

3. After cleaning the threads, remove any debris from the head bolt holes on the cylinder block with a vacuum hose.
4. Visually inspect the head bolt holes on the cylinder block for thread damage.
5. If a damaged head bolt thread is observed, repair the damaged head bolt thread with a Heli-Coil thread repair kit.
6. Inspect the cylinder head and the cylinder block for flatness. Refer to Guideline for Reusable Parts and Salvage Operations, SEBF8162, "Procedure to Measure and Salvage Cylinder Head Assemblies and Related Components".
7. Install the new O-ring seals and the new cylinder head gasket on the cylinder block.

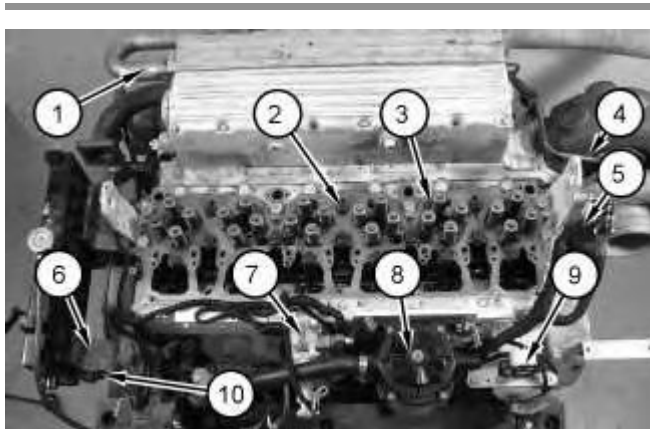


Illustration 1

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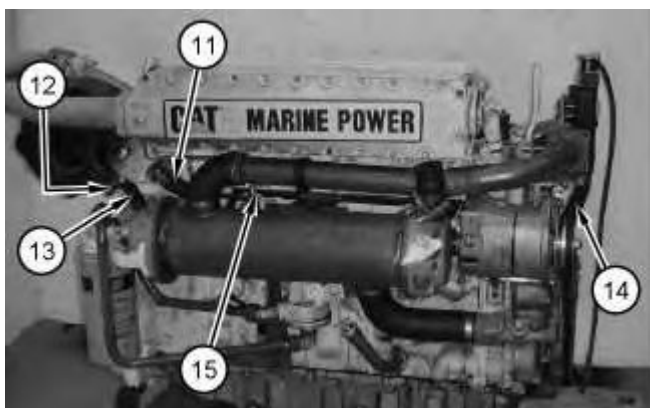


Illustration 2

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8. Attach a suitable lifting device to cylinder head (3). The weight of the cylinder head is approximately 295 kg (650 lb). Position cylinder head (3) on the cylinder block.
9. Install new bolts (2) .