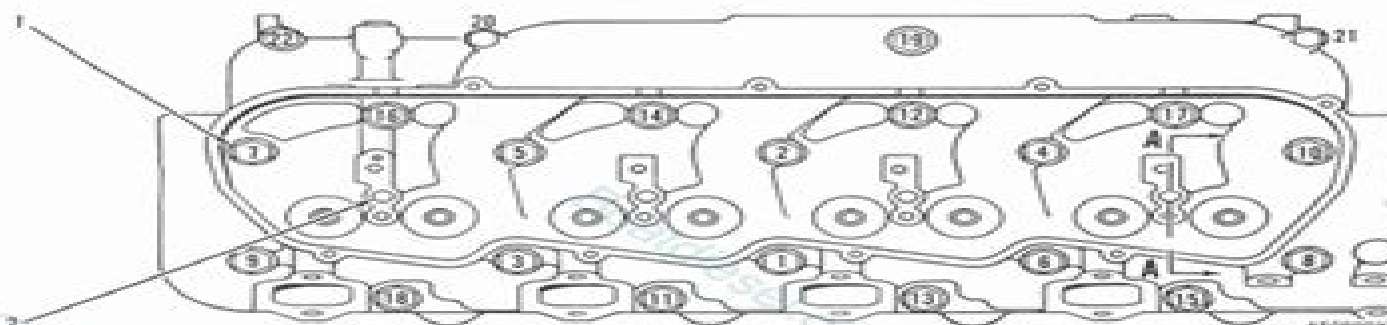


CYLINDER HEAD



HEAD BOLT LOCATION AND TIGHTENING SEQUENCE

- (1) Put engine oil on bolt threads and tighten bolts according to the procedure that follows:

Step 1. Tighten bolts 1 thru 18 in number sequence to _____ 60 = 10 lb.ft. (80 = 14 N-m)

Step 2. Tighten bolts 1 thru 18 in number sequence to _____ 110 = 5 lb.ft. (150 = 7 N-m)

Step 3. Again tighten bolts 1 thru 18 in number sequence to _____ 110 = 5 lb.ft. (150 = 7 N-m)

Step 4. Tighten bolts 19 thru 22 in number sequence to _____ 32 = 5 lb.ft. (43 = 7 N-m)

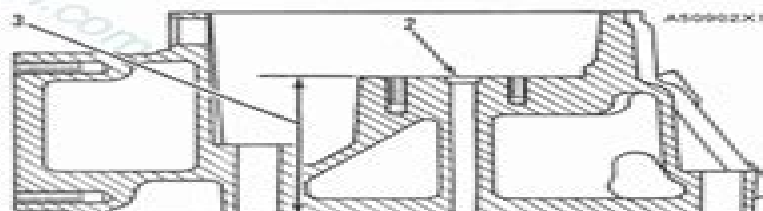
- (2) Holes for fuel injection nozzles.

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

New _____ 3.785 = .006 in. (95.14 = 0.15 mm)

Minimum permissible thickness _____ 3.774 in. (95.86 mm)

HEAD BOLT LOCATION CHART			Bolt Length "L"	
Dia.	Part No.	Location (Bolt No.)	in.	mm
1/2"	6F5262	5,2,4,10	5.25	133.4
	2B2006	7,9,3,1,6,8	4.75	120.6
	L1329	16,14,12,17	3.00	76.2
	2B947	18,11,13,15	2.25	57.2
3/8"	5B9603	19,20,21	5.00	127.0
	S1571	22	1.75	44.5



SECTION A-A

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