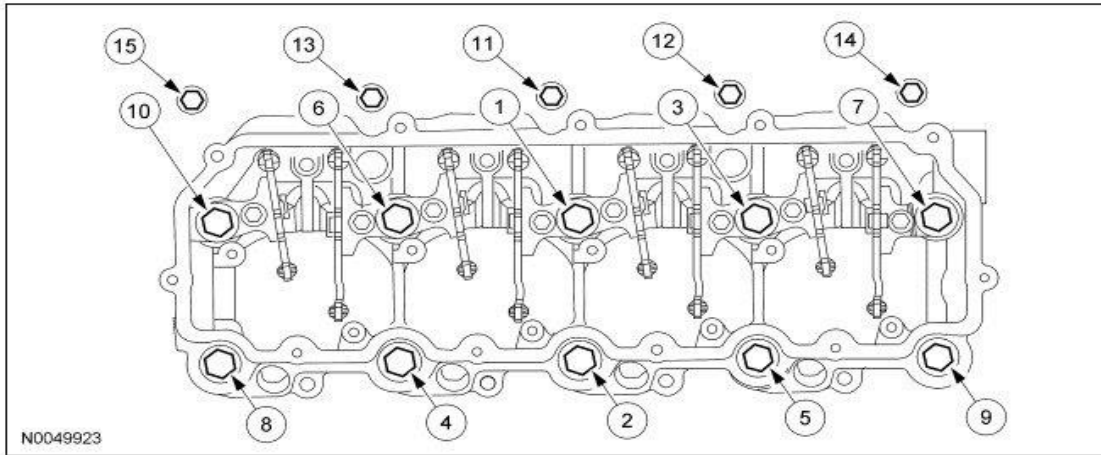
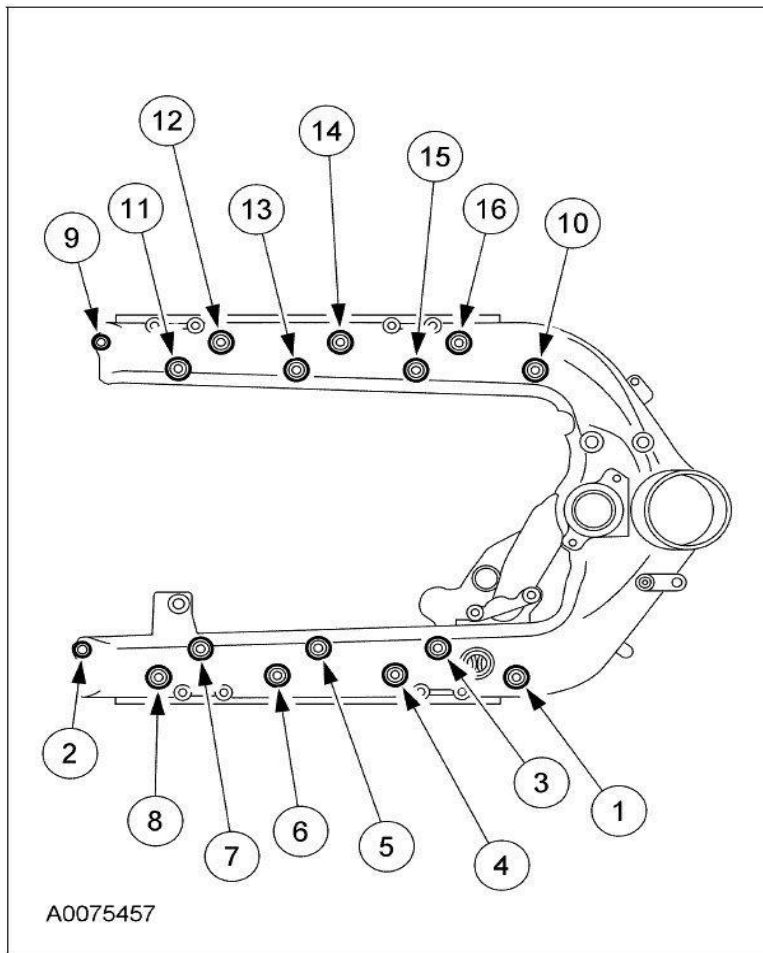


Tighten the head bolts in the following sequence.

1. Tighten bolts 1 through 10 to 88 Nm (65 lb-ft).
2. Tighten bolts 1 through 10 to 115 Nm (85 lb-ft).
3. Tighten bolts in sequence 1 through 10, clockwise 90 degrees.
4. Tighten bolts in sequence 1 through 10, a second time, clockwise 90 degrees.
5. Tighten bolts in sequence 1 through 10, a third time, clockwise 90 degrees.
6. Tighten bolts 11 through 15 to 24 Nm (18 lb-ft).
7. Tighten bolts 11 through 15 to 31 Nm (23 lb-ft).

FACTORY REPLACEMENT
SPECS





Tighten all Bolts in Sequence to

8 lb - ft

