

Installation Instructions for 83405 & 83408 Head Bolt Kit

170,000 PSI - 11mm Diameter Large Bolts & 8mm Small bolts

Installation Instructions:

1. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block & on the bolts.
2. Clean and inspect all hardware prior to installation. Check proper fit and length.
3. Position the chamfered side of the 11mm washers on the bolt so it faces the bolt head. This is done to clear the radius on the under head of the bolt. **Note:** Improper installation of the washer will cause premature bolt failure. The 8mm washers don't have a chamfer, but the hole is large enough to clear the chamfer on the bolt.
4. Lubricate the threads of the bolts with 30wt. motor oil.
5. Install the cylinder head(s) and check for binding or misalignment.
6. Lubricate the under head of the bolt and washers with 30wt. motor oil. Then install the bolts into the cylinder head and tighten them hand tight.
7. Following the manufacturers recommended torque sequence, tighten the 11mm bolts in three equal steps to:
 - 11mm x 2.0 Bolts – First Pass 30 lb-ft, Second Pass 50 lb-ft, Third Pass 75 lb-ft
 - 8mm x 1.25 Bolts – 25 lb-ft



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