



Sedan Range

DATE 11/97  
Amended 2/98

03.1-13

SERVICE

## TECHNICAL BULLETIN

### Cylinder Head Bolts – Reuse Twice – Conditions

MODEL 1995-97 MY  
Sedan (4.0L) Range  
VIN  
720001-812255

Remove and destroy Bulletin 03.1-13, dated 11/97.  
Replace with this Bulletin.  
Revisions are marked with a bar and in **bold text**.

#### ISSUE:

It is now Jaguar Cars policy that the cylinder head bolts of AJ16 engines should be re-used **twice** in service, during repair operations involving removal of the cylinder head.

To be able to identify the number of times a bolt has been reinstalled, it is **mandatory** that bolts are marked as detailed below.

#### ACTION:

**Before reusing a cylinder head bolt, clean the threads thoroughly.**

After reinstalling and fully tightening a used cylinder head bolt (EXCEPT when a NEW bolt has been installed), mark the bolt head with **ONE** punch mark, **using an AUTOMATIC center-punch**.

A second removal and reinstallation is permissible. A bolt showing one punch mark may be reinstalled, **and marked with a second punch mark**.

When removing a bolt already marked with two punch marks, it **MUST** be discarded.

Any bolt showing obvious signs of damage must be replaced.

**PARTS INFORMATION:**

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
Bolt, cylinder head	JZB 100053	A/R

**WARRANTY POLICY:**

Claims for bolt replacement will not be honored unless the bolts have already been re-used twice.

**WARRANTY INFORMATION:**

The above has no effect on Repair OperationTimes.