SERVICE BULLETIN #1025

SUBJECT Torque on Cylinder Head Hold-Down Screws.

MODEL MISC.
7-55, 99, 33 Series, D44, 55, S44, S55

DATE 6-24-58

As the result of extensive research, we have discovered that the previously recommended torque of 60-65 inch pounds on cylinder head hold-down screws is excessive, causing the screws to yield (stretch) and loosen. This results in blown cylinder-head gaskets and engine failure.

To correct this condition we now recommend that the 10-24 cap screws holding the cylinder head by torqued (tightened) to 40-50 inch pounds.

We also recommend that after one or two days of saw operation the cylinder head hold-down screws be torqued to 45-50 inch pounds pressure to correct any loosening which may result from engine vibration.

LITHO IN U.S.A.