


Cylinder head bolt torque specifications manual

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Next

2C-2		FT-LBS (N·M)
Torque specifications		
Camshaft sprocket bolts		216 in-lbs
Camshaft retainer plate bolts		105 in-lbs
Crankshaft balancer bolts		63
Crankshaft balancer hub bolt		74
Cylinder head bolts - in sequence (see illustration 12.17)		65
1995 and earlier models		
1996 on		22 in-lbs
Step 1, all		Turn an additional 1/4 turn
Step 2, short bolts		Turn an additional 1/4 turn
Step 2, medium and long bolts		30
Exhaust manifold bolts		74
Flywheel/driveplate		
Intake manifold bolts		
Step 1		71 in-lbs
Step 2		35
Oil deflector nut		30
Oil pan-to-crankcase		
Corner bolt/nut		
Side-rail bolts		180 in-lbs

Step	Sequence	Diagram
1	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13	(Diagram showing bolt locations)
2	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13	(Diagram showing bolt locations)

Step	Sequence	Diagram
1	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13	(Diagram showing bolt locations)
2	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13	(Diagram showing bolt locations)

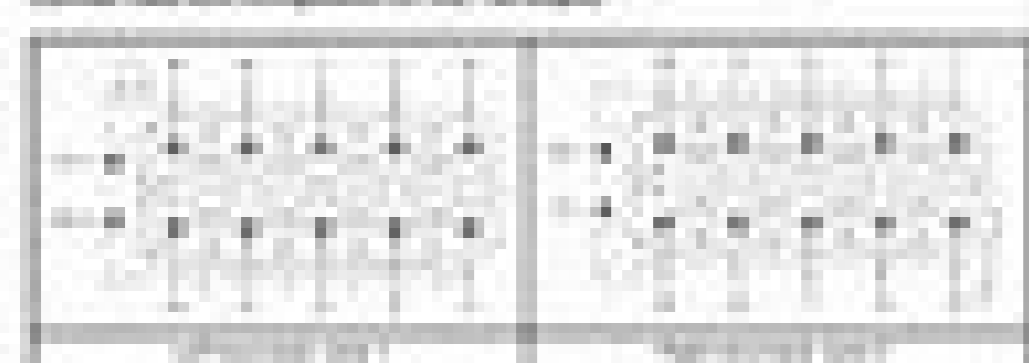
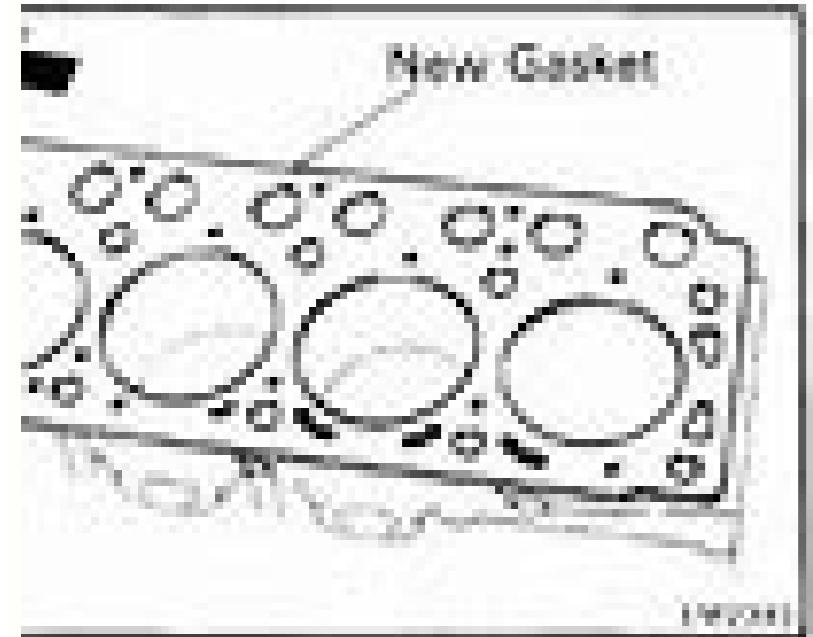


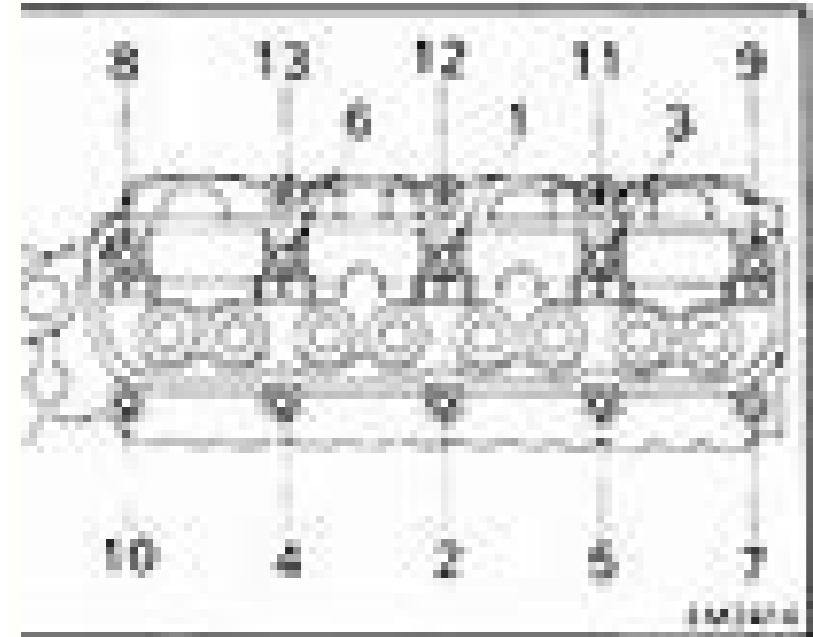
Illustration 12.17 - Cylinder head bolt torque specifications manual



INSTALLATION OF CYLINDER HEAD
(See page EM-9)

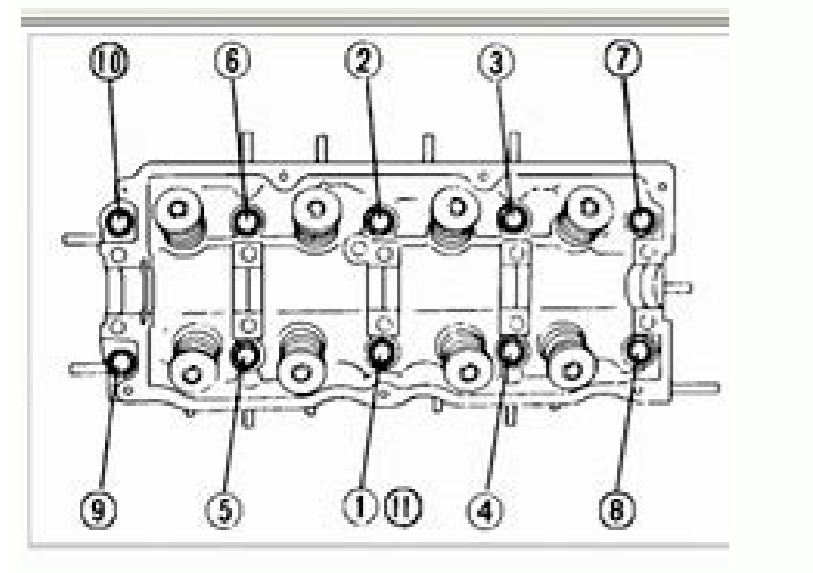
- INSTALL CYLINDER HEAD**
 - Install a new cylinder head gasket on the cylinder block.

NOTE: Be careful of the installation direction.



- Place the cylinder head on the cylinder head gasket.
- Apply a light coat of engine oil on the threads under the cylinder head bolts.
- Install and uniformly tighten the thirteen cylinder head bolts in several passes, in the sequence shown.

Torque:
 14 mm bolt head 900 kg-cm (65 ft-lb, 88 N)
 12 mm bolt head 195 kg-cm (14 ft-lb, 19 N)



Engine Line	Spark Plug Head	Cylinder Head	Main Bearing	Rod Bearing	Flywheel	Intake Manifold	Exhaust Manifold
LS1-LS6 (ATD)	13	53	29	25	61	12.5	12.5
LS1-LS6 (ATD)	13	53	29	25	61	12.5	12.5
LS1-LS6 (ATD)	13	53	29	25	61	12.5	12.5



Installation procedure, torque specifications and sequence To properly install your LS cylindrical heads, follow the steps below. This will avoid oil and coolant losses and a loss of compression from an exploding warhead gasket. If you are using aftermarket bolts or bubbles, follow the instructions provided with the new fasteners.** Pre-Installation Before installing your heads, make sure the bolt holes in the block are clean and the threads are not damaged. Valves, gaskets and springs are installed correctly. The freezer plugs are installed. The coolant temperature sensor is installed in the driver's side head. The coolant transition cap is installed on the passenger side head. The block is fixed to the motor bed. It can rotate with the added weight of the cylinder head. Installation process Press new Dowel Pins in the engine block. There are two ties per side (in the holes \35; 7 and \35; 8). They align the head to the block. Always replace them before installing the cylinder heads. If necessary, hit them slightly with a hammer. Clean the surface of the block bridge with a clean cloth and acetone (or a similar detergent). Place the head gasket on the block. Make sure that the front or this side at the top is facing in the right direction. Clean the surface of the head deck with a clean cloth and acetone (or a similar detergent). Gently place the cylinder head on the head gasket. Make sure you sit properly on the benches. Be careful not to scalp or scratch the surface of the bridge of the head. Install all all thumb-held bolts. Copy the M11 bolts in three steps. Copy the M8 bolts in one step. See below for the couple specs and sequence. Repeat the procedure The other head of the cylinder. Engine head bolt family LS Specific engine family First Pass Second Final Pass bolt Gen. 3 (LS1, LS6, etc.) M11 x 155.5mm 22 ft.-lbs. 90 degrees M11 x 101mm 50 degrees M8 x 46mm*22 ft.-lbs. Gen 4 (LS2, LS3, etc.) M11 x 155.5mm 22 ft.-lbs. 90 degrees M8 x 46mm*22 22 degrees M8 x 46mm* Notes The styled cylinder head bolts are the pair to produce fasteners. Never reuse old TTY bolts. 2003 and previous blocks use 155.5 mm long bolts in holes #1-8 and 101 mm long bolts in holes #9-10. The final torque angle is different. Make sure you use the right specifications! For engines using M12 head bolts, such as LSA and LS9, refer to the GM Service Manual. Reply ID 5187 A© | A© Published 2019/03/20 01:23 A© | A© A A© Updated 2019/04/19 09:36 I need the torque specifications for the screw cylinder at will. Do you have the same problem? Yesno Friday January 15, 2021 at 5:45 AM 2 replies Hello, here are the instructions that include the specifications and sequence of the pair. The attached photos are correlated with the directions. Let me know if this helps or if you have

any more questions. 1997 Hyundai Accent GL BEDAN L4-1495CC 1.5L SOHC MFI Removal and Installation Vehicle Engine, Cooling and Unloading Engine Cylinder Assembly Assembly and Repair Procedures Removal and Installation PIC 1 Removal 1. Drain the coolant and disconnect the top radiator hose. 2. Remove the hose (between the air filter and the head cover). 3. Remove the air intake hose. 4. Remove the vacuum hose, fuel hose and water hose. 5. Remove the cables from the candles. The cables must be removed holding the boot portion. 6. Remove the ignition coil. 7. Remove the pump and oil bracket from the power steering, then the suction manifold. 8. Remove the heat protector and the exhaust manifold group. ICP 2 9. Remove the coolant pump pulley and the crankshaft pulley. 10. Remove the cover of the timer strap. 11. Remove the pulley tensioner of the strap. Twelve. Remove the distribution belt. Thirteen. Remove the head cap. 14. Using the sequence shown in the illustration and the bolt tool of the cylinder head n. 09221-32001 and 09221-32001 and 09221-11000, or equivalent, remove the bolts from the cylinder head, hence the head assembly. Note: release the bolts in two or three steps. 15. Remove the gasket parts from the top of the cylinder block and the lower surface of the cylinder head. Note: Make sure the gasket pieces do not fall into the engine. Installation 1. Clean all the seal surfaces of the cylinder block and cylinder head. 2. Install a new cylinder head gasket on the cylinder head assembly. Do not apply sealing to the gasket and not reuse the old cylinder head gasket. Precise Pic Sequence 3. Use the sequence indicated in the tool for the illustration and the English head bolt wrench n. 09221-11001 or equivalent, install and then tighten the cylinder head bolts in two phases using the following specifications: Install the cylinder head bolts. Starting from the upper center, tighten all the bolts of the cylinder head in sequence, as shown in the illustration, using the Principality Cylinder Head (09221 -11001) or equivalent. Repeat the procedure, restart all the cylinder head bolts to the specified torque. The cylinder head bolt M10: 30 Nm (300 kg. Cm, 22 ft. LBS.) + (60 -65) + (60 -65) M12: 35 Nm (350 kg. Cm, 26 ft. LBS.) + (60 -65) + (60 -65 65) Note: When tightening the cylinder head bolt, with a special tool and a torque, tighten the bolt to the specified English key [M10: 30 Nm, M12: 35 Nm] And then turn the torque key 60 -65 and repeat once again as shown in the illustration. 4) Install the belt traction pulley. 5. Install are the time strap on the camshaft pinion, making sure that the tension side is narrow by rotating the camcock of the cams on the contrary, all the signs of time are aligned. 6. Adjust the time, refer to the timing components. 7. Install the rocker cover and tighten the bolts at 8-10 nm (80-100 kg. Cm, 5.3-7.2 ft. Lbs.). 8. Install the belt cover of 9) Install the new suction collector and the suction collector, tighten the nuts and bolts to 15-20 nm (150-200 kg. Cm, 11-14 ft. LBS.). 10. Install the new exhaust manifold gasket and the exhaust manifold, tighten the nuts and bolts to 15-20 nm (150-200 kg. Cm, 11-14 ft. LBS.). 11. Install the embossing tank and tighten the bolts at 15-20 nm nm kg. Cm, 11-14 ft. lbs.). The 12. Install the steering oil pump and bracket. I hope this helps. Let me know. Joe Images (Click to enlarge) LINK SPONSORED Sun+2 Friday, January 15, 2021 At 5:55 AM Hello, I have attached a chart for the pair for you to view. Using the sequence shown in the illustration and a screw wrench n. 09A 221-11A 000, or equivalent, tighten all cylindrical head bolts in two steps, using the following specifications: M10: 30 Nm (22 ft lb) + (60 +65) + (60 +65) M12: 35 Nm (26 ft lb) + (60 +65) + (60 +65) Roy Images (Click to enlarge) S No+2 Friday, January 15, 2021 at 6:00 AM Please log in or register to post a response. reply.

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