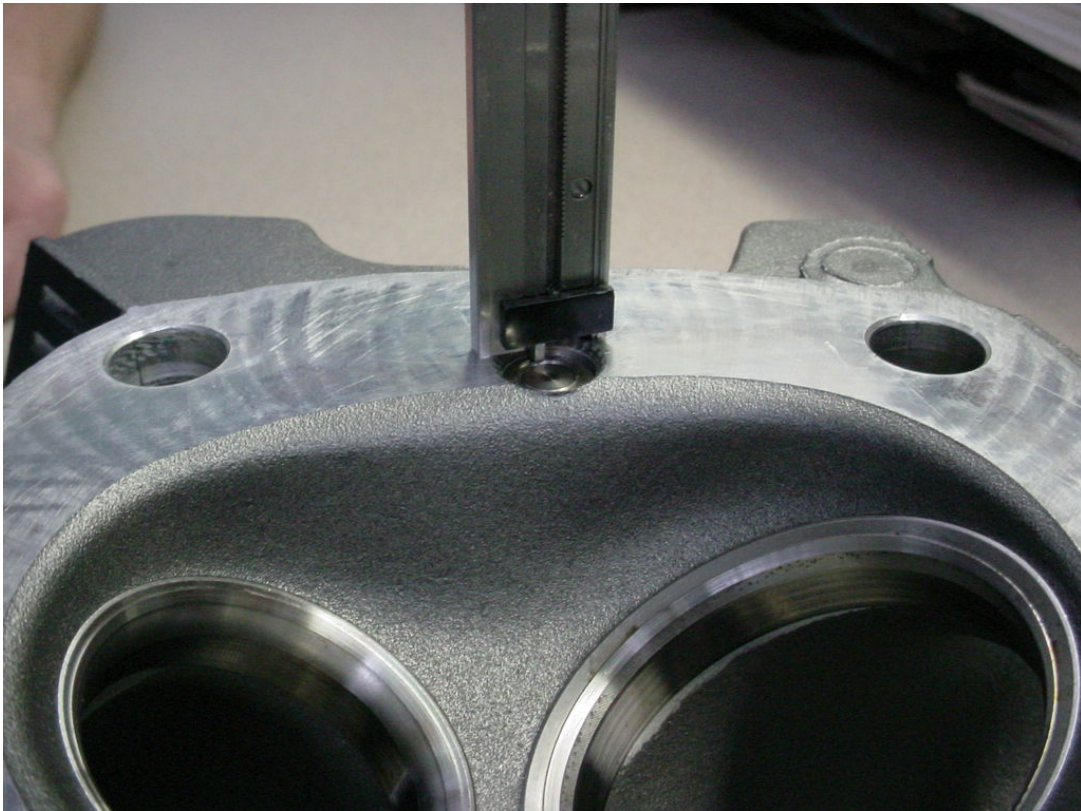


ACR Torque for 110 and 103 P&A Cylinder Heads

It is possible that some ACR equipped P&A 110 (1800 cc) and 103 (1690 cc) cylinder heads were shipped with the ACR partially torqued.

Before installation or retail, please check all heads to ensure that the ACR is properly seated. This can be achieved by simply measuring the depth to the ACR from the head gasket surface of the cylinder head. A properly torqued ACR will measure .080"-.090" from the head gasket surface to the ACR.



If the automatic compression release is more than .090" from the surface of the cylinder head dome, the component should be removed from the head, cleaned and reinstalled using the ACR socket tool (Part Number **HD-48498A**)

1. Verify that the copper seal washer is in place on the ACR.
2. Identify a location around the threads of the ACR approximately 1/3 of the way up from the end.
3. Apply three equally spaced dots of LOCTITE 246 (blue) on threads.
4. To prevent cross threading, install and finger tighten.
5. Using ACR solenoid socket, tighten to 11-15 ft-lbs (14.9-20.3 Nm).