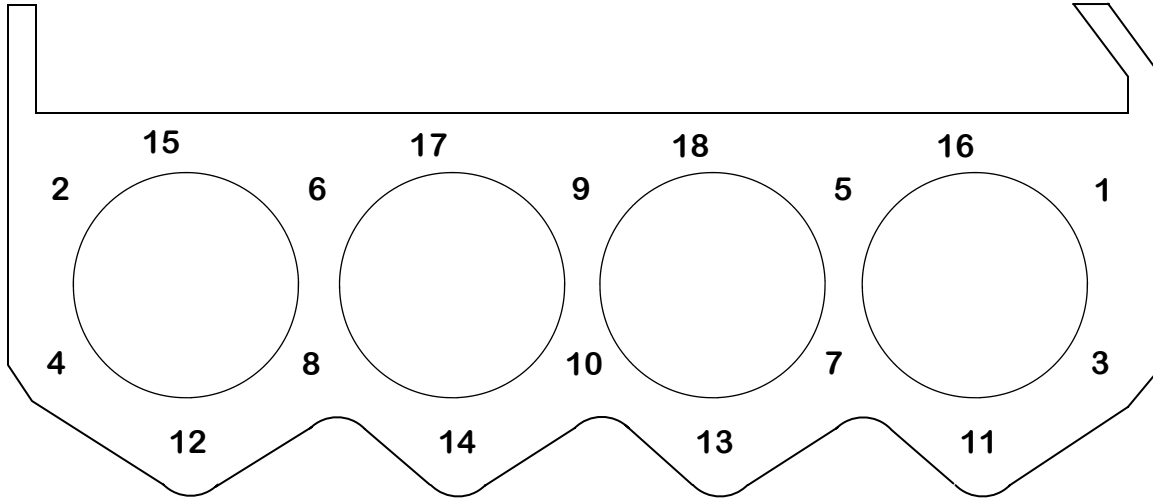


AJPE 481X Head Torque Sequence

10/16/08



<u>1st Torque</u>		
1/2" stud	#1 thru #10	60 lbs.
1/2" stud	#11 thru #14	60 lbs.
3/8 stud	#15 thru #18	50 lbs.

<u>2nd Torque</u>		
1/2" stud	#1 thru #10	80 lbs.
1/2" stud	#11 thru #14	80 lbs.
3/8 stud	Re-check #15 thru #18	50 lbs.

<u>3rd Torque</u>		
1/2" stud	#1 thru #10	100 lbs.
1/2" stud	Re-check #11 thru #14	80 lbs.
3/8 stud	Re-check #15 thru #18	50 lbs.

<u>4th & Final Torque</u>		
1/2" stud	#1,2,5,6,&9	110 lbs.
1/2" stud	Re-check #3,4,7,8,&10	100 lbs.
1/2" stud	Re-check #11 thru #14	80 lbs.
3/8 stud	Re-check #15 thru #18	50 lbs.

Use Detroit Diesel "Peanut butter" #2 on nuts & washers.
AJPE part # 00Z-954