Cylinder Head Bolt Torque Addendum for B Series Engines (T657)

This service parts topic is an addendum to the cylinder head bolt torque plus turn procedure for the B Series engines.

**B Series**

All B Series engines (including pre-'91 certification levels) need to use the new torque plus turn procedure defined in topic 98T2-13.

Capscrews for the '91 and later certification level engines are the same overall length but have a longer threaded area.

**CAUTION**

Do not use pre-'91 B certification level engine capscrews in a '91 B or later certification level engine because pre-'91 capscrews do not have enough threads to provide adequate thread engagement in the '91 and later certification engines.

**CAUTION**

B Series only: Capscrews for a '91 B or later certification level engine can be used in a pre-'91 certification level engine because '91 and later capscrews have enough threads to provide adequate engagement in all certification level engines.

Each '91 and later certification capscrew has been marked with symbols and an angle specification. The capscrew type can be identified by inspecting the marks on the capscrew head.
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<th>3920779</th>
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Pre-'91 B Series

'91 B Series

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