



SERVICE

V8 XJ Series/XK8

DATE 12/98

303-31

## TECHNICAL BULLETIN

Replacement Cylinder Heads – Preparation  
for Normally Aspirated Engines  
With VVT Feature – Procedure

MODEL  
1997-98 MY XK8 Range  
1998 MY V8 XJ Series  
VIN  
001001-031302  
812256-853935

**Issue:**

Cylinder heads are supplied by Jaguar Parts as a common part for all three versions of the V8 engine: 3.2 Liter (non-NAS), 4.0 Liter normally aspirated and 4.0 Liter supercharged.

The oil supply gallery for the Variable Valve Timing (VVT) unit that is present on all these cylinder heads is plugged which makes the cylinder head **non-VVT** specification as used on supercharged engines.

When a replacement cylinder head is installed on an engine that is equipped with VVT units, the plug must first be removed to permit VVT operation on that cylinder bank. The aluminum blind rivet plug in the VVT supply gallery is secured in position similar to a pop rivet in that the center pin and cone is pulled to expand the rivet until the pin shears below the head. This leaves the aluminum plug and the head of the pin in position to seal the gallery.

**Action:**

When installing a replacement cylinder head on a normally aspirated 1997-98 MY V8, proceed as follows to remove the blind rivet plug:

1. Place the cylinder head on a clean workbench area with access to a compressed air supply.
2. Identify the VVT supply gallery and the 8 mm. plug. (bold arrow, Illustration 1).

REMOVING OIL GALLERY PLUG

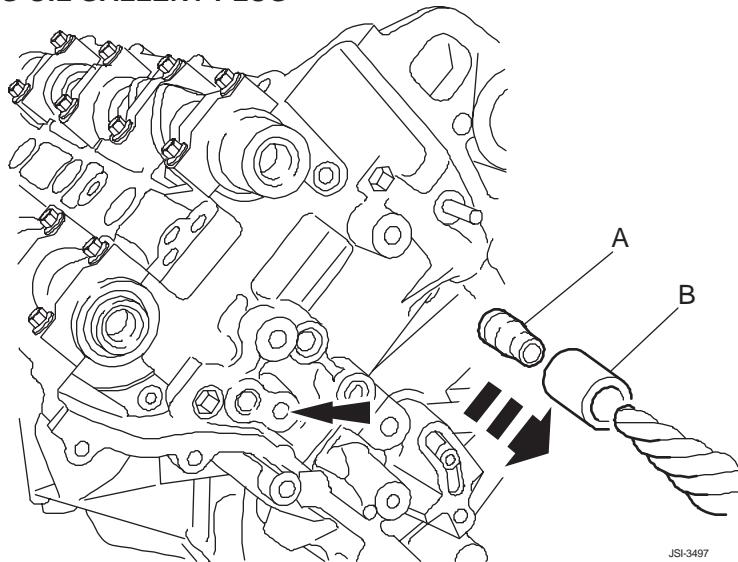


ILLUSTRATION 1

3. Use a 3 mm. (1/8") punch to drive the pin and cone (A, Illustration 1) through the center of the plug until they drop behind the plug.
4. Use a screw extractor to remove the plug (B, Illustration 1). The center bore of the plug is 6 mm. (7/32") diameter.
5. Use a magnet to probe the gallery to locate and remove the pin and cone.
6. Identify the oil supply gallery in the lower cylinder head face and then apply a clean compressed air supply to blow out any debris that may be lying in the VVT supply gallery.

**⚠ Warning:** Wear safety goggles or other suitable eye protection when blowing out debris.

## Parts Information:

<u>DESCRIPTION</u>	<u>PART NUMBER</u>
Cylinder head - A bank (right) without valves and springs	NCA 2602AF
Cylinder head - B bank (left) without valves and springs	NCA 2603AF
Cylinder head - A bank (right) with valves and springs	NCA 2604AB
Cylinder head - B bank (left) with valves and springs	NCA 2605AB

**Note:** The cylinder heads listed above can be installed on all versions of the 1997 MY or 1998 MY V8 engine, i.e. 4.0L & 4.0L SC. **This information is not applicable to 1999 MY vehicles.**

## Warranty Information:

<u>R.O. NUMBER</u>	<u>DESCRIPTION</u>	<u>TIME ALLOWANCE</u>
12.30.12	Conversion of Cylinder head from non-VVT to VVT specification	0.10 hrs.