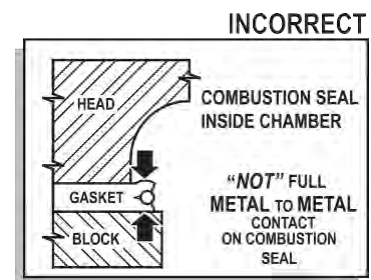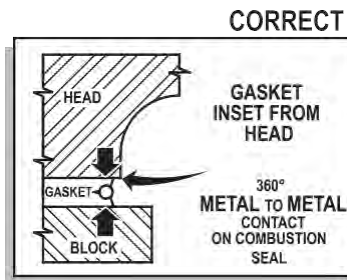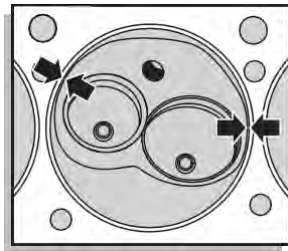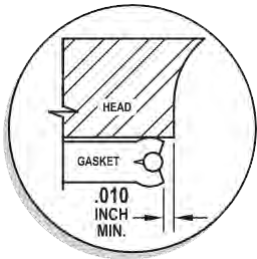# ICS INTEGRAL COMBUSTION SEAL HEAD GASKETS TITAN

Installation Instructions

Note: Ensure 360° Contact. Do not use O-rings. Sealant (such as Copper Coat, SCE p/n G1612) may be used if desired.

Recommended uses: High Performance Street, Mild Race, with Medium Boost or Nitrous.

Steps:

1. Before installing head gasket, visually inspect for shipment damage. Sealant beads must be continuous without gaps or scratches and the wire should not protrude out from combustion seal.

2. Gasket to head check, place cylinder head on a bench flat side up. Align new gasket on head in the assembled location, check to insure 360° metal to metal contact on combustion seal paying close attention to valve reliefs, see illustrations above.

3. Check head and block mating surfaces to ensure flatness within .002" using a steel straight edge and thickness gauge. If a sealing surface exceeds .002" out of flat, have the component resurfaced to an 80ra finish or finer.

4. New head studs/bolts are recommended for proper gasket sealing, threads must be in good condition otherwise replace. Use a tap to clean threads in block. If threads are tapped through the deck, use care in sealing threads to prevent coolant migration up the bolt. If studs are to be used check for proper length so nuts do not "bottom out". Always use quality hardened washers and thread lubricant to prevent thread galling.

5. Sealant is not required but may be used if desired (Copper Coat p/n G1612). Position new gasket over locating dowels on block. Position cylinder head over dowel pins without disturbing gasket, Tighten bolts and torque in sequence per manufacturers' specifications.

6. ICS Titan head gaskets must be re-torqued. Start the engine and allow it to reach operating temperature without placing any load on the engine. Shut down and allow the engine to return to ambient temperature. With the engine cold and following the recommended torque sequence, one at a time back each fastener off just enough to relieve the friction set, then re-torque to specified torque value