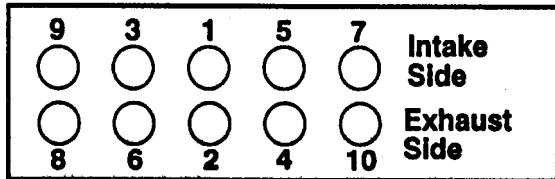


**CYLINDER HEAD BOLTS:** Install NEW cylinder head bolts every time the cylinder head is removed and replaced.

**IMPORTANT:** DO NOT reuse cylinder head bolts under any circumstances.

Previously installed bolts have been "STRETCHED" beyond their reusable limit and will no longer provide the required clamping force.

If flat washers are present, discard them and install integrated washer style head bolts. **DO NOT INSTALL ANY WASHERS.**



**TORQUE SPECIFICATIONS:** Following sequence shown in illustration, torque the NEW bolts in the following steps:  
Torque all bolts to 44 ft. lbs

Following the same torquing sequence, turn bolts 90° (1/4 turn).

To complete the tightening procedure the bolts must be turned in sequence again, 90° (1/4 turn).

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

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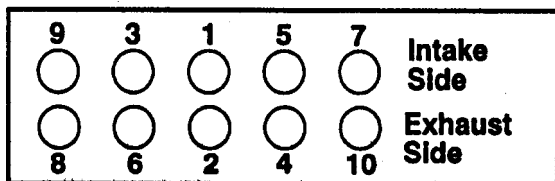
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**FIT**

## FEL-PRO INSTALLATION TIPS

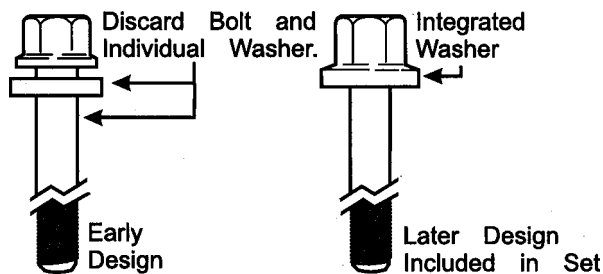
### HEAD GASKET

**CLEAN MATING SURFACES** of all foreign materials.

**CHECK HEAD AND BLOCK** for flatness. Refer to OEM manual to determine flatness tolerances and resurfacing limitations.

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

**CLEAN ALL BOLT 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 bolt not entering the coolant passages require oil on the threads.



CUT TO 4 X 5.25

**FIT**

## FEL-PRO INSTALLATION TIPS

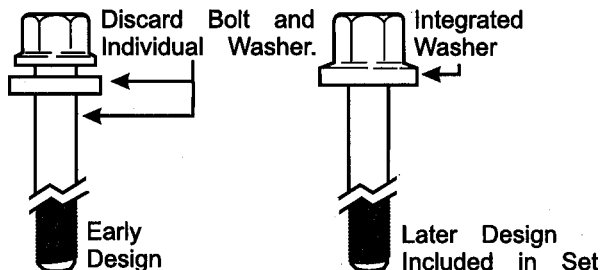
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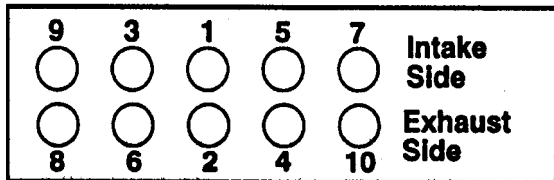
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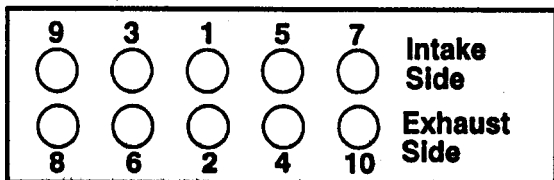
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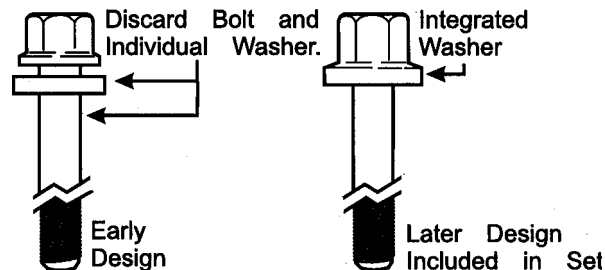
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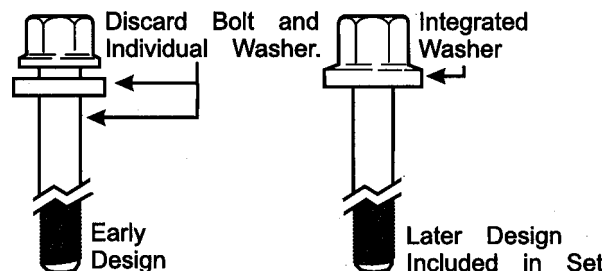
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