



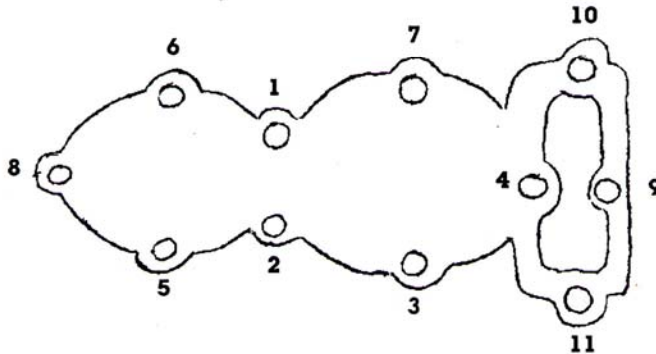
Data Sheet No. 14

Subject: Fitting Cylinder Heads

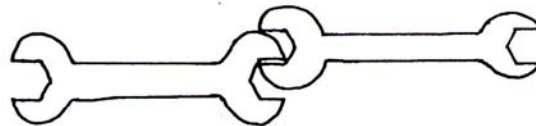
The Sunbeam head has a tendency to blow if insufficiently tightened.

When refitting a cylinder-head:

1. **NEW** or **GOOD** head nuts – with any doubtful ones on the **outsides**.
2. Must be **NEW WASHERS** (special very thick flat ones).
3. **NEW** gasket every time!
4. Hylomar cement (or your preference) both sides with joint surfaces – cleaned off and wiped clean with petrol.
5. All head studs good – none shaky and *none* stripped or stretched.
6. Tighten nuts in **correct sequence**.
7. Use a *long, slim good quality* spanner.



8. Final tighten using another spanner on the end.



9. Run until hot – then let go **STONE COLD** preferably overnight, and retighten **every** nut (this means removing chain inspection plate – and loosening front mounting nut to give spanner room etc.).
10. **REPEAT** Step 9 **after 100-200 miles**.