



Andhra Pradesh State Road Transport Corporation  
**Mechanical Engineering Department**  
Office of the VC & MD, Bus Bhavan, Hyderabad – 624.

No : OP4/462(2)/2012- MED

**Circular No: 08/2012-MED, dated 17-03-2012**

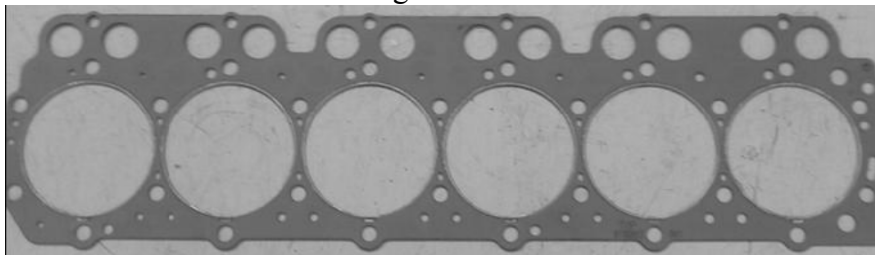
Sub : **MAINTENANCE** – Introduction of ***Multi Layer Steel (MLS)*** Cylinder Head Gasket in all ***H-Series Leyland Hino Engines*** – Reg.

M/s Ashok Leyland Ltd have informed through Service Circular No STU: SETC: CB: 7121 that they have introduced ***MULTI LAYER STEEL (MLS) Cylinder Head Gasket*** in all H' Series Hino Engines in place of the earlier 'Soft gasket'.

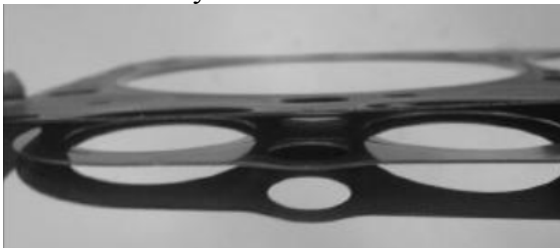
This new MLS Gasket is interchangeable with old soft gasket. MLS gasket can be identified by the following features.

- No O' rings in water holes
- Part No. X1700813 punched over top face of gasket (6 Cyl.)
- Three layers of steel

No O'Rings for water holes



Layers of Steel

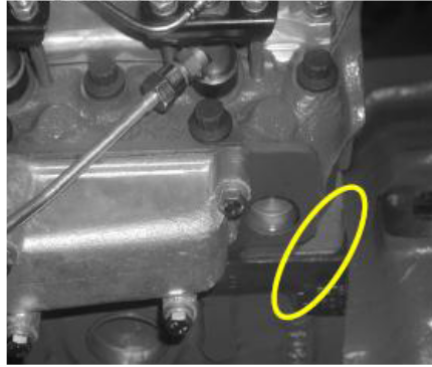


Part Number is punched



MLS gasket outer profile is different and it is possible to indentify MLS gasket without removing the Cylinder Head.

MLS gasket projection on Head



**Instruction for fitment :**

1. ***Angle torque tightening*** is to be adopted. (***70 N-m snag torque followed by 90 deg angular tightening***)
2. Tightening ***sequence is same as existing***, and is applicable to all M12 bolts in cylinder heads including that of Rocker shaft bracket mounting bolts – Total 19+7.

The Chassis Cut-off details are as follows.

Engine Type	Engine Cut off
6 Cylinder	XPH479317
6 Cylinder CNG	UPH493988

The Part Number of MLS Cylinder Head Gasket for 6 Cylinder H’series Hino engines is ***X1700813***.

Further, for all H-Series Hino 6D, 6E of norms upto BS-II and 6DTI BS-III (122 Kw) engines, M/s Ashok Leyland Ltd have introduced ***Mild Interference Fit (MIF) Liners*** in place of slip fit liners for improved durability, reduced air gaps for better cooling, avoid bore distortion/ Liner wandering, lesser oil consumption and reduced blow-by. MIF liners have an increased OD (outer diameter) and do not have flame arrestors as compared to slip fit liners. It is imperative to ***use only MLS Gaskets for engines fitted with MIF liners. Nylon bong has to be used while inserting MIF liner to have smooth fitment.*** The Part number matrix of Mild Interference Fit liners and Slip fit liners is furnished hereunder.

S. No	Slip Fit Liners (Existing)		Mild Interference Fit Liners (New)	
	Part Number	Description	Part Number	Description
1	F3434922	Cylinder Liner-W	X3404222	Cylinder Liner-W
2	F3435122	Cylinder Liner-X	X3404322	Cylinder Liner-X
3	F3435222	Cylinder Liner-Y	X3404422	Cylinder Liner-Y
4	F3435322	Cylinder Liner-Z	X3404522	Cylinder Liner-Z

The Depot Managers and Maintenance incharges are advised to make note of the above modifications and propagate the message to all maintenance staff. It is also advised to ensure minimum stock of MLS Cylinder Head Gasket at all Depots. The Controllers of Stores are advised to procure Genuine MLS Gaskets from suitable sources and supply the same to the Depots till such time the item is included in PC.



**EXECUTIVE DIRECTOR (E&IT)**

To

All Depot Managers of Leyland Area Depots for necessary action.

Copy to : EDs(Zones) for information

Copy to : CCOS, CME(C&B) & CE(IT) for information

Copy to : All Dy.CMEs for necessary action.

Copy to : All Works Managers for necessary action

Copy to : All COS' for necessary action.

Copy to : All Principals, ZSTCs and TA/HPT for information.

Copy to : All Maintenance incharges of Leyland area depots for necessary action.

Copy to : Manuals section.