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Cylinder Head Installation For 2003-2005 Ford 6.0L Diesel Engines

S. B. International, Inc., offers the following information regarding cylinder head installation for 2003-2005 Ford 6.0L diesel engines. This bulletin is being revised to reflect changes to the head bolt torque sequence originally published.

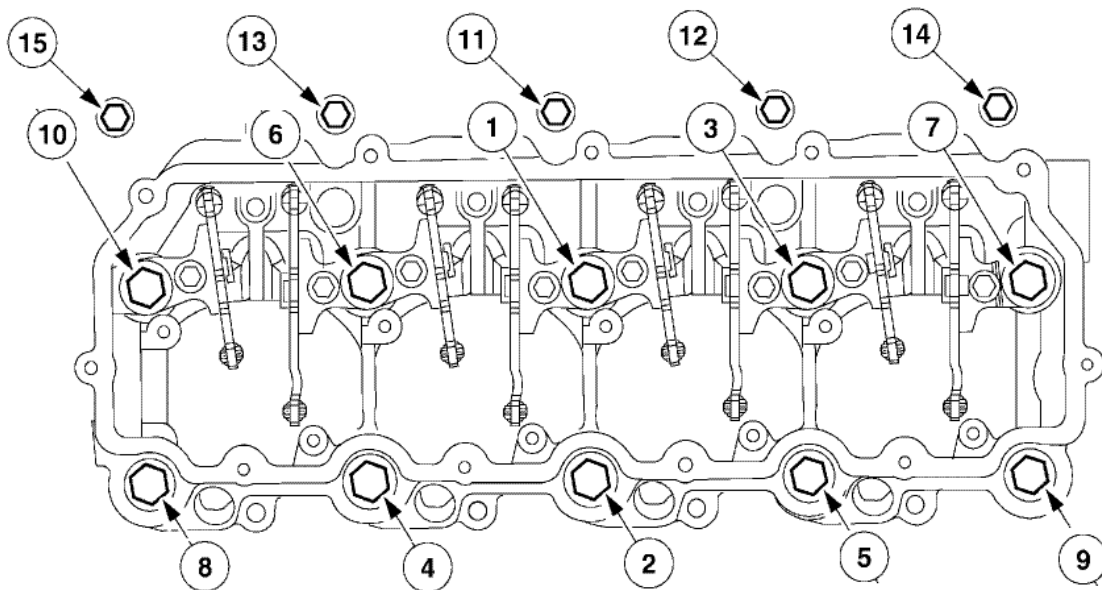
This engine utilizes fifteen bolts to secure each head to the cylinder block, ten M14 and five M8 bolts. Before installing the cylinder heads, it is important to obtain new M14 head bolts; the M8 bolts may be reused if they are undamaged.

NOTE: To prevent engine damage, you must always REPLACE all M14 x 192 cylinder head bolts when installing the cylinder head. Lightly lubricate M14 x 192 bolt threads and mating surfaces of bolt flanges with clean engine oil. Too much oil will cause hydrostatic lock and give incorrect torque reading. Do not lubricate the M8 x 70 bolts. Do not use anti-seize compounds, grease, or any other lubricant except engine oil. Other lubricants have an adverse effect on torque results. Follow the steps listed below to correctly install this engine's cylinder heads. Refer to Figure 1 below for the proper sequences.

M14 Bolts

1. Torque lubricated bolts in the sequence numbered 1 through 10 to 65 ft/lbs (88Nm).
2. Torque all bolts in sequence numbered 1 through 10 to 85 ft/lbs (116 Nm).
3. Torque all bolts in sequence numbered 1 through 10, clockwise 90°.
4. Torque all bolts in sequence numbered 1 through 10, a second time clockwise 90°.
5. Torque all bolts in sequence numbered 1 through 10, a third time clockwise 90°.

M8 Bolts - DO NOT LUBRICATE M8 BOLTS



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