CAUTION

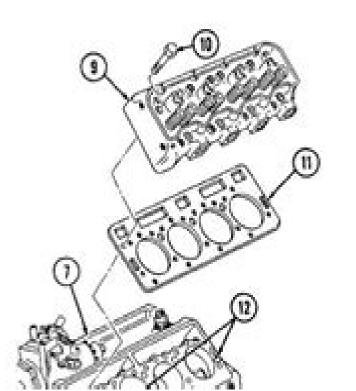
Failure to tighten cylinder head capscrews in proper sequence may result in leaks or damage to cylinder head.

- Install cylinder head (9) on cylinder block (7) with seventeen capscrews (10). Tighten capscrews (10) to 20 lb-ft (27 N*m), following torque sequence shown.
- 4. Tighten seventeen capscrews (10) to 50 lb-ft (68 N·m), following torque sequence shown.

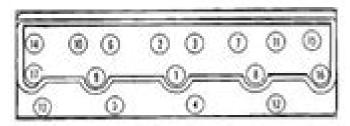
NOTE

Mark capscrews after torque turn to prevent retightening.

- Tighten seventeen capscrews (10) an additional 90°, following torque sequence shown and mark capscrews (10).
- 6. Repeat steps 1 through 5 for opposite side.



TOROUE SECUENCE



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