

Injector sleeve fitting instructions

Injector sleeve 37D2599 was originally designed to be fitted to the BMC/Leyland 2.6, 2.8, 3.4, 3.8, 5.1, 5.7 engines. The sleeve is larger at the top than the bottom it is worth stating that some of the above engines will be fitted with AMK330 which is a parallel sleeve, this was fitted to early 2.6, 3.4, 3.8, 5.1 engines.

All Leyland injector sleeves were designed to be fitted with rolling tools LC.173 and LC.174.



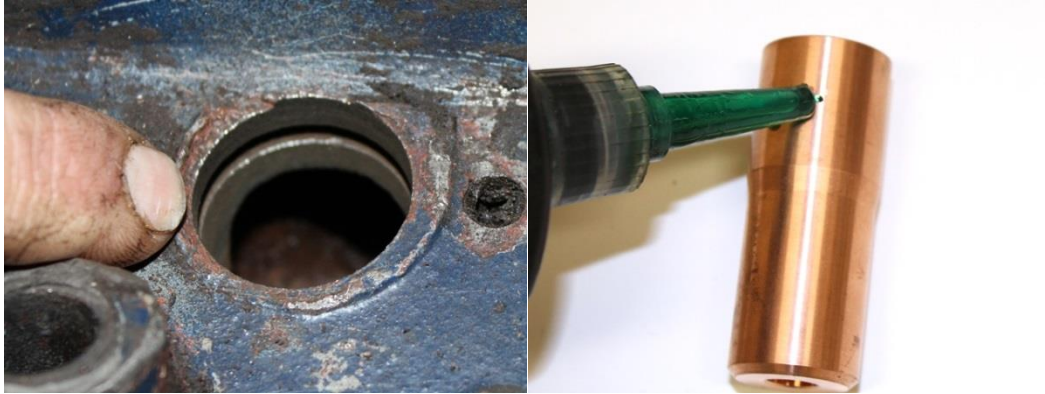
These tools are still available but very expensive; we at Tractor Spare Parts Ltd have redeveloped 37D2599 so it can be fitted without the over rolling tools. It's worth noting these new sleeves can also be used on the 4/98 and 6/98 series of engines. When used on these engines you do not have to fit the loose injector washer 86K1099.

The fitting instructions below are for a cylinder head off a Leyland 4/98 engine.

Firstly remove the old sleeve and o-ring (if fitted) from the head, and then clean with rotary wire brush.



Next check there are no burrs around the edge of the hole, as if burrs are not removed they will damage the side of the injector sleeve as it's fitted. Fit new o-ring 86K906 if required, next apply high strength bearing retainer (Loctite, Bondloc Studlock B270 are the brands we use or an equivalent) around the top the sleeve and in the bore in the cylinder head.



Fit the sleeve now into the head, you will need a flat face mandrel to drive the sleeve home.



Finally use the back side of a socket and extensions bar to swell the open end sleeve.