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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 1th, 2024

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