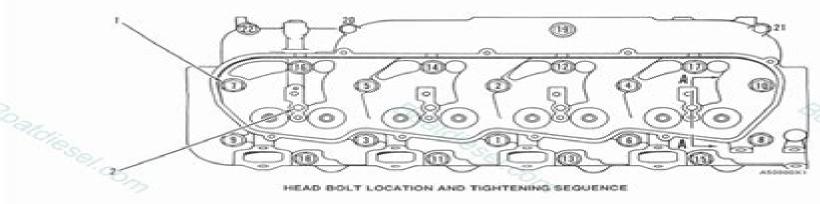
Godfoling.

CYLINDER HEAD



HEAD BOLT LOCATION AND TIGHTENING SEQUENCE

653	Plut emgine oil	lion bott	Threads	and	tightion.	toolts.	according	No.	Dhee
	procedure the	of Politicary	e contract						

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

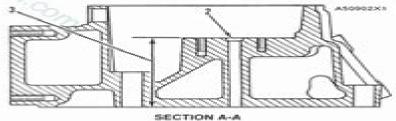
Step 4. Tighten bolts 19 thru 22 in

(2) Holes for fuel injection nozzles.

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

Napor	3.785 = .006	im.	496.14	-	0.15 mm)
Minimum permissible 5	nickmess	- 3	774 in	. 79	6.86 mm)

HEAD BOLT LOCATION CHART				iiiii.
Dia.	Part No.		Bolt Length "L"	
		Location (Bolt No.)	in.	more
	6F5282	5.2.4.10	5.25	133.4
	28/2006	7.9.3.1.6.8	4.75	120.6
1/2	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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