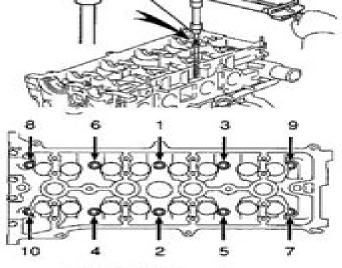


Install and uniformly tighten the 20 bearing cap bolts in several passes, in the sequence shown. Torque:

29.5 Nm (300 kgf cm, 22 ft. lbs.) for No. 1 and No. 2

9 Nm (90 kof-cm, 80 inch lbr.) for others

10 mm Bi-hexagon Wrench



Cylinder Head Belt Torque Sequence

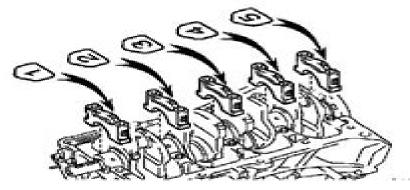
Orlinder Head

Cylinder Head Tongue.

Step 1 79 Nm (58 ft.lb)
Step 2 90 degrees

If any cylinder head bolt is broken or deformed, replace it. Apply a light cost of engine oil on the threads and under the heads of the cylinder head bolts.

If any one of the cylinder head bolts does not meet the torque specification, replace the cylinder head bolt.



Main Bearing Cap Bolt Torque Sequence

- Apply a light coat of engine oil on the threads and under the main bearing cap bolts.
- Install and uniformly tighten the 10 main bearing cap bolts in several passes, in the sequence shown.
 Torque: 20 Nm (205 kgf-cm, 15 ft. lbs.)
- 3 Retigites the 10 main bearing cap bobs in several passes, in the sequence shown. Torque: 40 Nm. (410 kgf-cm, 30 ft. lbs.) If any one of the main bearing cap bolts does not meet the torque specification, replace the main bearing cap bolt.
- 4 Mark the frost of the main bearing cap bolt with point.
- Retighten the main bearing cap bolts by 90° in the numerical order shown.
- 6 Check that the pointed mark is now at a 90° angle to the front.
- c. Check that the crank shaft turns smoothly.

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