

DKP

DERBY

Engineering Instruction

No. MD/324
ISSUE 3

TITLE
NEW VALVE SEAT INSERTS FOR LEYLAND 680 SERIES ENGINE CYLINDER HEADS

LOCOMOTIVES, VEHICLES OR EQUIPMENT

Description
Class 101, 104, 105, 107, 108,
116, 117, 118, 119, 120,
121 and 122 DMU's.

INSTRUCTION **WORKS**

This Instruction supersedes Engineering Instruction MD/324 Issue 2 dated 17.10.79 which shall be destroyed. This Issue includes reference to the new British Leyland Part No. suffix.

The design of the inlet and exhaust valve seat inserts for the Leyland 680 Series Engines has been revised in line with developments currently being introduced by Leyland Vehicles Ltd. This action will result in the following changes in BR Catalogue/Leyland Part Numbers.

Item	Superseded Nos.		New Nos	
	BR Cat No	LV Ltd Part No	BR Cat No	LV Ltd Part No
Inlet Valve Seat	15/69626	608372	15/1598	UZJ1009/S1
Exhaust Valve Seat	15/405 ^{4/} 37	281326	15/1599	UZJ1010/S1
Cylinder head Assembly	15/1182	AAL8693	15/1600	ABL5337
	15/1119	10332514	15/1600	ABL5337

No further orders shall be placed for the superseded items existing stocks to be used until exhausted.

NOTE:-
When valve seats require renewal at engine overhaul, the new items BR Cat Nos 15/1598 and 15/1599 will fit any 680 engine cylinder head. However, BR Cat Nos 15/69626 and 15/40547 will not fit into the new cylinder head assembly stocked

This Instruction is to be implemented * - Immediately. Continued

Signed M. W. Platt Corres. Ref. TDM/177-204-110(JDB) Date 16.7.80
for C.M. & E.E. (B.R.B.) H.Q. EXT. 056-3523

FOR B.R.E.L. H.Q. USE ONLY				
B.R.E.L. Eng. Inst. No.	Type of Instruction		Estimates of unit cost change are/are not required	
	Recurring	Non-Recurring	Recurring	Non-Recurring

Redistribution Panel

To :- * Divisional/Works Manager -----
* Works/Depot -----
Please acknowledge receipt of this Engineering Instruction

Signed _____ Corres. Ref. _____ Date _____
for C.M. & E.E./M.D., B.R.E.L.

TO BE
EXTRACTED
EXT
ISSUE
3M 74/5
10.7.80

[Handwritten Signature]

Engineering Instruction

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(Continuation)

against BR Cat No 15/1600.

This work shall be carried out as and when required at Main Works.