ECM) to deliver optimal intake and exhaust valve timing for performance, drivability and fuel economy. The camshaft position actuator incorporates an integral trigger wheel, which is sensed by the camshaft position sensor mounted in the front cover, to accurately determine the position of each camshaft. The exhaust camshaft position actuator has a different internal configuration than the intake camshaft position actuator since the exhaust camshaft position actuator phases in the opposite direction relative to the inlet camshaft position actuator.

The camshaft position actuator oil control valve (OCV) directs oil from the oil feed in the head to the appropriate camshaft position actuator oil passages. There is one OCV for each camshaft position actuator. The OCV is sealed and mounted to the front cover. The ported end of the OCV is inserted into the cylinder head with a sliding fit. A filter screen protects each OCV oil port from any contamination in the oil supply.

Connecting Rods and Pistons

The connecting rods are sinter-forged with a high copper content and have press-in-place piston pin bushings. The connecting rods and rod cap are aligned by dowel pins retained in the cap. The cast aluminum pistons incorporate a polymer-coated skirt to reduce friction. The pistons are unique to the LGZ both for compression ratio and combustion efficiency. The piston uses two low tension compression rings and one multi-piece oil control ring.

Cooling System

This engine has a targeted cooling system which sends coolant simultaneously to each water jacket in the heads and block. This new, parallel-flow design maximizes heat extraction in the area of the upper deck, intake and exhaust valve bridges in the heads and integrated exhaust manifold with a minimal amount of coolant. The result is more even and consistent cooling, which enhances performance, and faster engine warm up, which improves cold-start efficiency and reduces emissions.

Crankcase

The cylinder block is constructed of aluminum alloy by precision sand-casting with cast in place iron cylinder liners. Each nodular main bearing cap incorporates 6 bolts bolting the cap into the engine block. Along with 2 outer and 2 inner bolts, 2 side bolts are used in the deep skirt block. To prevent aeration, oil return from the valve train and cylinder heads is channeled away from the rotating and reciprocating components through oil drain back passages incorporated into the cylinder heads and engine block. Pressure-actuated piston oil cooling jets are mounted between opposing cylinders. Twin knock sensors are located in the valley of the block between the cylinder heads. The knock sensors have an acoustic foam noise barrier that surrounds them in the valley.

Crankshaft

The crankshaft is a hardened, forged steel design with 4 main bearings. Crankshaft thrust is controlled by the upper portion of the number 3 main bearing. The crankshaft position reluctor wheel is pressed onto the rear of the crankshaft in front of the rear main journal. A micro encapsulated adhesive is used on the reluctor wheel to aid retention. This crankshaft is internally balanced.

Cylinder Heads

The cylinder heads are a two piece design consisting of a head and a camshaft carrier which are cast aluminum with powdered metal valve seat inserts and valve guides. The two piece design allows for the Active Fuel Management (AFM) System. The cylinder heads also feature integrated exhaust manifolds; the exhaust manifolds are incorporated into the head casting. Two intake valves and two exhaust valves are actuated by roller finger followers pivoting on a stationary hydraulic lash adjuster (SHLA). In the LGZ engine, the valves and seats are constructed with specialized materials and coatings, and the exhaust valves are sodium filled for robustness. The cylinder heads also feature a "high-tumble" port design, and are sealed with LGZ specific head gaskets. The head gaskets are also specific to the LH and RH sides.

Separate exhaust and intake camshafts are supported by bearings machined into the camshaft carrier. The front camshaft bearing cap is used as a thrust control surface for each camshaft. Each spark plug is shielded by a tube that is pressed into the cylinder head. Each spark plug ignition coil is also mounted through the spark plug tube. The LGZ engine uses specific spark plugs and a different spark plug gap from other HFV6 engines. The engine coolant temperature (ECT) sensor is mounted in the thermostat housing near the flywheel end of the engine. With direct injection, the high pressure injectors are located in machined bores below the intake ports. A stainless steel, high pressure fuel rail is attached to the intake side of the head. The LGZ engine has unique higher-flow injectors and fuel pump. The cylinder head has a larger bore for the new larger diameter fuel pump

follower that operates the higher-flow pump. The fuel injectors are retained to the fuel rail in a new "twist-lock" retention scheme that does not require special tools for service.

Oiling System

The LGZ engine contains a dual-pressure control and variable-displacement vane pump that enhances efficiency by optimizing oil pressure as a function of engine speed. The oil pump is located beneath the cylinder block inside the oil pan, contributing to the engines smoother and quieter operation. The oiling system components differ depending on the engine being in a transverse or longitudinal orientation. The LGZ has unique oil pans depending on orientation, with the pans being separated into an upper (traditional aluminum) and lower (stamped steel) pan. This configuration helps with noise and mass concerns. It also affords some serviceability improvements through not needing to remove the entire upper pan for some service procedures; the procedures can be performed through removing the lower pan. The LGZ oil pans contain oil level switches as do nearly all HFV6 applications. The oil level switch is normally open and closes at oil levels above minimum requirements.

Right and Left Bank Designation

Right hand (RH) and left hand (LH) designation through the engine mechanical section are viewed from the rear, flywheel side, of the engine or from inside the vehicle. These banks are also referred to as Bank 1 (RH) and Bank 2 (LH).

NEW PRODUCT INFORMATION

The purpose of New Product Information is to highlight or indicate important changes from the previous model year.

Changes may include one or more of the following items:

- Torque values and/or fastener tightening strategies
- Changed engine specifications
- New sealants and/or adhesives
- Disassembly and assembly procedure revisions
- Engine mechanical diagnostic procedure revisions
- New special tools required
- A component comparison from the previous year

The LGZ is a new engine based on the LGX, though nearly all components are unique to the LGZ. Refer to [Engine Mechanical Specifications](#) for detailed information.

Torque Values and/or Fastener Tightening Strategies

- All fasteners and threaded holes on the engine utilize metric threads.
- Cylinder head, front cover, and crankshaft main bearing cap bolts apply a two-step, torque and angle tightening strategy.
- Certain fasteners may not be used again. Bolts, studs, or other fasteners that must be replaced will be called out in the specific service procedure.
- There are high strength stainless steel fuel lines that require extreme care and proper order and torque when tightening the connections. Refer to specific service procedures for details.

Changed Engine Specifications

Some specifications have been revised for the LGZ engine. Refer to [Engine Mechanical Specifications](#) for details.

New Sealants and/or Adhesives

Sealers and adhesives, as required, are identified within the specific service procedures. Refer to [Adhesives, Fluids, Lubricants, and Sealers](#) .

Disassembly and Assembly Procedure Revisions

The LGZ is based on the LGX engine and is largely similar, however, specific LGZ procedures should be followed.

Engine Mechanical Diagnostic Procedure Revisions

Diagnosis on a vehicle should follow a logical process. Strategy based diagnostics is a uniform approach for repairing all systems. The diagnostic flow should always be used in order to resolve a system condition. The diagnostic flow is the place to start when repairs are necessary. For a detailed explanation, refer to [Diagnostic Starting Point - Vehicle](#) .

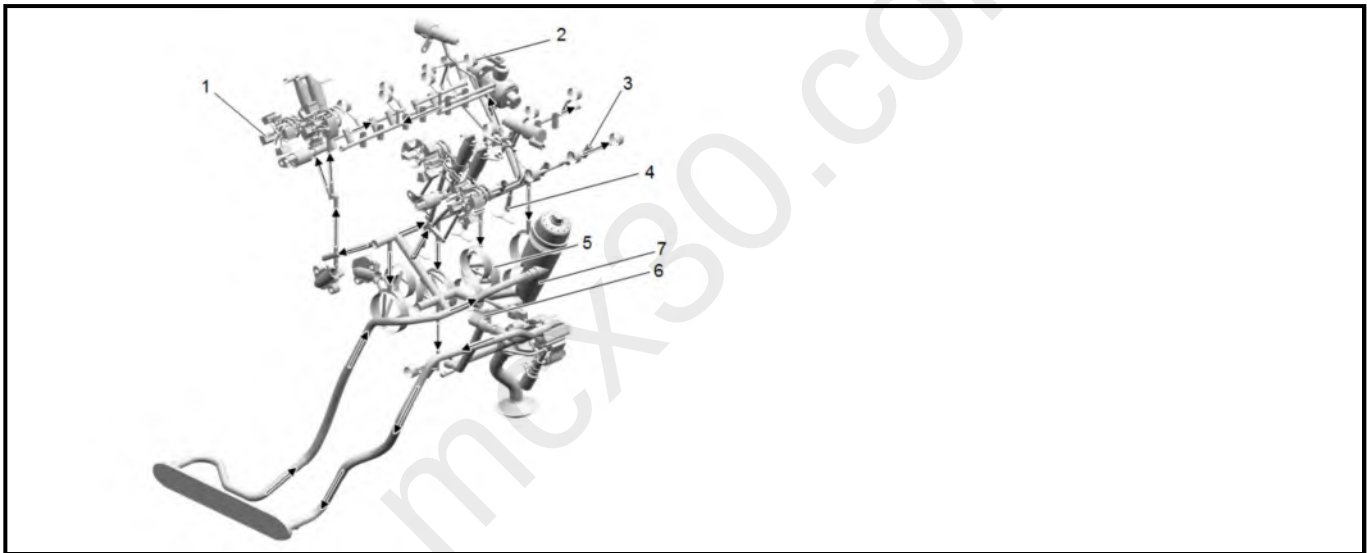
New Special Tools Required

There are no special tools unique to the LGZ engine.

A Component Comparison from the Previous Year

The LGZ engine is new this year. Refer to [Engine Component Description](#) for detailed information.

LUBRICATION DESCRIPTION



Engine lubrication is supplied by a variable displacement two-stage vane-type oil pump assembly. An oil control solenoid valve, controlled by the engine control module (ECM) and mounted to the oil pump, will vary engine oil pressure according to engine needs based on speed and load. Oil pressure may change quickly as the engine speed or load varies. Oil pressure may also vary with outside temperature and oil viscosity. This is considered normal. The oil pump is mounted to the engine block oil pan rail and main bearing caps and is driven by a dedicated timing chain. The pump rotor and vanes rotate and draw oil from the oil pan sump through a pick-up screen and pipe. The oil is pressurized as it passes through the pump and is sent to the oil cooler if equipped for oil conditioning.

Pressurized oil is directed through the oil pan to the full flow oil filter (7) where harmful contaminants are removed. A bypass valve is incorporated into the oil filter, which permits oil flow in the event the filter becomes restricted. Oil exits the oil filter and is then directed to the main oil gallery. Oil from the main oil gallery is directed to the crankshaft bearings (5), piston oil nozzle (4) used for piston cooling under certain conditions, and the cylinder heads via drilled passages.

Oil that has entered the cylinder heads is used to actuate the camshaft position phasors (1), pressurize the hydraulic lash adjusters (3), lubricate the cam bearings (2) and valve train, and actuate cylinder deactivation and reactivation through ECM control of the active fuel management (AFM) oil control valves located on the

camshaft covers. With active fuel management activated, the ECM commands the two AFM solenoids to open, directing oil through the camshaft cover and cylinder head oil galleries to deactivate the intake and exhaust valve for cylinders 2 and 5.

Oil returning to the pan is directed by the crankshaft oil deflector. The oil pressure sensor is located on the oil filter adaptor.

CLEANLINESS AND CARE

An automobile engine is a combination of many of the following surfaces:

- Machined
- Honed
- Polished
- Lapped

The tolerances of these surfaces are measured in the ten-thousandths of an inch. When you service any internal engine part, cleanliness and care are important. Apply a liberal coating of engine oil to the friction areas during assembly in order to protect and lubricate the surfaces on initial operation. Throughout this section, practice proper cleaning and protection procedures to the machined surfaces and to the friction areas.

CAUTION: Engine damage may result if an abrasive paper, pad, or motorized wire brush is used to clean any engine gasket surfaces.

Whenever you remove the valve train components, keep the components in order. Follow this procedure in order to install the components in the same locations and with the same mating surfaces as when removed.

WARNING: Refer to [Battery Disconnect Warning](#) .

Disconnect the negative battery cables before you perform any major work on the engine.

SEPARATING PARTS

In addition to the room temperature vulcanizing (RTV) sealant's sealing capabilities, the RTV sealants may form an adhesive bond between the components. This may make the components difficult to remove or to separate. Pry points have been provided in the components that utilize RTV as the sealing system. Pry points are positioned so they can be used without damaging other vital engine components.

REPLACING ENGINE GASKETS

Special Tools

EN-28410 Gasket Remover

For equivalent regional tools, refer to [Special Tools](#) .

Gasket Reuse and Applying Sealant

- Do not reuse any gasket unless specified.
- Gaskets that can be reused will be identified in the service procedure.
- Do not apply sealant to any gasket or sealing surface unless specified in the service procedure.

Separating Components

- Use incorporated pry points to separate components using an RTV sealing system.
- Do not try to separate RTV sealed components by prying against other engine components.
- Pry points are positioned so no other vital engine components are damaged when they are used.

Cleaning Gasket Surfaces

- Use care to avoid gouging or scraping the sealing surfaces.
- Use a plastic or wood scraper in order to remove all the sealant from the components.

Do not use any other method or technique to remove the sealant or the gasket material from a part.

- Do not use abrasive pads, sand paper, or power tools to clean the gasket surfaces.
 - These methods of cleaning can cause damage to the component sealing surfaces.
 - Abrasive pads also produce a fine grit that the oil filter cannot remove from the engine oil.

This fine grit is an abrasive and can cause internal engine damage.

Assembling Components

- Assemble components using only the sealant, or equivalent, that is specified in the service procedure.
- Sealing surfaces must be clean and free of debris or oil.
- Specific components such as crankshaft oil seals or valve stem oil seals may require lubrication during assembly.
- Components requiring lubrication will be identified in the service procedure.
- Apply only the amount of sealant specified in the service procedure to a component.
- Do not allow the sealant to enter into any blind threaded holes, as the sealant may prevent the fastener from clamping properly or cause component damage when tightened.

NOTE: Do not overtighten the fasteners.

- Tighten the fasteners to the proper specifications.

USE OF ROOM TEMPERATURE VULCANIZING (RTV) AND ANAEROBIC SEALANT

Cleaning Mating Part Surfaces for RTV Joints

RTV sealant depends greatly on adhesion to the mating parts in order to form and maintain a robust sealed joint. As with any adhesion system, proper surface preparation of the bonded parts is extremely important to ensure good adhesion over the life of the product.

CAUTION: When cleaning the sealing surfaces of engine components, DO NOT use bristle discs, abrasive pads, wire wheels or surface conditioning discs. These types of devices should not be used because they produce a very fine grit that is abrasive and known to cause internal engine damage. The bristle discs and pads are embedded with abrasive material and wear down as they clean, continually exposing fresh abrasive to the surface of the component.

Abrasive pads, wire wheels and bristle discs can remove enough metal to affect the engine front cover, cylinder head, engine block, oil pan rail, and intake manifold runner surface flatness, which can then result in engine coolant leaks, engine oil leaks and air leaks. It takes about 15 seconds to remove 0.203 mm (0.008 in) of metal with an abrasive pad.

Abrasive pads, wire wheels and bristle discs used with high speed grinders produce airborne debris that can travel throughout the shop contaminating other work being performed outside of the immediate work area.

When cleaning engine gasket sealing surfaces and/or cleaning parts from an engine that are to be reused, surface conditioning discs, typically constructed of woven fiber or molded bristles that contain abrasives, such as a high amount of aluminum oxide, should NOT be used. The use of such surface conditioning discs dislodges aluminum oxide from the disk and metal component particles, which can lead to premature engine bearing failure. The presence of aluminum oxide in engine oil has been shown to cause premature engine

bearing failure. In some cases, this failure occurs in as little as 1, 600 km (1, 000 mi) or less after the repair has been made.

Surface conditioning discs may grind the component material and embed it into the disc. This can result when more aggressive grinding of the gasket surface takes place.

General Motors strongly recommends using a plastic razor blade, plastic gasket scraper, a wood scraper or a non-metallic scraper to remove all sealer/gasket material on the surface of engine components that are to be reused. Do not use any other method or technique to remove the sealant or the gasket material from a part.

- Do not gouge or scratch any engine sealing surface during the cleaning process.
- It is not necessary to remove every speck of the old sealer.

To remove the old RTV sealant from the sealing surface, spray GM Low VOC Cleaner or an equivalent, on the mating surfaces and allow it to soak to loosen the old gasket material. Use care to avoid getting GM Low VOC Cleaner in any area other than the mating surface to be cleaned.

Use a plastic razor blade, that mounts in a scraper device or a hand held plastic razor blade, to remove old RTV sealant from a sealing surface. Use a new blade for each corresponding engine component surface. Hold the blade as parallel to the flat surface as possible.

To properly clean the sealing surfaces prior to reassembly, spray GM Low VOC Cleaner on a folded lint free shop cloth. Wipe the mating surfaces on the engine and front cover and rotate the shop cloth until there are no more visible signs of contamination on the cloth.

After the final cleaning of the parts, allow up to 5 minutes for the components to dry before applying new RTV sealant.

NOTE: After the final cleaning with GM Low VOC Cleaner and before reassembly, **DO NOT touch the cleaned surfaces with your hand. Oils from your skin WILL CONTAMINATE the surface and prevent proper bonding of the new RTV sealant.**

Typical Applications

This procedure is intended for use in the following operations:

- Building of engines in a manual low volume build process where the use of assembly lubricants and other typical conditions exist which may contaminate the component sealing surfaces in an RTV joint.
- Cleaning of surfaces contaminated with oil or other substance during the assembly operation as a special case event.

In the typical situation, both the part being assembled, and the assembly to which it is to be sealed will be cleaned. An example is an oil pan assembled to a block/front cover/rear cover assembly using an RTV seal applied to the pan or the block. Both the pan and the block assembly should be cleaned prior to RTV application.

Any loose gaskets that are part of the RTV joint should not be cleaned unless it is known that they have been contaminated during the build process. Examples of loose gaskets are intake side and end seals which contact RTV used to seal a T-joint.

Assemblies supplied to GM with gaskets in place should not be cleaned unless they are known to be contaminated during the build process. Examples are rocker/cam covers with press in place gaskets using RTV at corners or T-joints.

Materials Needed

Use clean dry lint free cloths to wipe surface with approved solvent based cleaner. Examples are:

- GM Good Wrench Service Low VOC Brake Parts Cleaner
- AC Delco Non-Chlorinated Brake Parts Cleaner
- Loctite ODC - Free Cleaner & Degreaser

Procedure:

1. Identify the surfaces to which the RTV will come into contact in the assembled joint.
2. Using an approved solvent based cleaner, thoroughly soak an appropriate portion of a clean, dry cloth. Immediately wipe the surfaces with the cloth to remove any residue of oil, soap, etc.
3. Repeat step 2 using a clean portion of the cloth as many times as required until the cleanliness of the cloth after wiping the surface becomes constant in appearance. There is typically some discoloration of the cloth after wiping however a clean surface should produce the same level of discoloration with successive wiping with a clean cloth and solvent.
4. If crevices exist in the joint such that wiping the surface would not be sufficient to clean the crevice, the approved solvent based cleaner should be directly sprayed on the joint to ensure wetting of the surfaces and removal of the contaminant. DO NOT spray rubber components directly. Care must be used to avoid getting solvent in areas other than necessary to clean the joint. Then continue with step 3.
5. Allow the surfaces to dry for a minimum of 1 minute or longer if necessary for the solvent to evaporate from the surface.
6. Do not touch the cleaned surface with anything prior to RTV application.
7. The surface is now prepared for RTV application.

Sealant Types

NOTE: The correct sealant and amount of sealant must be used in the proper location to prevent oil leaks, coolant leaks, or the loosening of the fasteners. DO NOT interchange the sealants. Use only the sealant, or equivalent, as specified in the service procedure.

The following two major types of sealant are commonly used in engines:

- Room Temperature Vulcanizing (RTV)
- Anaerobic sealant, which include the following:
 - Gasket Eliminator
 - Pipe Sealant
 - Threadlock

Room Temperature Vulcanizing (RTV) Sealer

This type of sealant is used where two components, such as the intake manifold and the engine block, are assembled together.

Use the following information when using RTV sealant:

- Do not use RTV sealant in areas where extreme temperatures are expected. These areas include:
 - The exhaust manifold
 - The head gasket
 - Any other surfaces where a different type of sealant is specified in the service procedure
- Do not use RTV sealant unless the ambient air temperature is at least 18B°C (65B°F) degrees or higher.
- Always follow all the safety recommendations and the directions that are on the RTV sealant container.
- Use a plastic or wood scraper in order to remove all the RTV sealant from the components.

CAUTION:

Do not allow the RTV sealant to enter any blind threaded hole. RTV sealant that is allowed to enter a blind threaded hole can cause hydraulic lock of the fastener when the fastener is tightened. Hydraulic lock of a fastener can lead to damage to the fastener and/or the components. Hydraulic lock of a fastener can also prevent the proper clamping loads to be obtained when the fastener is tightened. Improper clamping loads can prevent proper sealing of the components allowing leakage to occur. Preventing proper fastener tightening can allow the components to loosen or separate leading to extensive engine damage.

NOTE:

The bead size is critical and is easier to maintain consistency and application with a RTV dispensing tool. This also helps to eliminate waste.

- The surfaces to be sealed must be clean and dry.
- Use a RTV sealant bead size as specified in the service procedure.
- Apply the RTV sealant bead to the inside of any bolt holes areas.

NOTE:

Do not wait for the RTV sealant to skin over.

- Assemble the components while the RTV sealant is still wet to the touch, within 10 minutes.

NOTE:

Do not overtighten the fasteners.

- Tighten the fasteners in sequence, if specified, and to the proper torque specifications.

Anaerobic Type Gasket Eliminator Sealant

Anaerobic type gasket eliminator sealant cures in the absence of air. This type of sealant is used where two rigid parts, such as castings, are assembled together. When two rigid parts are disassembled and no sealant or gasket is readily noticeable, then the two parts were probably assembled using an anaerobic type gasket eliminator sealant.

Use the following information when using gasket eliminator sealant:

- Always follow all the safety recommendations and directions that are on the gasket eliminator sealant container.
- Apply a continuous bead of gasket eliminator sealant to one flange.
- The surfaces to be sealed must be clean and dry.

CAUTION:

Do not allow the sealant to enter a blind hole. The sealant may prevent the fastener from achieving proper clamp load, cause component damage when the fastener is tightened, or lead to component failure.

- Do not allow the gasket eliminator sealed joint to cure more than 5 minutes before torquing to specification. This will result in an incorrect clamp load of assembled components.
- Do not overtighten the fasteners.
 - Apply the gasket eliminator sealant evenly to get a uniform thickness of the gasket eliminator sealant on the sealing surface.
 - Tighten the fasteners in sequence, if specified, and to the proper torque specifications.
 - After properly tightening the fasteners, remove the excess gasket eliminator sealant from the outside of the joint.

Anaerobic Type Threadlock Sealant

Anaerobic type threadlock sealant cures in the absence of air. This type of sealant is used for threadlocking and sealing of bolts, fittings, nuts, and studs. This type of sealant cures only when confined between two close fitting metal surfaces.

Use the following information when using threadlock sealant:

- Always follow all safety recommendations and directions that are on the threadlock sealant container.
- The threaded surfaces to be sealed must be clean and dry.
- Apply the threadlock sealant as specified on the threadlock sealant container.

NOTE:

- **Do not allow the threadlock sealant to cure more than 5 minutes before torquing to specification. This will result in an incorrect clamp load of assembled components.**
- **Do not overtighten the fasteners.**

- Tighten the fasteners in sequence, if specified, and to the proper torque specifications.

Anaerobic Type Pipe Sealant

Anaerobic type pipe sealant cures in the absence of air and remains pliable when cured. This type of sealant is used where two parts are assembled together and require a leak proof joint.

Use the following information when using pipe sealant:

- Do not use pipe sealant in areas where extreme temperatures are expected. These areas include:
 - The exhaust manifold
 - The head gasket
 - Surfaces where a different sealant is specified
- Always follow all the safety recommendations and the directions that are on the pipe sealant container.
- The surfaces to be sealed must be clean and dry.
- Use a pipe sealant bead of the size or quantity as specified in the service procedure.

CAUTION:

Do not allow the sealant to enter a blind hole. The sealant may prevent the fastener from achieving proper clamp load, cause component damage when the fastener is tightened, or lead to component failure.

- Apply the pipe sealant bead to the inside of any bolt hole areas.
- Apply a continuous bead of pipe sealant to one sealing surface.

NOTE:

Do not overtighten the fasteners.

- Tighten the fasteners in sequence, if specified, and to the proper torque specifications.

TOOLS AND EQUIPMENT

- Special tools are listed and illustrated throughout this section, with a complete listing at the end of the section. These tools, or their equivalents, are designed to quickly and safely accomplish the operations for which they are intended. The use of these special tools also minimize possible damage to engine components. Some precision measuring tools are required for inspection of certain critical components. Torque wrenches and a torque angle meter are necessary for the proper tightening of various fasteners.
- To properly service the engine assembly, the following items should be readily available:
 - Approved eye protection and safety gloves
 - A clean, well-lit, work area
 - A suitable component cleaning tank

- A compressed air supply
 - Trays or storage containers to keep components and fasteners organized
 - An adequate set of hand tools
 - Approved engine repair stand
 - An approved engine lifting device that adequately supports the weight of the components
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