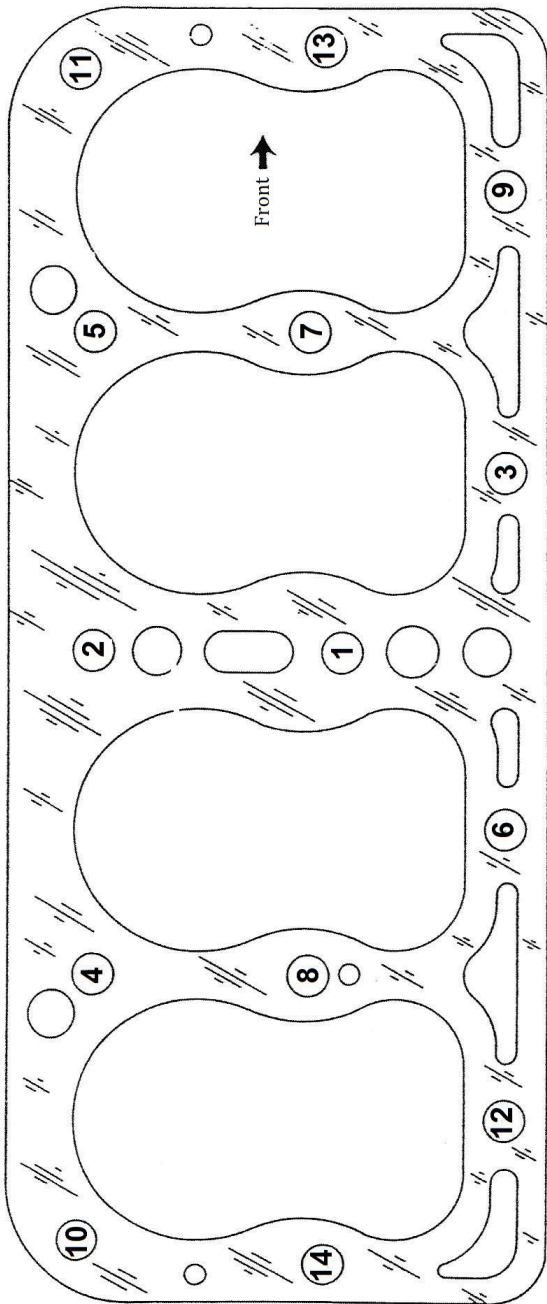


The correct torque sequence for all Model A and B head gaskets.



Start Torque at 35 foot pounds, using the sketch above, in numerical sequence and increase incrementally 10 pounds at a time to a final torque of 55 pounds. (35, 45, 55)

ALWAYS re-torque to 55 pounds a minimum of three (3) times **COLD**. . . **NO** Shortcuts. Run the engine to its normal running temperature and allow to cool before re-torquing. By the 2nd tightening, seepage, in most cases, should be gone. After the 3rd cooling and re-torque you should be ready to go.

Model A Ford 1928-1931 Torque, Gap and Capacity Specifications

Camshaft bearing clearance	.001 to .003
Cooling system	3 gal.
Connecting rod to crankshaft clearance	.001 to .00336
Crank rod pins	1.500 less 1 to 2 thousands for oil (1.498/1.499)
Crankshaft bearing size	1.625 less 1 to 2 thousands for oil (1.623/1.624, subtract .010 or .020 or .030 for rods)
Crankshaft end play	.004
Distributor point gap	.018 to .022
End play of water pump shaft	.006 to .010
Engine compression	76 PSI at sea level; at 5,000 ft. deduct 20
Flywheel depth	1.123 distance from 12 hole surface to refinish surface
Gas tank 1928-29	10 gal.
Gas tank 1930-31	11 gal.
Oil	5 qts.
Oil Pressure	2 to 3 pounds depending on weight of oil
Piston to cylinders	.002
Piston ring gap - lower ring	.008 to .010
Piston ring gap - center ring	.010 to .012
Piston ring gap - upper ring	.012 to .015
Main bearing clearance	.001 to .0015
Rear axle	1 1/2 pint
Rod wrist pin bushing - Machine shop must	expand ID of bushing in rod before honing to .0003 or 4.
Spark plug gap	.035
Steering gear	7 3/4 oz. for 7 tooth, 4 1/2 oz. for 2 tooth box
Transmission	1 pint
Timing gear backlash	.004
Tire pressure	35 PSI
Valves in valve guides	.001 to .0015
Valve to tappet clearance	.010 to .012 for all valves

Torque measurements are in foot-pounds.

Axle housing to differential	35
Camshaft nut	100
Connecting rods	35
Crankshaft Pulley Nut	80
Cylinder Compression on NEW engine	64
-The cylinders should not vary more than 7 pounds between cylinders.	
Flywheel	55
Head	50-55
Main bearing cap bolts	70 - 80
Manifold - exhaust	25 - 30
Oil pan	15 - 25
Pressure plate - use grade 5 bolts	25
Rear axle shaft nut	100
Timing cover	25
Torque tube to differential	35
Valve cover	15 - 25
Water inlet	40
Water neck - torque with caution	50
Wheel lug nuts	50-55