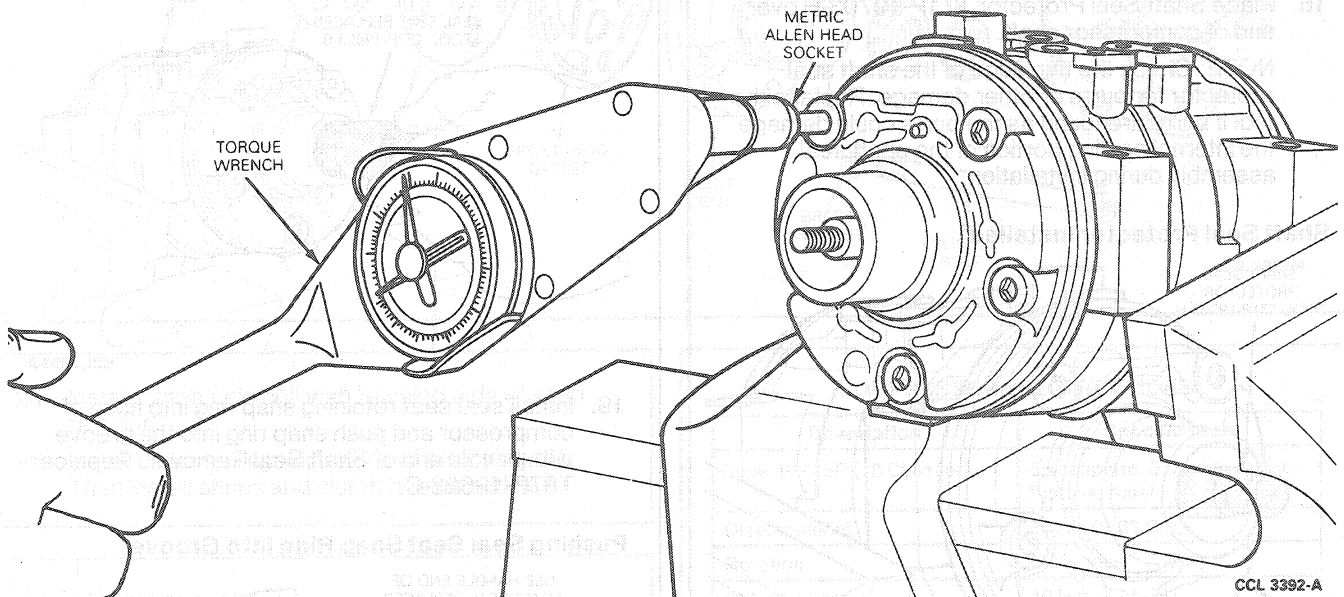


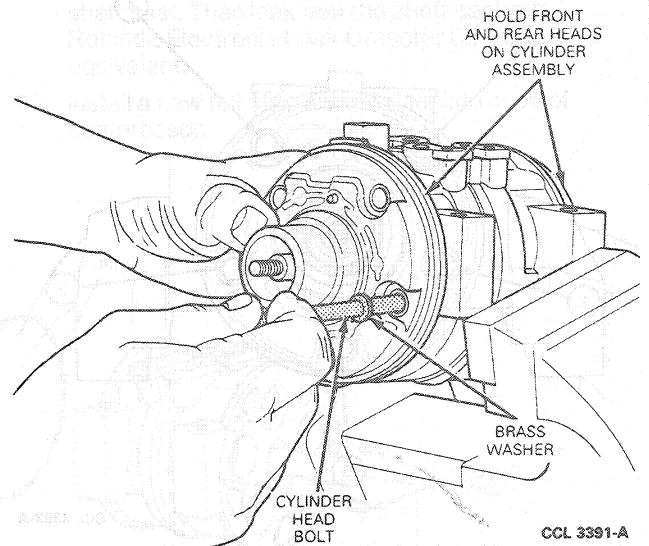
## MAJOR SERVICE OPERATIONS (Continued)

8. Lubricate rear reed valve with clean refrigerant oil and place it in position on the rear of the cylinder assembly. Ensure reed valve is properly positioned on cylinder assembly for cylinder bolts to pass through reed valve to rear head.
9. Lubricate rear valve plate (marked with an "R") and place it in position on rear of cylinder assembly. The "R" mark must be showing when valve plate is properly installed.
10. Lubricate rear head gasket and place it in position on cylinder assembly with raised portion of gasket away from cylinder assembly. Be certain gasket does not block cylinder bolt passages and gas passage opening is positioned to the right of center.
11. Lubricate rear head O-ring and place it in the groove on back of cylinder assembly.
12. Position rear head to cylinder assembly, aligning dowel pins with dowel pin holes in rear head.
13. Hold front and rear heads on the cylinder assembly. Install cylinder bolt until snug. This will prevent the rear head from separating from the cylinder assembly while the other cylinder bolts are installed.

### Tightening Cylinder Bolts with Torque Wrench



### Holding Cylinder Heads and Installing Cylinder Bolt



14. Using a torque wrench, tighten five cylinder bolts in three steps: 16 N·m (12 lb-ft), 20 N·m (15 lb-ft) and 25 N·m (19 lb-ft) in a diagonal sequence as shown in the illustration.