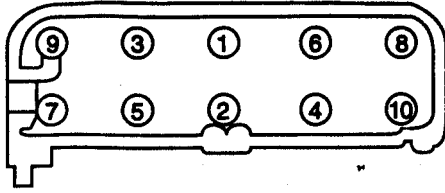


HEAD BOLTS

IF BOLTS have a sealant pre-applied to the threads and underside of bolt head, simply install the bolts. **ADDITIONAL SEALANT/OIL IS NOT REQUIRED.**



IMPORTANT: Consult the latest OEM torque specifications as changes may have taken place since this printing.

TORQUE SPECIFICATIONS: Follow sequence shown in illustration, torque **all bolts** in the following steps:

Torque all bolts to 22 ft. lbs.
Torque all bolts to 59 ft lbs.
Now loosen all bolts.
Then torque all bolts to 18-25 ft. lbs.
Finally, turn all bolts to 80-85°.

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FEL-PRO INSTALLATION TIPS

HEAD GASKET

CLEAN MATING SURFACES of all foreign materials. You may wish to use a degreaser.

CHECK HEAD AND BLOCK for flatness. Make certain combined flatness is within .0015".

CLEAR ALL THREADED HOLES in the block by using a bottoming tap. Tap below the maximum bolt penetration to prevent bottoming.

CLEAN ALL BOLTS THREADS by using a wire brush. Lubricate the underside of **every** bolt head with oil. Determine which bolts extend into the coolant passages. Those **entering** the coolant passages require a pliable non-hardening sealer on the threads. Those bolts **not entering** the coolant passages require oil on the threads.

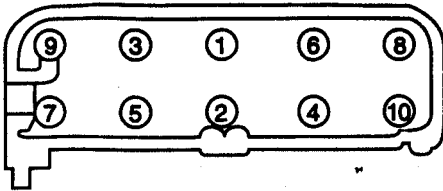
ATTACH AND ALIGN GASKET(S) FOLLOWING ANY DIRECTIONAL MARKINGS SHOWN ON THE GASKET. If no markings exist, simply install the gasket by matching the gasket to engine deck surface.

FIBER FACED GASKET(S) are to be installed dry. **METAL FACED GASKET(S)** require a thin even coat of sealer, to be applied to the metal side(s) of the gasket.

- Continued -

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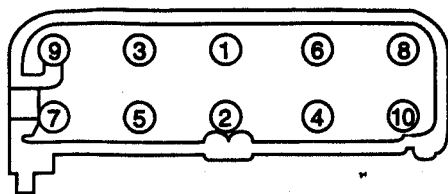
- Continued -

Cut to 4 X 5.25

Cut to 4 X 5.25

HEAD BOLTS

IF BOLTS have a sealant pre-applied to the threads and under-side of bolt head, simply install the bolts. **ADDITIONAL SEALANT/OIL IS NOT REQUIRED.**



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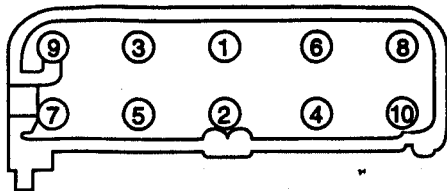
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- Continued -



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