

**CONTINUED FROM PRECEDING PAGE
ENGINE EXCHANGE**

1937-45 "V8" MODELS

REPLACEMENT CYLINDER BLOCKS: New 1945 type Cylinder Block (with valves .09" farther from center line of engine) is furnished for service replacement on all models. When old type cylinder heads are used with these new blocks, heads must be reworked for increased valve clearance. See "Reworking of Cylinder Head for Valve Clearance" above.

85 & 90 HP. Models

Part No.	Cyl. Assy.	Used to Replace Cyl. Block No.
41A-6010-B2	41A-6011-B2①	81A-6010-A, -B
	41A-6011-C2②	

95 & 100 HP. Models

59A-6010-C	59A-6011-A③	99A-, 19A-, 29A-6010
	59A-6011-B④	

①—Marked 41A-B2. ③—Marked 59A-A.
②—Marked 41A-C2. ④—Marked 59A-B.

CYLINDER SLEEVES

1940-42 MODELS

CYLINDER SLEEVES:—Replaceable dry type hardened cylinder sleeves used in production on some Ford engines. On V8 engines with sleeves, engine may be marked with letters 'HS' stamped on top of block beside inner front corner of left cylinder head.

Servicing:—To recondition engines with cylinder sleeves, sleeves should be replaced. Car manufacturer recommends use of KRW #6055A Sleeve Puller and Replacer (sleeves should not be pressed in with arbor press). Sleeves furnished in standard size and should be fitted with new standard size pistons only.

Model	Wall Thickness	Part No.
4 Cyl. Engine	.040"	99A-6055
6 Cyl. Engine	Cast-iron	1GA-6055-C
V8 '80' Engine	.040"	52-6055-B
V8 '90' Engine	.040"	91A-6055
V8 '90' Engine	Cast	11A-6055-B
V8 '100' Engine	.040"	99A-6055
V8 '100' Engine	.060"	09A-6055

Fitting Pistons on Sleeve Equipped Engines:—Special gauge thicknesses used (not same as for engines without sleeves). See Piston Fitting Instructions on each car model page for complete instructions.

PISTONS

1937-40 '60' MODELS

REPLACEMENT PISTONS ('60' ENGINES):—Steel-alloy pistons only used on these models.

Part No.	Piston Sizes
52-6110-A	Standard
52-6110-B	.0025" Oversize
52-6110-C	.005" Oversize
52-6110-D	.015" Oversize
52-6110-E	.030" Oversize
52-6110-F	.045" Oversize

1934-36 V8 '90' MODELS

REPLACEMENT PISTONS:—Finished flat head type (aluminum) pistons used on all 1934-35 engines and part production 1936. Dome head pistons (aluminum or steel-alloy) used on part production 1936 and all later engines. For Dome Head Piston data on 1936 and later models (and 1934-36 models when equipped with this type piston), see 1937 Replacement Piston data following.

IMPORTANT:—Flat head type pistons and Dome head pistons are not interchangeable. Dome head pistons used only with special cylinder heads.

Aluminum (flat head)—Finished pistons furnished for these 1934-36 engines in following sizes:
Flat Head Pistons (1934-36)

Part No.	Piston Sizes
40-6110-A2	Standard
40-6110-B2	.0025" Oversize
40-6110-C2	.005" Oversize
40-6110-D2	.015" Oversize
40-6110-E2	.030" Oversize
40-6110-F2	.045" Oversize
40-6110-G2	.060" Oversize

1937-42 MODELS

REPLACEMENT PISTONS:—Both Steel and Aluminum pistons are furnished for service as follows:

V8 Pass. Car & Truck—Aluminum (3 Ring)

'90' Eng. Part No.	'100' Eng. Part No.	Size
11A-6110-A	09A-6110-A	Standard
11A-6110-B	09A-6110-B	.0025" Oversize
11A-6110-C	09A-6110-C	.005" Oversize
11A-6110-D	09A-6110-D	.015" Oversize
11A-6110-H	09A-6110-H	.020" Oversize
11A-6110-E	09A-6110-E	.030" Oversize
11A-6110-J	09A-6110-J	.040" Oversize
11A-6110-F	09A-6110-F	.045" Oversize
11A-6110-G	09A-6110-G	.060" Oversize

V8 Pass. Car & Truck—Steel (3 & 4 Ring)

'90' Eng. Part No.	'100' Eng. Part No.	3 Ring	4 Ring	Size
91A-6110-A	29A-6110-A			Standard
91A-6110-B	29A-6110-B			.0025" Oversize
	29A-6110-C			.005" Oversize
	29A-6110-D			.015" Oversize
	29A-6110-G			.020" Oversize
	29A-6110-E			.030" Oversize
	29A-6110-H			.040" Oversize
	29A-6110-F			.045" Oversize

①—Used with new 29A-6303-A Crankshaft.

V8 Truck & Bus—Aluminum (4 Ring)

'90' Eng. Part No.	'100' Eng. Part No.	Bus Eng. Part No.	Size
01T-6110-A	09T-6110-A	29B-6110-A	Std.
01T-6110-B	09T-6110-B	29B-6110-B	.0025" OS
01T-6110-C	09T-6110-C	29B-6110-C	.005" OS
01T-6110-D	09T-6110-D	29B-6110-D	.015" OS
01T-6110-H	09T-6110-H	29B-6110-H	.020" OS
01T-6110-E	09T-6110-E	29B-6110-E	.030" OS
01T-6110-J	09T-6110-J	29B-6110-J	.040" OS
01T-6110-F	09T-6110-F	29B-6110-F	.045" OS
01T-6110-G	09T-6110-G	29B-6110-G	.060" OS

4 Cylinder—Steel Pistons (3 Ring)

Part No.	Size
99A-6110-A or 2N-6110-A①	Standard
99A-6110B	.0025" Oversize

6 Cylinder Pass. Cars & Trucks

Steel — Part No.	Aluminum	3 Ring	4 Ring	Size
1GA-6110-B	1GA-6110-C	2GT-6110-A		Std.
1GA-6110-J	1GA-6110-D	2GT-6110-B		.0025" OS
1GA-6110-K	1GA-6110-E	2GT-6110-C		.005" OS
1GA-6110-L	1GA-6110-F	2GT-6110-D		.015" OS
		2GT-6110-G		.020" OS
1GA-6110-M	1GA-6110-G	2GT-6110-E		.030" OS
		2GT-6110-H		.040" OS
1GA-6110-N	1GA-6110-H	2GT-6110-F		.045" OS

Piston Fitting Note:—Steel and aluminum pistons not fitted with same clearance (different feelers must be used) and pistons also fitted differently when sleeves not used. See Piston fitting instructions on each car model page for instructions.