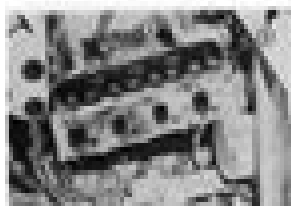




2. Inspect the condition of water female seal and seal (2). Make a replacement if needed. Put water female seal and seal (2) in position with the adjusting screw of hose clamp (1) turned to the top and approximately 45° to the right of vertical as seen from the front of the engine.

3. Make sure the seal is installed all the way as the counterflange.

NOTE: If the plugs in the oil passages in the cylinder head were removed, put JF9413 Pipe Sealant with Teflon on the threads, and install the plugs in the head.



4. Fit the seal (A) and a bolt to the cylinder head assembly. Put cylinder head assembly (3) in position on the cylinder block.

5. Put JF9401 Anti-Seize Compound on all the threads of the head bolts.

Dia.		Part No.	Location (Bolt No.)	Bolt Length "L"	
				in.	mm
1/2"	1/2"	104571	5, 2, 4, 10	5.50	139.7
		200408	7, 8, 3, 1, 6, 8	5.00	127.0
		111229	16, 14, 12, 17	3.00	76.2
		70547	18, 11, 13, 15	2.25	57.2
3/8"	3/8"	587803	20, 21	5.00	127.0
		145064	19	4.50	114.3
		51671	22	3.75	95.3

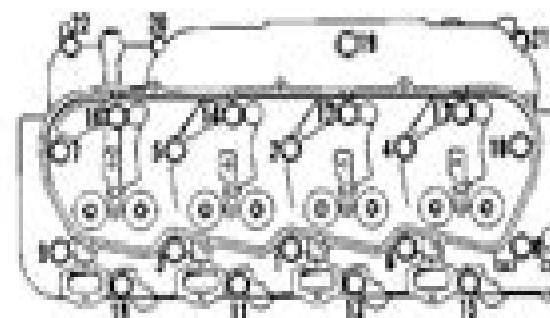


FIGURE 4

Head Bolt Location and Tightening Sequence

6. Install the head bolts, and tighten in follows:

- Tighten bolts (2) to (10) by counter sequence to a torque of 50 ± 14.7 N·m (36 ± 10.5 ft·lb).
- Tighten bolts (1) to (18) by counter sequence to a torque of 110 ± 7.35 N·m (80 ± 5.35 ft·lb).
- Tighten bolts (1) to (18) again by counter sequence to a torque of 110 ± 7.35 N·m (80 ± 5.35 ft·lb).
- Tighten bolts (19) to (22) by counter sequence to a torque of 40 ± 7.35 N·m (30 ± 5.35 ft·lb).



7. Tighten hose clamp (1).

8. Install valve assembly (4).

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Ying Liu



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Table of Contents Cat 953 Service Manual

1. Understanding the eBook Cat 953 Service Manual
 - The Rise of Digital Reading Cat 953 Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Cat 953 Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Cat 953 Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Cat 953 Service Manual
 - Personalized Recommendations
 - Cat 953 Service Manual User Reviews and Ratings
 - Cat 953 Service Manual and Bestseller Lists

5. Accessing Cat 953 Service Manual Free and Paid eBooks
 - Cat 953 Service Manual Public Domain eBooks
 - Cat 953 Service Manual eBook Subscription Services
 - Cat 953 Service Manual Budget-Friendly Options
6. Navigating Cat 953 Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Cat 953 Service Manual Compatibility with Devices
 - Cat 953 Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Cat 953 Service Manual
 - Highlighting and Note-Taking Cat 953 Service Manual
 - Interactive Elements Cat 953 Service Manual
8. Staying Engaged with Cat 953 Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Cat 953 Service Manual
9. Balancing eBooks and Physical Books Cat 953 Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Cat 953 Service Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Cat 953 Service Manual
 - Setting Reading Goals Cat 953 Service Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Cat 953 Service Manual
 - Fact-Checking eBook Content of Cat 953 Service Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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