

SERVICE BULLETIN

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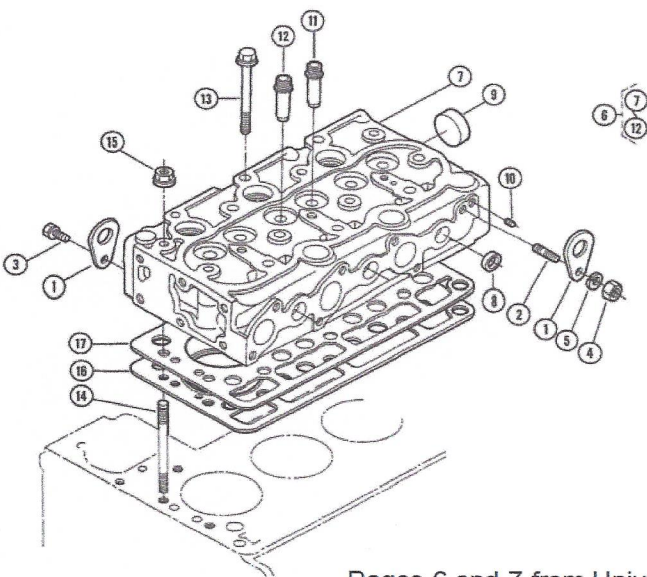
SUBJECT: Universal M25, M25XP, M25XPA and M25XPAC - Appropriate use of Cylinder Head Shims 300142 and 302185.

DETAIL: Confusion regarding when to use the cylinder head shim, reference 17 illustrated below, included in complete or upper gasket sets for the M25 and M25XP products has prompted the following explanation of when use of the shim is required.

Upon assembly of the engine by the manufacturer the cylinder head to piston top height clearance is measured to determine if a shim is needed. This results in inconsistency from one engine to the next. When replacing the cylinder head gasket on the subject models pay attention to whether a shim was originally used. Be sure to use the new shim if one originally existed in order to avoid the possibility of interference issues.

In the event you did not disassemble the engine and you do not know if a shim was used originally we recommend both the gasket and shim be installed to avoid problems. Installing a shim in either case is acceptable and preferred.

CYLINDER HEAD GROUP



Item	Part No.	Unit	Description
1	298666	2	Engine Hook
2	300135	1	Stud
3	300008	1	Bolt
4	299529	1	Nut
5	299515	2	Spring Washer
6	300136	1	Cylinder Head Assembly
6A	302183		Cylinder Head Assembly M-25XP
7			Order by Item No. 6
8	299905	5	Sealing Cap
9	299906	1	Sealing Cap
10	299356	2	Plug
11	299386	3	Inlet Valve Guide
12	299394	3	Exhaust Valve Guide
13	300137	12	Cylinder Head Bolt
14	300138	2	Cylinder Head Stud
15	300139	2	Cylinder Head Nut
16	300141	1	Cylinder Head Gasket M-25
16A	302184		Cylinder Head Gasket M-25XP
17	300142	AR	Cylinder Head Gasket Shim M-25
17A	302185		Cylinder Head Gasket Shim M-25XP

Pages 6 and 7 from Universal M25 / M25XP parts list 200142 edition 1.