

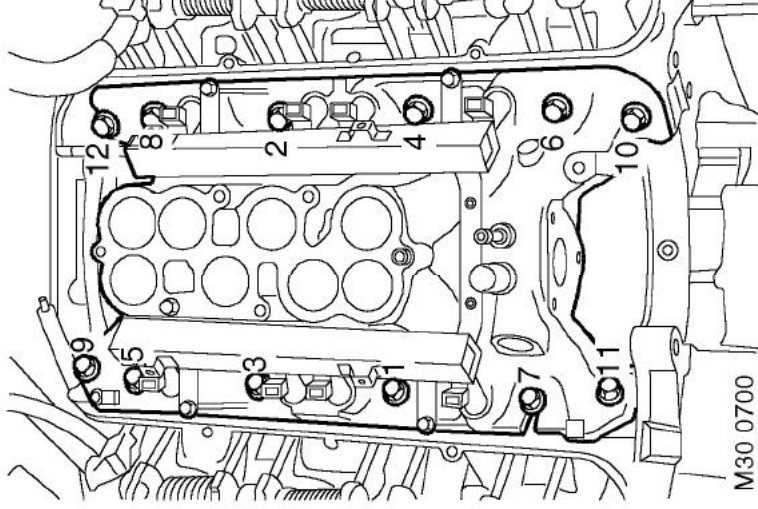
15. Remove 2 bolts securing manifold gasket and collect gasket clamps.
16. Remove inlet manifold gasket.
17. Remove gasket seals.

**Reassembly**

1. Clean sealant from cylinder head and from notches in the cylinder block.
2. Clean mating faces of cylinder block, cylinder head and manifold.

**CAUTION: Do not use a metal scraper or machined surfaces may be damaged.**

3. Ensure bolt holes are clean and dry.
4. Apply sealant, Part No. STC 50550 to cylinder head and notches in cylinder block.
5. Fit new gasket seals, ensuring the ends engage correctly in notches.
6. Apply sealant, Part No. STC 50550 to gasket seals above the notches in the cylinder block.
7. Fit new manifold gasket, dry.
8. Position gasket clamps, fit and lightly tighten bolts.
9. Position inlet manifold assembly to cylinder head.



10. Fit manifold bolts and, working in the sequence illustrated, tighten as follows:
  - Initially, tighten bolts numbered 1, 4, 9 and 12 in numerical order to 5 Nm (4 lbf.ft).
  - Inlet manifold bolts - initial tighten = 10 Nm (8 lbf.ft).
  - Inlet manifold bolts - final tighten = 51 Nm (38 lbf.ft).
  - Tighten inlet manifold gasket clamp bolts to 18 Nm (14 lbf.ft).
  - Tighten inlet manifold bolts to 51 Nm (38 lbf.ft)
11. Clean mating faces of rocker cover and cylinder head, ensure that bolt holes are clean and dry.
12. Fit new rocker cover gaskets, dry, position rocker covers, ensuring gaskets are correctly located.
13. Fit new 'patched' multi-hex rocker cover bolts ensuring that short bolts are on sides of rocker covers nearest centre of engine.
14. Tighten bolts by diagonal selection to:
  - Stage 1 - 3 Nm (2.5 lbf.ft)
  - Stage 2 - 8 Nm (6 lbf.ft)
15. Ensure that outer rim of each gasket is correctly positioned around periphery of rocker cover.
16. Secure ht leads to rocker cover.
17. Clean coolant outlet elbow mating faces.
18. Lubricate and fit new 'O' ring to outlet pipe.
19. Position coolant outlet elbow, fit bolts and tighten to 22 Nm (17 lbf.ft).
20. Position alternator, fit mounting bolts and tighten to 45 Nm (34 lbf.ft).