

**Engine Lifting & Mounting Brackets –
Special Tools 303-536 & 303-537****MODEL**1997 MY-ON XK8 Range
1998 MY-ON V8 XJ Series**VIN**001001-ON
812256-ON**Issue:**

This bulletin describes the use of Engine Rear Lifting Brackets, (right and left), 303-536 and Engine Stand Mounting Brackets, (right and left), 303-537 (Illustration 1).

Action:

- Install the Engine Rear Lifting Brackets, 303-536, at the rear of the cylinder heads, so the projecting tab of the bracket is positioned to fit against the intake side of the cylinder head.

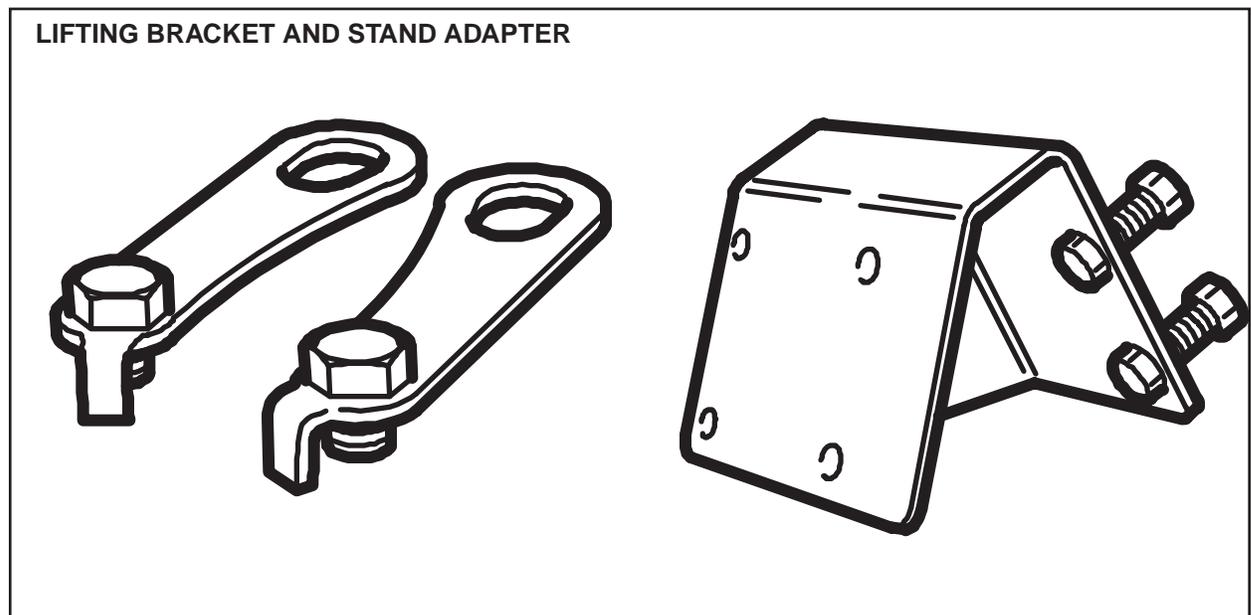
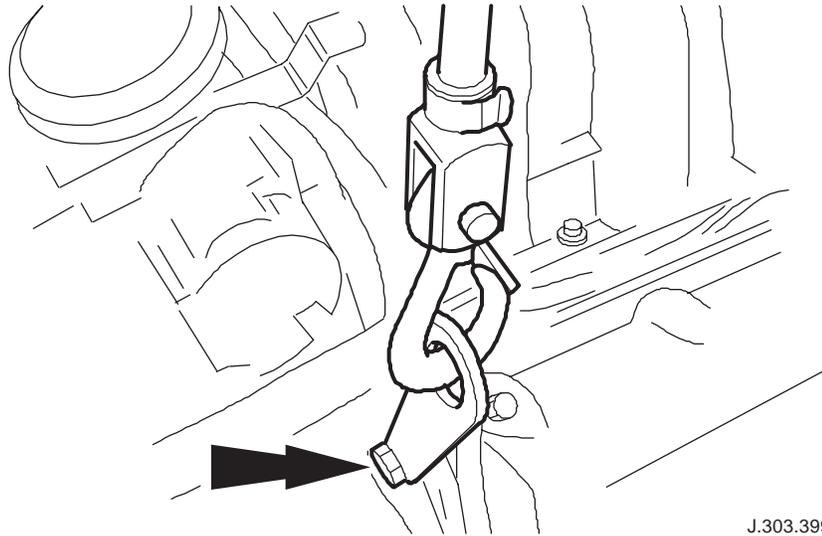


ILLUSTRATION 1

LIFTING BRACKET INSTALLED ON ENGINE



J.303.399

ILLUSTRATION 2

- The retaining bolt, indicated by the arrow in Illustration 2, is screwed into the tapped drilling at the rear of the cylinder head.
- If the engine has been in use for some time the tapped drilling will have to be cleaned out to ensure that the thread is unobstructed.

Note: The lifting bracket retaining bolts are captive in the brackets and should **NEVER** be removed from the tool. Any replacement retaining bolts must be of the same length and thread as the original bolts because the tapped drilling, into which the retaining bolt is screwed, connects with an oil gallery and has an AVDEL plug to seal it. If a bolt, which is longer than the original retaining bolt is fitted, the plug may be disturbed when the bolt is tightened, possibly causing a leak.

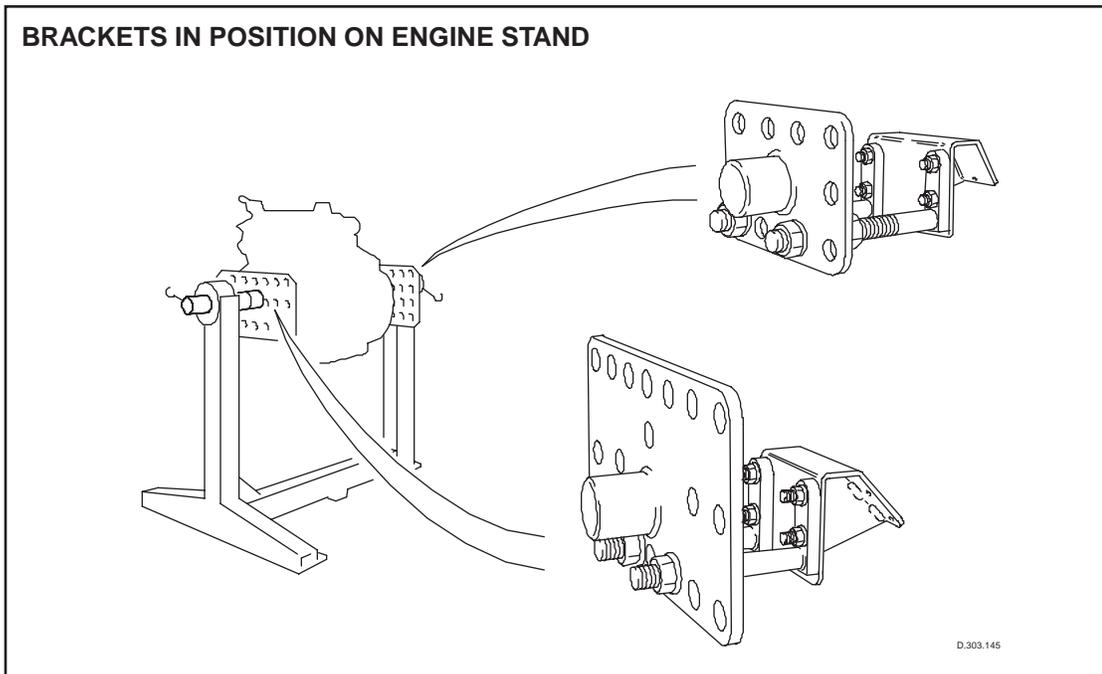


ILLUSTRATION 3

- After the lifting brackets are in position, the engine can be supported by the Engine Support Beam, 303-021.
- The Engine Stand Mounting Brackets are fitted to the engine mounting positions on either side of the cylinder block and are in turn fastened to the universal mounting plates on the Engine Stand, 303-011 or equivalent engine stand.

Note: The engine mounts are not equally positioned so the brackets must be fitted to the mounting plates to suit, as shown in Illustration 3.