



**EARL'S RACING PRODUCTS - HEAD BOLTS
P/N HBS-004ERL & TBS-004ERL
Installation Instructions 199R11483**

Big Block Chevy Engines - 170,000 PSI – 7/16"-14 Bolts
Fits: 396-402-427-454 OE Cast Iron Heads

INSTALLATION:

1. To ensure proper thread engagement and accurate torque readings, clean all threads in the block and on the bolts. Use a thread chaser or tap to clean out the threads in the block.
2. Inspect and check all hardware for proper fit and length – prior to installation.
3. The chamfered side of the washers must be facing toward the bolt head. The chamfer is needed to clear the radius under the head of the bolt. Improper installation of the washer will cause premature bolt failure.
4. Lubricate the washers and the underside of the head on the bolts w/ the anti-seize that is included with these parts.
5. Install the cylinder heads and check for any binding or misalignment.
6. Install the head bolts and tighten them hand tight (don't forget to lubricate the washers and underside of the head on the bolts).
7. Follow the manufacturer's recommended torque sequence. Tighten the 7/16" Bolts in three equal steps to 70 lb-ft.

199R11483

Date: 1-9-18



**EARL'S RACING PRODUCTS - HEAD BOLTS
P/N HBS-004ERL & TBS-004ERL
Installation Instructions 199R11483**

Big Block Chevy Engines - 170,000 PSI – 7/16"-14 Bolts
Fits: 396-402-427-454 OE Cast Iron Heads

INSTALLATION:

1. To ensure proper thread engagement and accurate torque readings, clean all threads in the block and on the bolts. Use a thread chaser or tap to clean out the threads in the block.
2. Inspect and check all hardware for proper fit and length – prior to installation.
3. The chamfered side of the washers must be facing toward the bolt head. The chamfer is needed to clear the radius under the head of the bolt. Improper installation of the washer will cause premature bolt failure.
4. Lubricate the washers and the underside of the head on the bolts w/ the anti-seize that is included with these parts.
5. Install the cylinder heads and check for any binding or misalignment.
6. Install the head bolts and tighten them hand tight (don't forget to lubricate the washers and underside of the head on the bolts).
7. Follow the manufacturer's recommended torque sequence. Tighten the 7/16" Bolts in three equal steps to 70 lb-ft.

199R11483

Date: 1-9-18