

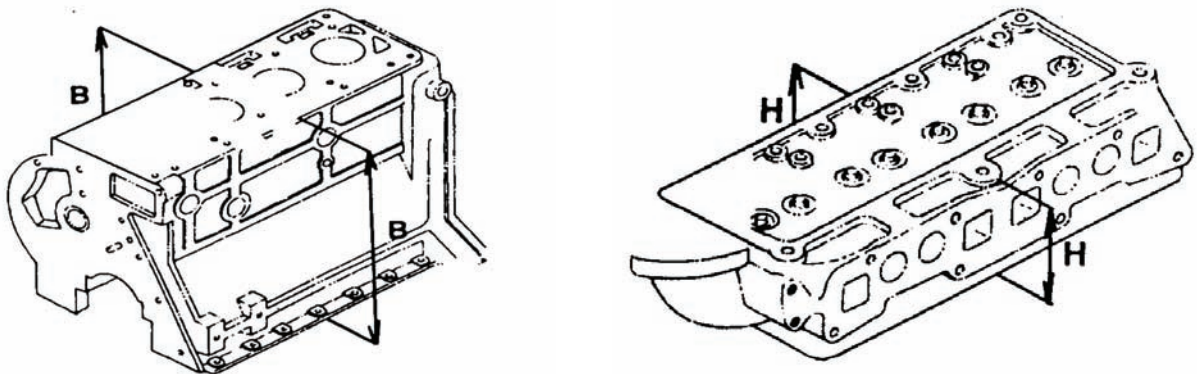
# Technical Stuff - Head and block resurfacing limits

This technical bulletin gives details of why flatness and tolerances of machined surfaces are important. It also indicates some of the ways we can distort blocks and heads, and how to check them. All that we are giving here are the factory tolerances from the bulletin.

1. Neither cylinder head nor engine block curvature may exceed 0.10mm (0.0039. inch) from front to back, measured at the mating surfaces; the curvature can be either convex or concave.
2. The standard height of a cylinder head, "H" in the diagram, is:  
R16 (1600) engine 82.5mm (3.248")  
U20 (2000) engine 115.0mm(4.528")
3. The standard height of an engine block, "B" in the diagram, is 282.05mm (11. 104") for both blocks.
4. Replace the head or block if the measurement at any point along the component is less than the minimum dimension which is (standard height minus 0.2mm (.0079")).
5. If both the head and the block passes this test, up to 0.2mm (.0079") total may be removed.  
Example: Both head and block are warped; it is decided to resurface them.

Head: 0.15mm (0.0059 ") removed  
Block: 0.05mm (0.0020") removed  
Total: 0.20mm (0.0079") removed.

Note: **Make sure you measure at points all along the head and block**, not just in the middle (as in our diagram)



*Courtesy of the Datsun Roadster Association.*

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