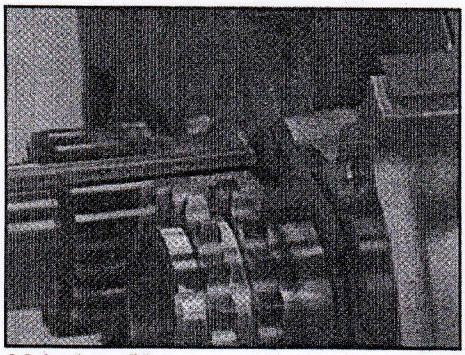
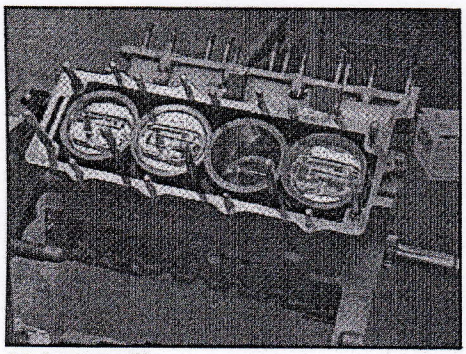


Main Assembly

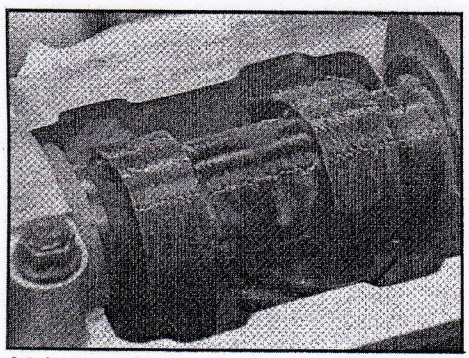
...and fit to the block as shown, making sure that the lock does not bind on the jackshaft. Torque to 20 ft lbs.



Main Assembly

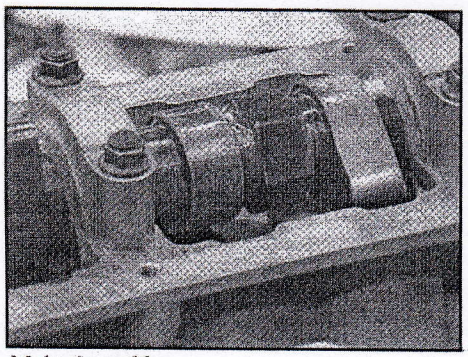
After making sure the block faces and liner tops are free from any particles, place the head gasket over the studs.

For Cylinderhead Build refer to its section.



Main Assembly

Make sure that the heads are set so that No.1 cylinder and No.8 cylinders are on overlap.



Main Assembly

I.E. The inlet and exhaust valve are open together as shown...