

# New 4 Cylinder Engine Bare Block

(Part#: 641145)

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We are not talking about a rebuilt engine here, we are talking about a brand new fresh out of the foundry L-134 engine block. Yes, really, they now exist! As anyone that has experienced the frustrations of looking for a useable block this is big!

Here is a short background on how these 4-134 L engine bare blocks came to be...

A Willys enthusiast with extensive manufacturing experience and began wondering about the availability of the flathead engines that drove the first Jeeps. Noting the lack of replacement engines, and the passion in the community for keeping these old flat fenders alive, he used his experience and resources to set about with the goal of making new L-134 blocks again, looking for a foundry that had the capability to produce this engine in the quality that Willys Jeep enthusiasts need and expect.

Like any good adventure, he was told that his quest was impossible (reminds me of many of our inventors back in the early 20th century!). No foundry could make the quality engine needed in low numbers. Factories said the same, they

couldn't do it. However, he worked on and convinced a foundry they could do what he wanted and then set about the backwards engineering of an L-134 from a 1952 CJ-3A.

The block was reverse engineered using a Coordinate Measuring Machine and Solid Works programming. Using old blocks and sawing them in produced lots of data.

The new blocks are finished machined and ready for assembly. Hardened intake and exhaust seats are already installed as are the freeze plugs and cam plugs. The blocks are coated and wrapped in plastic for delivery.

Each block is individually serialized with the number stamped into the machined deck surface in front of the block. Machined specs are: Cylinder bore: 3.1255 +/- 0.0005 Valve guide bore diameter: 0.374 +/- 0.0005 Valve seat surface width: 0.09375 to .125 +/- 0.0005 Tappet bore diameter: 0.626 +/- 0.0005"

All of the machining operations are performed on highly accurate CNC machines. Notice the cast block number preceded by JF to indicate what the foundry is.

These blocks should perform far better than a rebuilt block, as they start at standard dimensions.

Installed in a CJ-5 test bed, the reports are clear that the new block works as good as, if not better than the original. Further testing will include dyno work as well.

## Questions about this Engine Block?

Call us Toll Free at:

**1-888-648-4923**

(Mon-Fri, 9AM-5PM, EST)

or email Mike Meditz at:

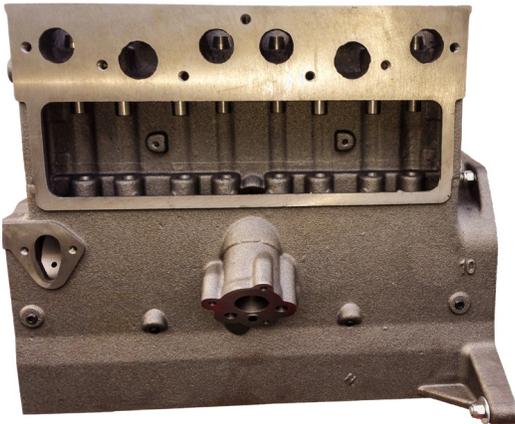
**mike@kaiserwillys.com**

## Warranty

Allied Powertrain warrants this product for one year from the date of purchase. If the product is used for racing or competition, this warranty is limited to manufacturer defects only; wear and breakage are not covered under any circumstances.

If the product shows, in our opinion, evidence of being used or installed contrary to the instructions and/or subjected to improper handling, packaging, or shipping by the customer, it will not be covered by our limited warranty. The liability to Allied Powertrain for losses or damages arising out of any cause whatsoever is limited to the full refund of the purchase price or, at our option, repair or replacement of the product(s).

Allied Powertrain shall not be liable for any consequential or incidental damages. Some states do not allow the exclusion or limitation of consequential or incidental damages, so the above limitation or exclusion may not apply to you.



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