



New Product Update & Parts Information

Cylinder Head Bolts

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Bulletin	UK	Export	Vap	Issued
1090	Yes	Yes	Yes	25 th November 2005

Cylinder head bolts **VPA3909** (Suitable replacement for John Deere bolt R85363)

Please note this may affect your warranty:

On more modern engines the method of tightening down the cylinder head bolts when replacing the cylinder head gasket has changed from a standard torque figure, to a torque and turn technique. John Deere are one of many manufacturers that use this method with a number of their engines. In this situation special cylinder head bolts are used, specifically designed to stretch when being tightened. This type of bolt **must** be replaced once removed, they are not designed to be re-used. If these bolts are not replaced it will affect any warranty claim.

To help our customers, Vapormatic have introduced a stretch type cylinder head bolt VPA3909 for this application. This new type bolt is 112mm long and has a flanged head design, as shown below it comes in a pack of 9. To aid with correct fitting please note that VLA1500 (Torque wrench) and VLA1513 (Motor angular torque gauge) are now available in the Vapormatic range.

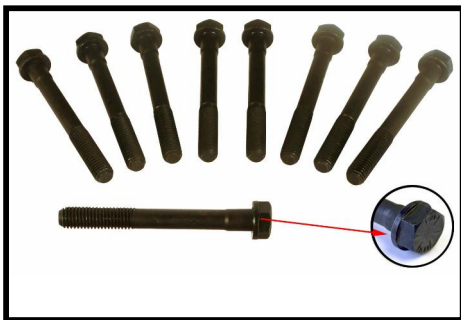
These bolts can also be used as a replacement for the 114mm long cylinder head bolts T20182 with hardened washer T20168.

Vapormatic will not warrant any engine rebuild where new stretch bolts have not been used.

Torque turn method with flanged heads: (**VPA3909**)

E.g:

- Step 1: 100Nm (75ft-lb)
- Step 2: 150Nm (110ft-lb)
- Step 3: Wait 5 minutes
- Step 4: Re-torque to 150Nm (110ft-lb)
- Step 5: rotate an additional 60°



VPA3909