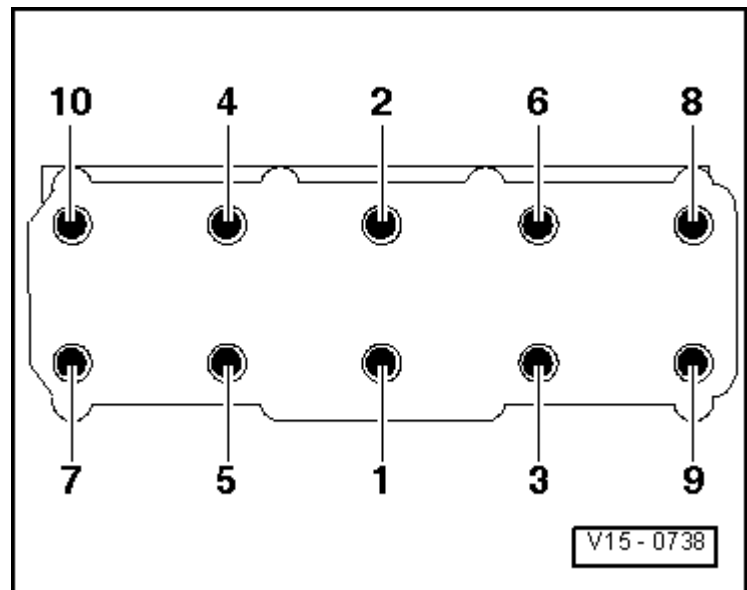


## Installing



### Note

- ♦ *Do not remove new cylinder head gasket from its packing until immediately before installing.*
- ♦ *Handle new gasket with extreme care. Damage will cause leakage.*
- Place clean cloths in cylinders so that no dirt or emery cloth particles can get in between cylinder wall and piston.
- Now carefully clean sealing surfaces of cylinder head and cylinder block. Ensure thereby that surfaces are not scored or scratched (if abrasive paper is used, grade must not be less than 100).
- Carefully remove metal particles, emery residue and cloths.
- Set No. 1 cylinder piston to top dead centre and then turn crankshaft back slightly.
- Camshaft pulleys locked into camshaft housing fitting holes with camshaft lock -T10016- and secured against turning.
- Fit new cylinder head gasket. Lettering (Part No.) must be readable.
- Fit cylinder head. When doing this, observe centring pins in cylinder block.
- Insert new cylinder head bolts and tighten hand-tight.
- Tighten cylinder head bolts in tightening sequence as follows:
- Tighten all bolts to 30 Nm.
- Then tighten all bolts  $\frac{1}{4}$  turn ( $90^\circ$ ) further using a rigid wrench.
- Then tighten all bolts again  $\frac{1}{4}$  turn ( $90^\circ$ ) further.
- Install support elements in cylinder head and fit respective roller rocker finger onto respective valve stem end and support element.
- Install exhaust manifold.
- Install front exhaust pipe to exhaust manifold.



Torque settings for exhaust pipe and exhaust manifold → [Chapter](#)

- Install camshaft housing → [Chapter](#).

Further assembly is basically the reverse of the dismantling procedure.

Filling with new coolant → [Chapter](#).