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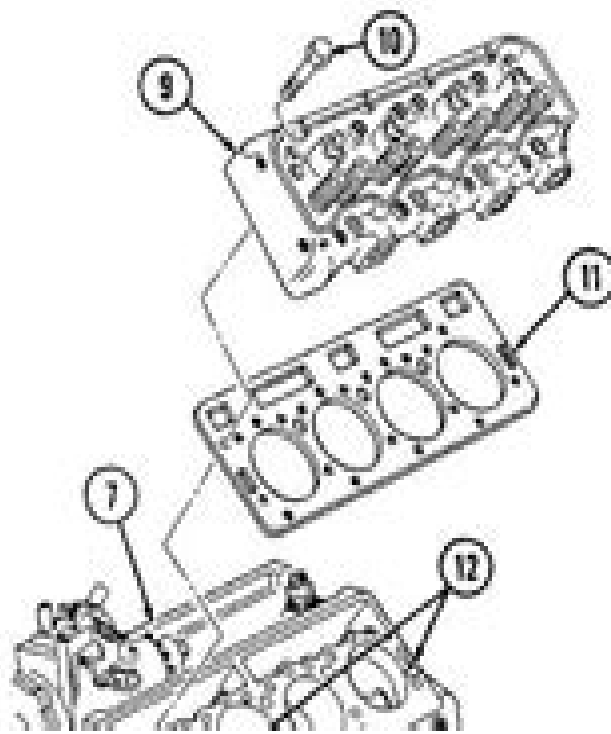
Failure to tighten cylinder head capscrews in proper sequence may result in leaks or damage to cylinder head.

3. 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.

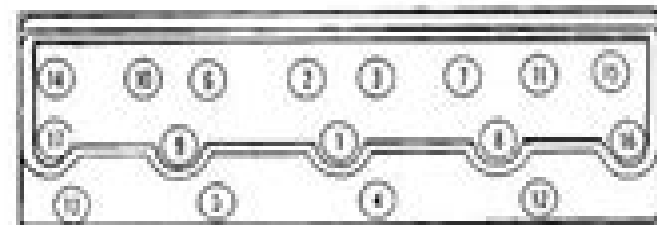
NOTE

Mark capscrews after torque turn to prevent retightening.

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



TORQUE SEQUENCE



Deutz Engine Head Bolt Torque Specs

Rachel Sandford



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Materials Handling News ,1984 **Workshop Manual for Air-cooled Deutz Diesel Engines , Torque Tables**
Fel-Pro Incorporated,1980 Workshop Manual for Air-cooled Deutz Diesel Engines, Types F/A 6-12 L 714 ,1962
Workshop Manual for Deutz Diesel Engines ,1981 **Deutz Instruction Manual F3-6L 912** Klöckner-Humboldt-Deutz
AG.,1975* Workshop Manual for Air-cooled Deutz Diesel Engines ,19??

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