ATTENTION!

The engine assembler is responsible for final checking and cleaning the cylinder heads of debris before installation. The assembler is also responsible for replacing the rocker box gasket; one is provided in the ATS kit for each head. The assembler is responsible for the installation of the head gasket and fire rings (if applicable). New gaskets and rings will not be provided to replace any damaged parts as a result of improper assembly. Transgel or heavy grease can be used to hold the gaskets in the head during installation. Be sure all rings are seated in the grooves before tightening the head studs. There should be a .013" to .017" gap between the head gasket and engine block when all the rings are in the grooves. If a gap of more than .020" is measured, remove the head and check to ensure that all four rings are properly seated in the grooves. Once the correct gap is measured, follow the instructions provided with the head studs to complete the assembly.