

CYLINDER HEAD

CAUTION

To ensure proper head gasket alignment, install new O-rings over cylinder ring dowels before installing the head gasket. Improper head gasket alignment will cause leaks.

1. With the part number topside, place the head gasket over the two ring dowels in the upper flange of the cylinder.
2. Note that the word "Front" or "Rear" is cast into the top of the cylinder head to ensure proper installation. With the indent in the cooling fins facing the right side of the engine, gently slide cylinder head over the two cylinder flange ring dowels. Lower the cylinder head at an angle that closely approximates the angle of the crankcase to avoid damage to machined surfaces or the ring dowels.

CAUTION

Thoroughly clean and lubricate the threads of the cylinder head bolts before installation. Friction caused by dirt and grime will result in a false torque indication.

3. Lightly coat the threads and bottom face of the cylinder head bolts in clean H-D 20W50 engine oil. Wipe off any excess oil.
4. See Figure 3-38. Loosely install the cylinder head bolts onto the cylinder studs. Place two short bolts on the left side of the engine and two long bolts on the right.

CAUTION

Improperly tightened cylinder head bolts could result in gasket leaks, stud failure and distortion of the cylinder and/or cylinder head.

5. Tighten the four cylinder head bolts.
 - a. Following sequence shown, alternately turn each cylinder head bolt until finger tight.
 - b. Following the same sequence, tighten the cylinder head bolts to 120-144 in-lbs (13.5-16.2 Nm).
 - c. Continuing the same sequence, tighten each bolt to 15-17 ft-lbs (20.3-23.0 Nm).
 - d. See Figure 3-39. Using a grease pencil, mark a straight line on the cylinder head bolt continuing the line over onto the cylinder head.
 - e. Using the marks as a guide, turn each bolt 1/4 turn or 90 degrees. Be sure to tighten the cylinder head bolts in the sequence shown in Figure 3-38.

NOTE

For best results, use Snap-on Torque Angle Gauge TA360.

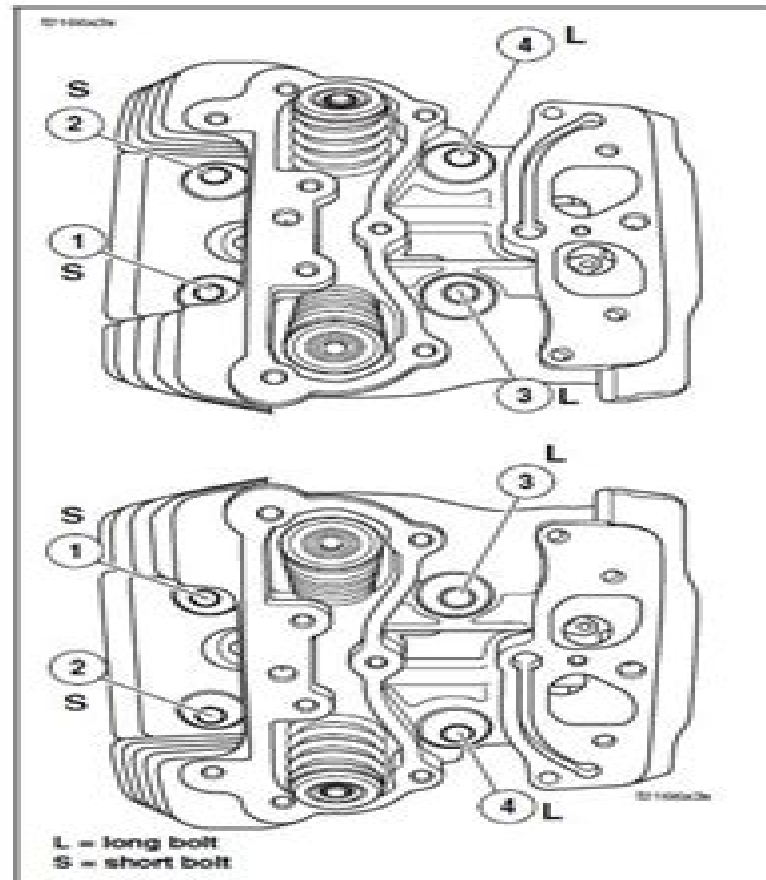


Figure 3-38. Cylinder Head Bolt Torque Sequence

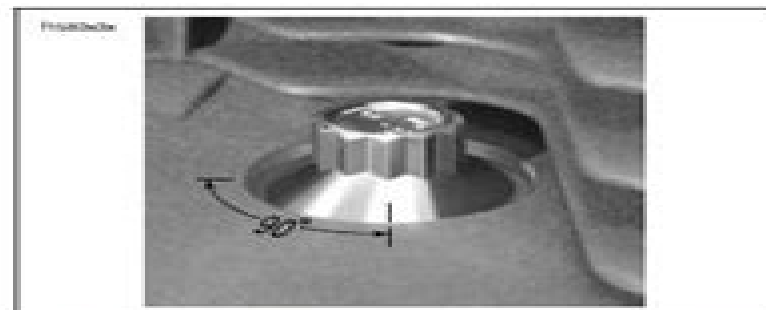


Figure 3-39. Final Tightening For Cylinder Head Bolts

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