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1) Lower Head Carefully Onto Gasket. Use Guide Pins (3070) To Keep Gasket And Head Aligned With Block. Tighten Cylinder Head Bolts In Sequence In 3 Stages. See Fig. 2. Tighten 12-point Bolts To 29 Ft. Lbs. (40 N.m) In First Step. 2) Tighten To 43 Ft. Lbs. (60 N.m) In Second Step. On Third Step, Turn Bolt 18 Jul 2th, 2024.

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