40E
Crawler

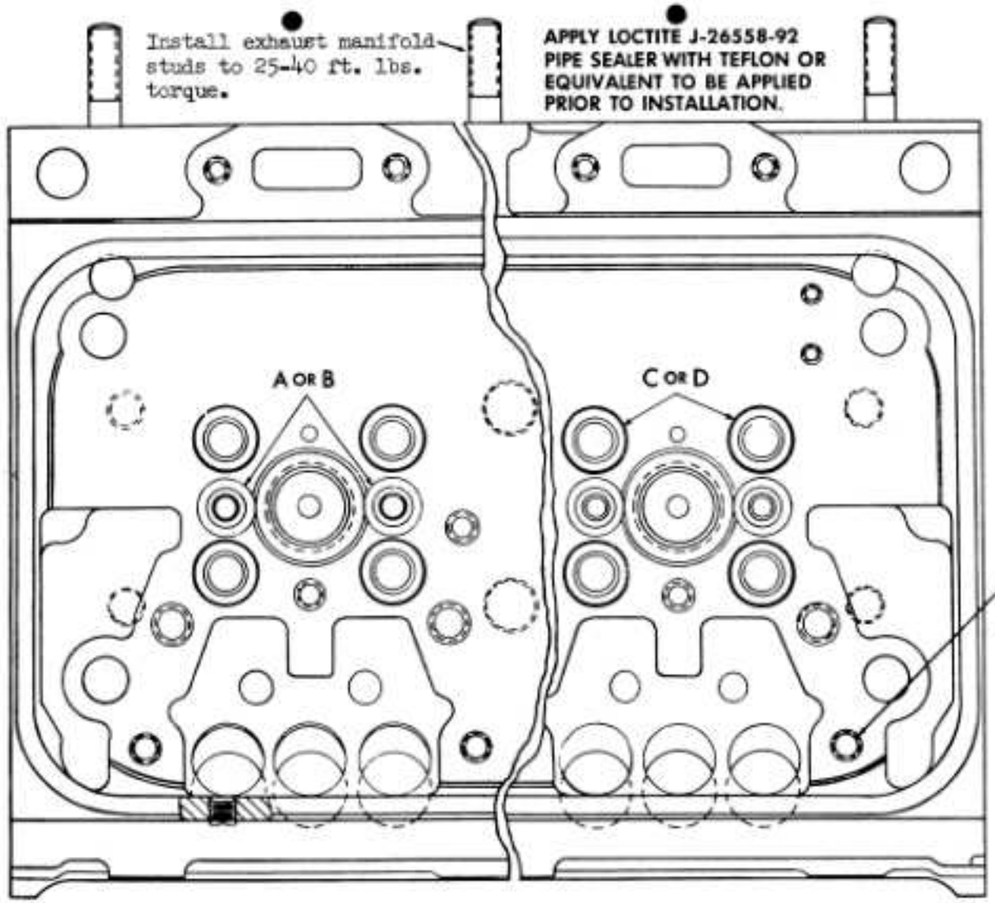
Service Manual

8-38230

CASE CONSTRUCTION

MidWestTech | Case 40E Crawler Service Manual | Publication 8-38230

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SERIES 71
FOUR VALVE HEAD
PLUGGING CHART

STANDARD PIPE PLUG TORQUE*

PIPE PLUG SIZE	TORQUE/FT. LBS.
1/8	10-12
1/4	14-16
3/8	18-22
1/2	23-27
3/4	33-37

*Caution—Do Not Over Torque Teflon Wrapped Pipe Plugs.

Install plug in both ends of cylinder head except on thermostat housing end(s) for 6V and 8V engines only.

Install fuel manifold connectors and washers.

A - Use with three spring design (spring under bridge).

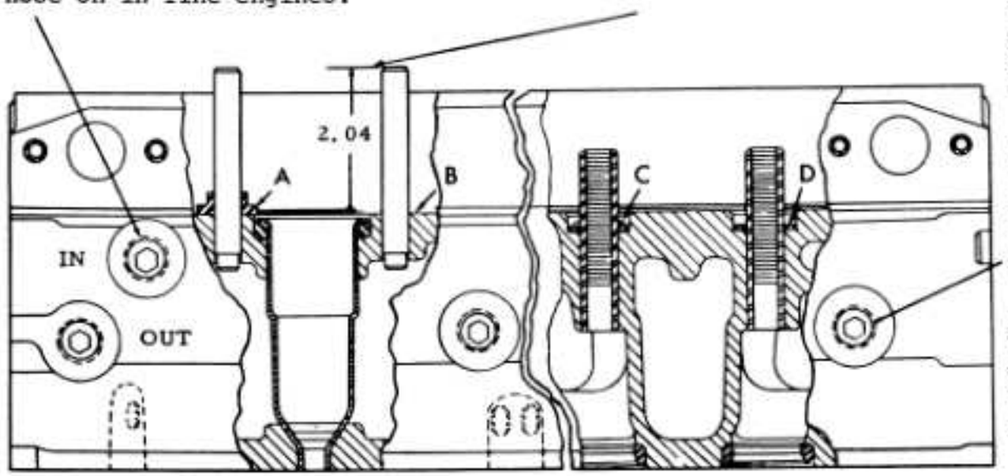
B - Two spring design (no spring under bridge).

C - Use with .581 I.D. valve spring.

D - Use with .645 I.D. valve spring.

Install special 1/4 pipe plugs in all manifold end and side positions except fuel inlet and outlet positions convenient for assembly of flexible hose on in-line engines.

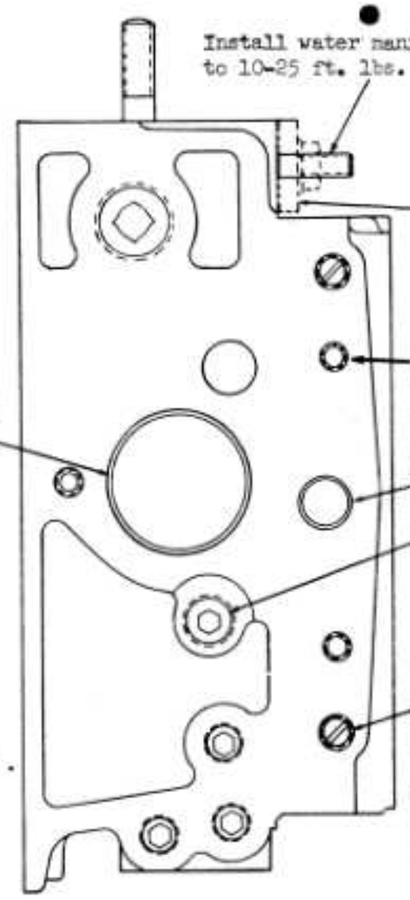
Bridge guides to be installed as shown.



Install restricted (R) orifice connector in convenient location in fuel manifold outlet.

Note: Use .1065" connector (marked R10) with 90CMM injectors. Use .080" connector (marked R80, R08 or R8) with all other injectors.

Install 1/4 pipe plugs below surface of head when assembling plugs in end positions on 71 in-line engines.





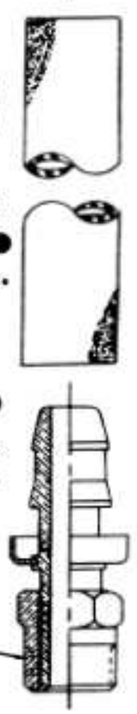
Cover plates and gaskets to be used on 6V and 8V-71 engines. Retain with lock washers and 3/8-24 Nuts.

Install 3/8" headless plugs in both ends

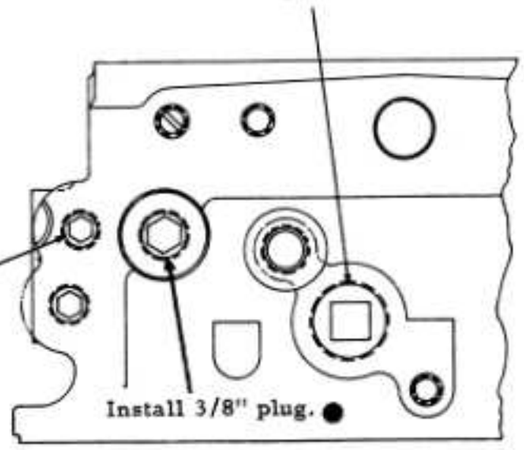
Install plug at each end except when lifter bracket is installed.

Install 3/8"-18 plug at each end to 1/16" above surface. 7/32" rod in oil feed hole must pass inner face of plug.

7/16-14 headless plug to be installed in two holes, both ends on V-71 engines. Install plugs on in-line engines only when lifter bracket is not used.



Before installing thermostat housings on 12V-71 engines, remove 3/4 pipe plug from front of both cylinder heads.



TO ASSEMBLE HOSE & FITTINGS

(1) Cut hose to required length. Oil inside of hose and outside of nipple.

(2) Push hose on fitting underneath protective cap.

REV. 1-81

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