

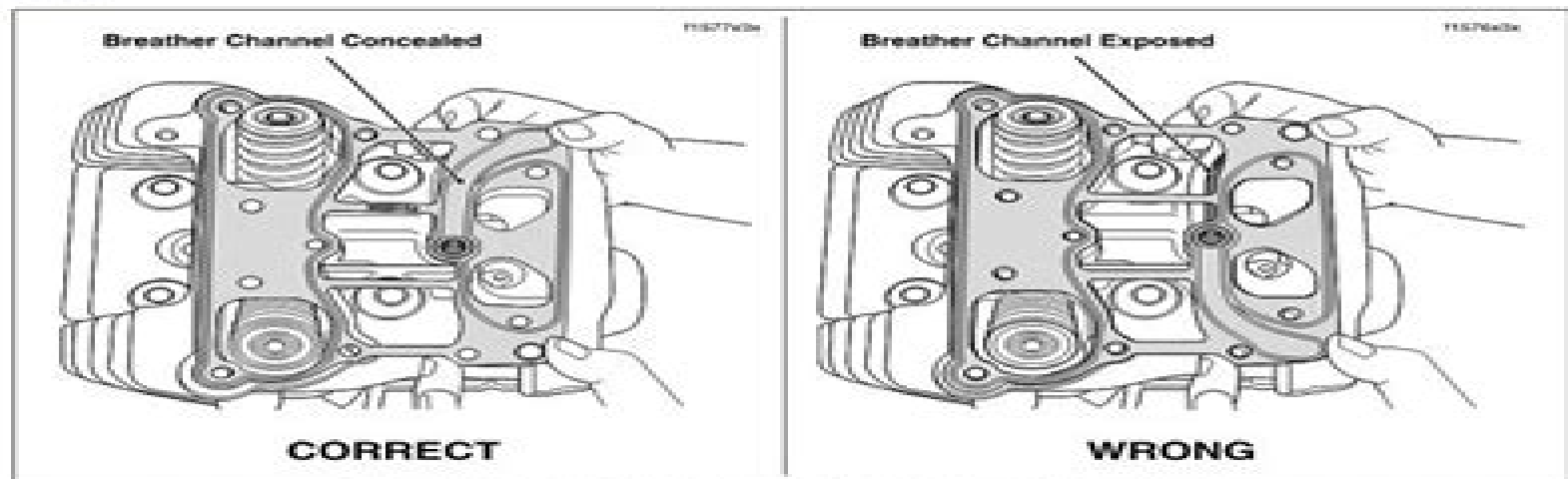


Figure 3-35. Install Rocker Housing Gasket (Rear Cylinder Shown)

24. Apply a small dab of Loctite Medium Strength Threadlocker 243 (blue) to threads of six rocker housing bolts. Start the rocker housing bolts, two long bolts on the left side of the engine, four intermediate bolts in the interior. Alternately tighten the bolts to 10-14 ft-lbs (13.6-19.0 Nm) in the pattern shown in Figure 3-37.

NOTE

Rocker housing and rocker cover bolts have both an internal and external hex, which allows the bolts to be installed with either a short 3/16 inch allen wrench (tight spaces), or a 7/16 inch socket or open end/box wrench (open spaces). If the engine is left in the chassis for service, the short 3/16 inch allen wrench is indispensable when installing the rocker housing and rocker cover bolts on the left side of the engine (particularly the rear) where there is close proximity to the frame.

NOTE

If the engine was left in the chassis for service, final tighten the rear left rocker housing bolt (rear cylinder) using a torque wrench with a 1/4 inch drive. Since this tool may not be available in foot-pounds, tighten the bolt to 120-168 in-lbs.

CAUTION

O-rings that are missing, distorted, pinched or otherwise damaged will result in either oil leakage or low oil pressure. Use of the wrong O-ring will have the same results. Since many O-rings are similar in size and appearance, always use new O-rings keeping them packaged until use to avoid confusion.

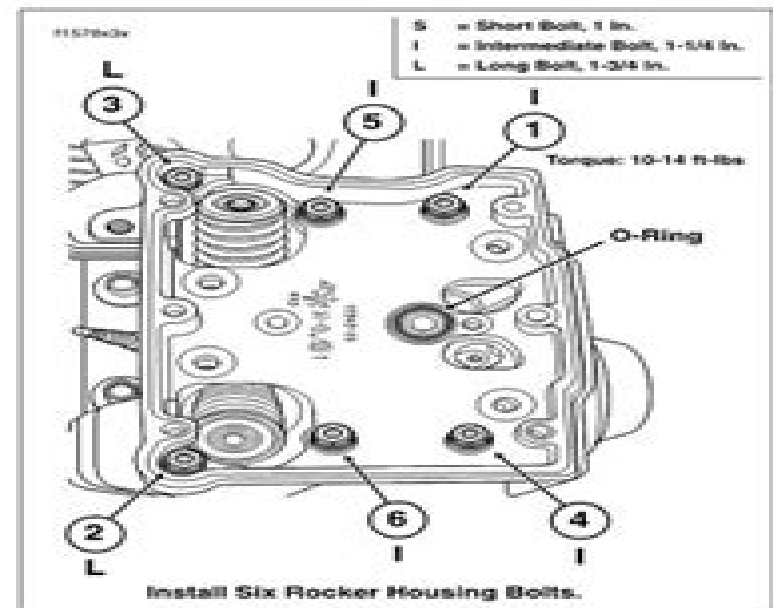


Figure 3-37. Rocker Housing Torque Sequence and Bolt Size (Rear Cylinder Shown)

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Lingsheng Yao



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Table of Contents 11 Harley Davidson Road King Service Manual

1. Understanding the eBook 11 Harley Davidson Road King Service Manual
 - The Rise of Digital Reading 11 Harley Davidson Road King Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 11 Harley Davidson Road King Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 11 Harley Davidson Road King Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 11 Harley Davidson Road King Service Manual
 - Personalized Recommendations
 - 11 Harley Davidson Road King Service Manual User Reviews and Ratings
 - 11 Harley Davidson Road King Service Manual and Bestseller Lists
5. Accessing 11 Harley Davidson Road King Service Manual Free and Paid eBooks
 - 11 Harley Davidson Road King Service Manual Public Domain eBooks
 - 11 Harley Davidson Road King Service Manual eBook Subscription Services
 - 11 Harley Davidson Road King Service Manual Budget-Friendly Options
6. Navigating 11 Harley Davidson Road King Service Manual eBook Formats

- ePub, PDF, MOBI, and More
- 11 Harley Davidson Road King Service Manual Compatibility with Devices
- 11 Harley Davidson Road King Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 11 Harley Davidson Road King Service Manual
 - Highlighting and Note-Taking 11 Harley Davidson Road King Service Manual
 - Interactive Elements 11 Harley Davidson Road King Service Manual
- 8. Staying Engaged with 11 Harley Davidson Road King Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 11 Harley Davidson Road King Service Manual
- 9. Balancing eBooks and Physical Books 11 Harley Davidson Road King Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 11 Harley Davidson Road King Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 11 Harley Davidson Road King Service Manual
 - Setting Reading Goals 11 Harley Davidson Road King Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 11 Harley Davidson Road King Service Manual
 - Fact-Checking eBook Content of 11 Harley Davidson Road King Service Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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