

Enginetech Inc
Tech Assistance 800-410-3664 ext. 340 or 237

TECHNICAL BULLETIN	
	April 2003 TB 2063
Mfg:	FORD
Model:	AEROSTAR
Liter:	3.0L
V I N:	U
Year:	90-99

Cylinder Head Installation Procedure For
1999-2003 Ford 3.0L VIN 1, 2 & U Engines

The AERA Technical Committee offers the following information regarding cylinder head installation procedures for 1999-2003 Ford 3.0L VIN 1, 2 & U engines. This procedure changed from previous years use of these engines. The use of new bolts is still required when re-installing the heads for these engines.

Use the following steps to install cylinder heads for the engines listed above. Ensure that all surfaces of the cylinder block, cylinder head, and gasket are completely free of any solid or liquid contamination and have been prepared for assembly using Motorcraft Metal Surface Cleaner, F4AZ-19A536-RA, or equivalent solvent.

1. □ Position new head gaskets, noting UP designation on head gasket face, on the cylinder block using the cylinder head to block dowel for alignment (see Figure 1).
NOTE: Replace cylinder head to block dowel if damaged. Position cylinder heads on cylinder block over cylinder head to block dowels.
 2. □ Always use New cylinder head bolts when installing cylinder head or damage to engine may occur.
 3. □ Tighten the New retaining bolts in sequence shown in Figure 2 below to 35-39 ft/lbs (47-53 Nm).
 4. □ Loosen all bolts in sequence a full 360° turn.
 5. □ Tighten the retaining bolts in sequence shown in Figure 2 below to 20-24 ft/lbs (27-33 Nm).
 6. □ Rotate all bolts in the numbered sequence shown in Figure 2 an additional 85-95°
 7. □ Rotate all bolts in the numbered sequence shown in Figure 2 an additional 85-95°
- NOTE: When cylinder head retaining bolts have been tightened, it is not necessary to retighten the bolts after extended engine operation.

Figure 1, Locating Dowel Installation

Figure 2, Cylinder Head Bolt Torque Sequence

The AERA Technical Committee

This information is provided from the best available sources. However, AERA does not assume responsibility for data accuracy or consequences of its application. Members and others are not authorized to reproduce or distribute this material in any form, or issue it to their branches, divisions, or subsidiaries, etc. at a different location, without written permission.
© Copyright AERA 2006



Reference:	
-------------------	--

TECHNICAL BULLETIN

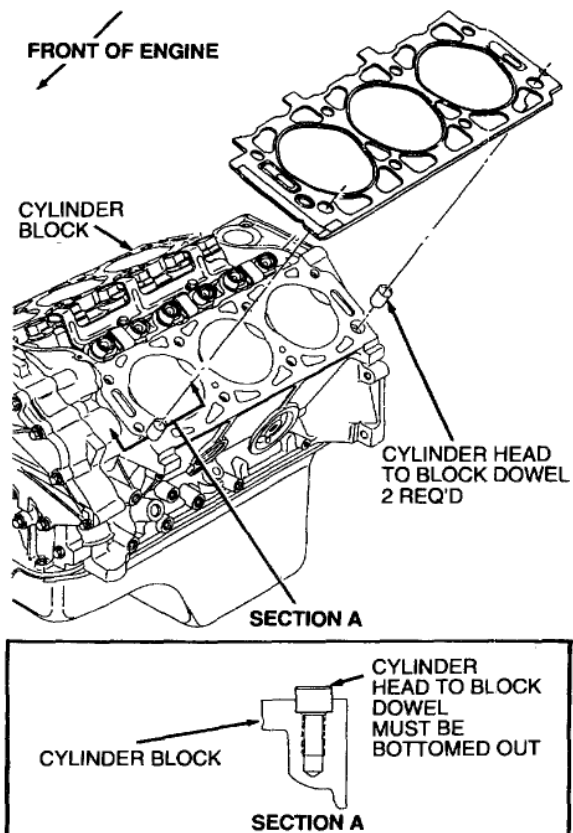


April 2003

TB 2063

Mfg: FORD
Model: AEROSTAR
Liter: 3.0L
VIN: U
Year: 90-99

Bulletin Diagram: LOCATING DOWEL INSTALLATION - CYLINDER HEAD



A15381-C

This information is provided from the best available sources. However, AERA does not assume responsibility for data accuracy or consequences of its application. Members and others are not authorized to reproduce or distribute this material in any form, or issue it to their branches, divisions, or subsidiaries, etc. at a different location, without written permission.
© Copyright AERA 2006



Reference:

TECHNICAL BULLETIN

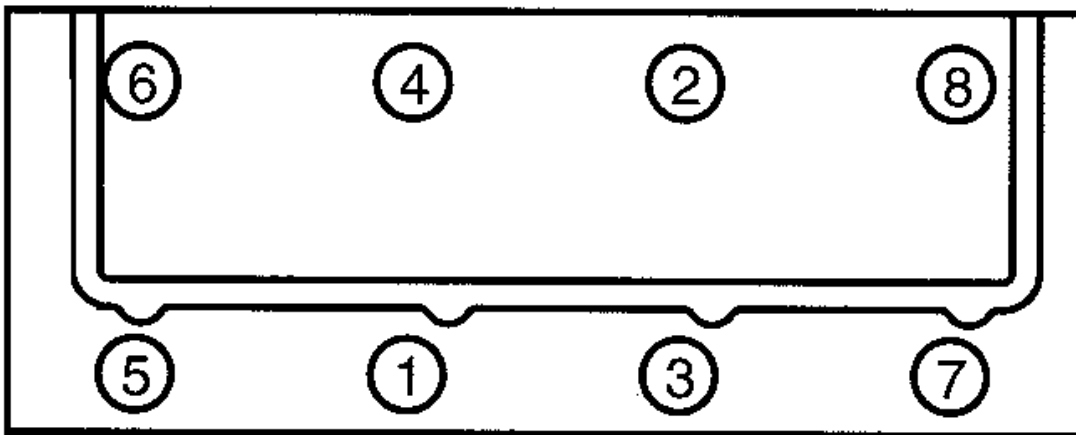


April 2003

TB 2063

Mfg: FORD
Model: AEROSTAR
Liter: 3.0L
VIN: U
Year: 90-99

Bulletin Diagram: CYLINDER HEAD BOLT TORQUE SEQUENCE - CYLINDER HEAD



This information is provided from the best available sources. However, AERA does not assume responsibility for data accuracy or consequences of its application. Members and others are not authorized to reproduce or distribute this material in any form, or issue it to their branches, divisions, or subsidiaries, etc. at a different location, without written permission.
© Copyright AERA 2006



Reference: