



Fig. 21

NOTE - The wire tube must be up and towards the right.

Insert the spring distributor and secure it as well as the automatic advance with 4 screws and 3 washers.

Assembling the Crankshaft Governor

Insert the driving piston, the 21-14.3 tab washer and the 14-12M nut.

Insert the governor by means of tool (4) and adjust the nut with a standard 1/8" spanner. Lock the washer on the nut (see Fig. 45, page 54).

ASSEMBLING THE PISTON ON THE CONNECTING ROD

Start at all starting from the top, to the upper...

INSTALLING THE PISTON RING



FITTING THE CYLINDER

Take the cylinder with the...



Fig. 22

As you lay in the valve, use the special tool provided, pulling upward and rotating alternately clockwise and counter-clockwise.

Change the position every now and then. Clamp the piston and the valve seat, assemble on top the valve and the valve nut, assemble as above by means of tool (2) and pull the valve down.

Fill the combustion chamber with petrol or kerosene and then blow with compressed air - from the exhaust pipe connection, in the case of exhaust valve, from the intake duct in the case of intake valve.

The operation must, of course, be carried out on the opposite side at a time; in the meanwhile, the other valve must either be properly fixed in its place or hung on its nut (even in the latter case the head will not flow through the valve head).

If bubbles do not appear on the surface of the liquid, then the operation has been correct. If bubbles do appear, then the tapping...

...the valve...

PREPARING THE CYLINDER HEAD

...the valve head...

Mounting the valves

...the valve head...



Fig. 23

Assembling the anchorage and springs (already fixed together) on the head

Fit the rubber oil seal on the valve guide. Assemble the anchorage/springs onto the head by inserting the anchorage in the valve-guide and by the anchorage threads in the head by tapping lightly with a pin punch and a hammer.



Fig. 24

NOTE - Wire thickness and tension of the intake and exhaust valve springs differ. Make sure to match the heavier intake valve springs with the intake valve, especially in the models Monza - Mark 1 and 4 - SR - G1 from c.a. 1942.

Loading the valve springs

Using tool (21), pull the springs until you can insert the spring cable on the valve seat...

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