

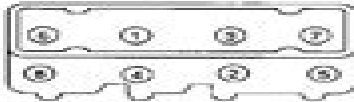
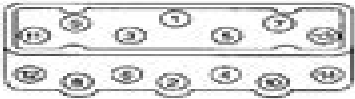
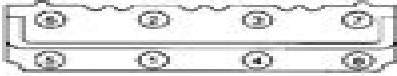
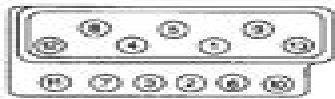
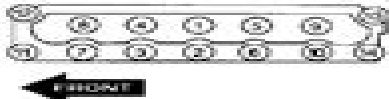
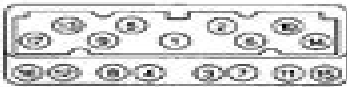
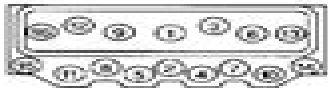
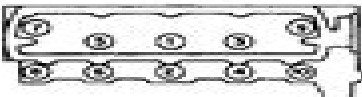
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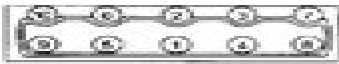
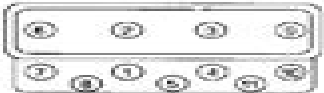
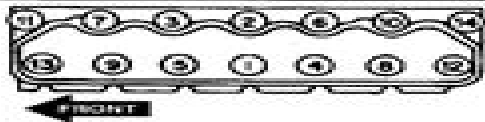
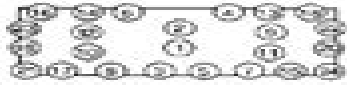
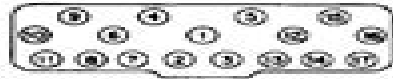
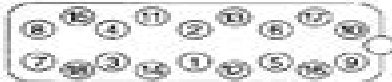
Please Note:

All torque values listed require the use of moly or anti-seize.

Notes:

1. Use 190,000 psi fasteners only.
2. Do not use OE or torque-to-yield type bolts
3. Wire brush bolt threads and fine stud threads to remove coating.
4. Use moly or anti-seize lubricant. DO NOT use oil.
5. Apply lube to both sides of washers, under bolt heads or nuts.
6. Lube bolts that go into water jackets with Teflon sealer.
7. Install studs with sealer.

Engine	Ft. Lbs.	
BUICK V6 196, 231, 252, Stage I Eng.	Short Bolts 65 Long Bolts 75	
BUICK V6 Stage II Eng.	Short Bolts 65 Long Bolts 75	
CHEVROLET V6 90° "V" Design 173 Eng.	70	
CHEVROLET V6 90° "V" Design 229, 262 Eng.	Short Bolts 65 Long Bolts 70	 
CHEVROLET V8 Small Block 262, 265, 267, 283, 302, 305, 307, 327, 350, 400 Eng.	Short Bolts 65 Long Bolts 70	
CHEVROLET V8 Big Block 396, 402, 427, 454 Eng.	Short Bolts 65 Long Bolts 75	
OLDSMOBILE V8 Upper 100 Lower 90		

Engine	Ft. Lbs.	
PONTIAC 4 151 Crossflow Eng.	80	
Super Duty (1/4" dia. head bolts)	100	
PONTIAC V8 326, 350, 389, 400, 421, 428, 455 Eng.	Upper 100 Lower 90	
FORD V6 90° "V" Design 4.5 Liter	Studs 90 Bolts 75	
FORD 5 Inline 240, 300 Engine	70	
FORD V8 Flathead 239 1938-49 w/Aluminum Heads w/Cast Iron Heads	Studs 50 55 Bolts 55 65	
FORD, MERCURY V8 (Note: Replace worn dowel tubes) 260, 289, 302, 62-93 302 Boss Eng.	1/4" Bolts Upper 75 Lower 65	
302 SVO, 351C, 351C, SVO, 351M, 351W, 351W SVO, 352, 380, 400, 406, 427, 428 Eng. 429 Except "Boss", 460 Eng.	1/4" Bolts Upper 100 Lower 90	
	Upper 120 Lower 110 Corners 95	
DODGE, PLYMOUTH V8 273, 318, 340 360 Eng.	Upper 100 Lower 90	
DODGE, PLYMOUTH V8 361, 383, 400, 413, 440 Eng.	70	
DODGE, PLYMOUTH V8 426 Hem.	75	
DODGE, PLYMOUTH V8 W7/W8 1/2" Dia. 100 7/16" Dia. 70 3/8" Dia. 60		

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Judd E. Hollander



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