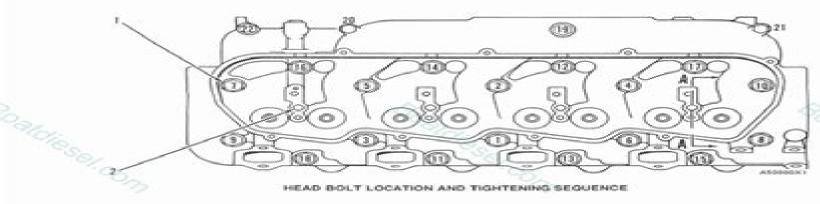
Godfoling.

CYLINDER HEAD



HEAD BOLT LOCATION AND TIGHTENING SEQUENCE

(11)	Plut emgime oil	ion bolt	Printered St	and	tightion.	toolts.	according	tion	Dhee
	procedure the	d Northchart							

number sequence to	60 = 10 lb.ft. (80 = 14 N·m)
Step 2. Tighten botts 1 thru 18 in number sequence to	110 = 5 lb.h. (150 = 7 N·m)
Step 3. Again tighten bolts 1 thru !	18 in (C)

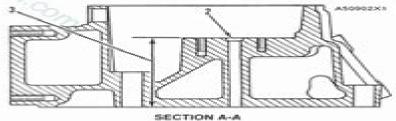
Step 4. Tighten bolts 19 thru 22 in

(2) Holes for fuel injection nozzles.

Thickness of cylinder head [measure through the fuel injection nozzle holes at each end of the cylinder head].

New	3.785 = .006	im.	(96.1	4	+ 0.	15	mm)-
Minimum permissible t	hickness	- 3	774 b	m.	(96)	86	mm).

HEAD BOLT LOCATION CHART				iiiii.	
	Part No.		Bolt Length "L"		
Distance.		Location (Bolt No.)	in.	more	
1/2"	6F5282	5.2.4.10	5.25	133.4	
	28/2006	7.9.3.1.6.8	4.75	120.6	
	L1029	16,14,12,17	3.00	76.2	
	28947	18,11,13,15	2.25	57.2	
3//8"	589603	19.20.21	5.00	127.0	
	\$1571	22	1.75	44.5	



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Chao Zhang

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