

Repairing an Onan 2-Piece Intake Manifold

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I have a 1984 Case 446 with an Onan B43M engine in it that was on it's way out. I replaced it with a rebuilt long block and for the life of me could not get it to run right. At high RPM or under load the governor would hunt. I had fuel, spark and good compression. After searching the internet, I found that these engines are notorious for leaking at the seam of the 2-piece intake manifold. I sprayed some brake cleaner at the seam at high RPM and it immediately sped up and smoothed out for a few seconds. Viola! I think I found the problem, now to fix it ...

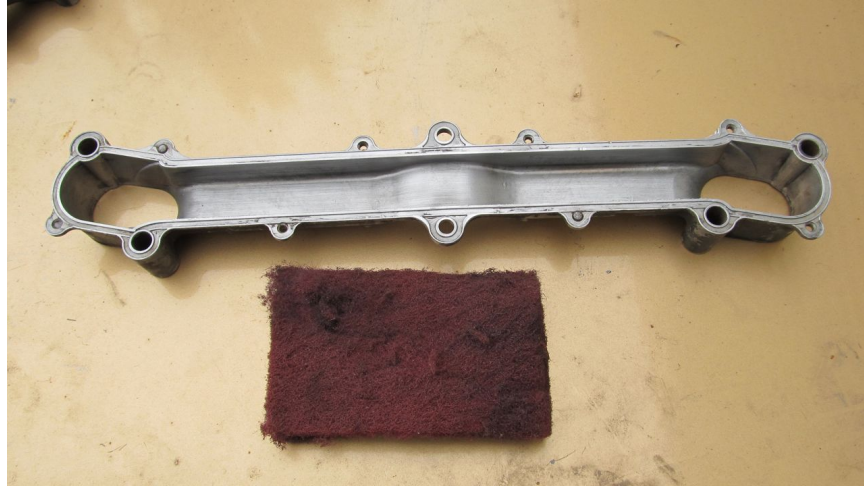
1. Remove the intake manifold from the tractor.
2. Remove the carburetor from the intake manifold.
3. Using a Dremel, grind off the rivets holding the halves together.



4. Carefully pry the two halves apart with a small thin screwdriver.
5. Use a small screwdriver and clean the old gasket material out of the groove.



6. Use a Scotch Brite pad to clean the gasket mating surface.

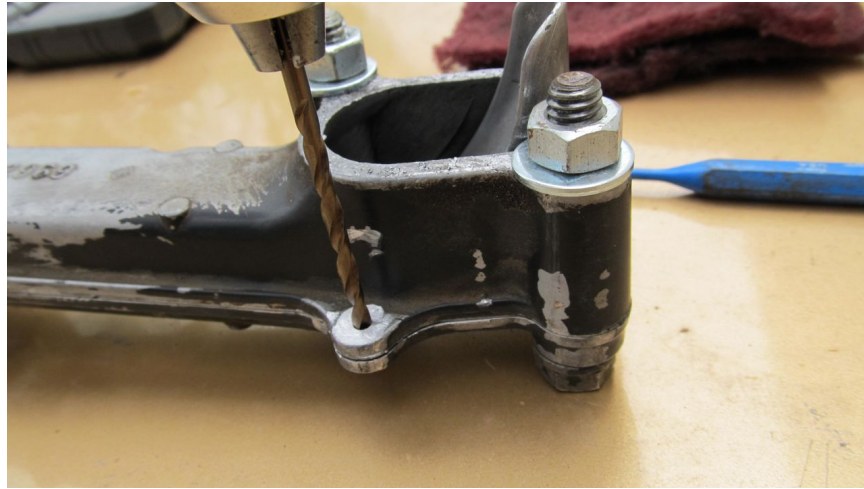


7. Using a small chisel, knock off the rivet stubs from the top half.



8. Bolt the two halves together using the mounting screws.

9. Drill out the upper half rivet boss with 1/8" drill using the lower hole as a guide.



10. Using Hondabond HT, apply a thin bead of sealant to the mating groove.



11. Rivet the two halves together using 1/8" rivets.



12. After allowing the sealant to dry, clean-up the edges, clean the intake and apply a fresh coat of paint.



13. Re-install carburetor to intake manifold.
14. Re-install manifold to engine and torque mounting bolts to 6-10 ft-lbs.

