

## FITTING INSTRUCTIONS FOR JGE WET LINERS

Julian Godfrey wet liners are made from steel and the bore is nikasil coated. Therefore use only tri- nitrided compression rings.

Liners are stocked in two bore sizes 90.8mm or 92mm.

Blocks are machined identical for both sizes of liners.

Use only with JGE type 10 long studs.

The Coopers rings groove is machined into the top of each liner and uses a MLS gasket to seal the waterways. Coopers rings are fitted with the swaged side facing the top of the liner.

Pistons are available for all applications to complement this conversion.

If using GPR A type oil squirt jets you may need to file these to allow the liners to fit correctly.

The liners are a slide fit into the block not a press fit. If the liner is tight, check there is no dirt or swarf in the block surface.

The liners are sealed to the block by using a small amount of blue hylomar around the liner. Make sure the block and liner are clean and free from oil and dirt. See picture 1

No 1 and 4 liners have 1 flat each and 2 and 3 have 2 flats. Position the liners so the flats face each other. See picture 2

Try not to turn the engine over until the cylinder head is fitted in position otherwise the liner seal will be broken and you will need to carry out the sealing procedure again.

If you are using a standard mechanical water pump you will need this to be machined to clear the front long stud. JGE will be happy to do this for you when your block is being machined.





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