

Installation Instructions for 83455 Premium Engine Bolt Kit

Includes:

HEAD BOLT WASHERS

MACHINED HEAD BOLT WASHER

SHORT HEAD BOLTS

(See Head Bolt instructions below)

HEAD BOLT, 7/16"-14 X 2"

INTERMEDIATE HEAD BOLTS

(See Head Bolt instructions below)

HEAD BOLT, 7/16"-14 X 3"

LONG HEAD BOLTS

(See Head Bolt instructions below)

HEAD BOLT, 7/16"-14 X 4"

VALVE COVER STUD

1/4"-20 X 1-3/4" SET SCREWS

1/4"-20 SS NYLON NUTS

1/4" STAINLESS AN WASHERS

INTERMEDIATE MANIFOLD BOLTS

3/8"-16 X 1-1/4" 12PT.

3/8" HARDENED WASHER

TIMING COVER BOLTS

1/4"-20 X 1/2" HH FLG. BOLT

BALANCER BOLT

1/2"-20 X 1.5" HIGH HHCS

1/2" LOCK WASHER

BALANCER WASHER

HEADER BOLTS

HEADER BOLT 3/8"-16 X 1"

OIL PAN BOLTS

1/4"-20 X 1/2" HH FLG. BOLTS

5/16"-18 X3/4" HH FLG. BOLTS

SHORT WATER PUMP BOLTS

3/8"-16 X 2.5" GRADE 5

3/8"-16 X 1.75" HHCS

3/8" SPLIT LOCK WASHERS

LONG WATER PUMP BOLTS

3/8"-16 X 2" HHCS GR.5

3/8" SPLIT LOCK WASHERS

WATER NECK BOLTS

3/8"-16 X 1" HHCS GRD. 5

3/8" STAINLESS AN WASHERS

FUEL PUMP BOLTS

3/8"-16 X 1-1/2" HHCS

3/8" SPLIT LOCK WASHERS

DISTRIBUTOR BOLT

3/8"-16 X 1" HHCS GR.5

3/8" STAINLESS AN WASHER

CAM BOLT KIT

CHEVY CAM LOCK'G RETAINER

5/16"-18 X 3/4" HHCS

CARB STUDS KIT 1-1/2"

RTV SILICONE GASKET MAKER

Head Bolt installation Instructions: (170,000 PSI - 7/16" Diameter)

1. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. Chase if necessary with JEGS thread chaser set #555-80505.
2. Clean and inspect all hardware prior to installation. Check proper fit and length.
3. Position the chamfered side of the washer 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.
4. If the cylinder head bolts protrude into a water jacket, lubricate the threads of the bolts with JEGS #555-28011 thread sealant.
5. If the cylinder head bolts protrude into a blind hole, lubricate the threads of the bolts with 30wt. motor oil.
6. Install the cylinder head(s) and check for binding or misalignment.
7. 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.
8. Following the manufacturers recommended torque sequence, tighten the bolts in three equal steps to 70 ft. lbs.



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