

WARNING: THE OUTSIDE EDGE OF THE HEAD GASKET IS VERY SHARP. WHEN HANDLING THE NEW HEAD GASKET, USE CARE NOT TO INJURE YOURSELF.

1. Install a new gasket with the part number side up, and locate the gasket over the dowel sleeves.
2. Using an engine lifting crane, lower the cylinder head onto the engine.
3. Lightly lubricate head bolts under bolt head and on threads, with engine oil and install. Using the sequence shown, tighten bolts in the following steps:
 - a. Torque bolts to 70 N·m (52 ft. lbs.).
 - b. Back off 360 degrees in sequence.
 - c. Torque bolts to 105 N·m (77 ft. lbs.).
 - d. Re-check all bolts to 105 N·m (77 ft. lbs.).
 - e. Tighten all bolts an additional ¼ turn (90°).

