



**EARL'S RACING PRODUCTS - HEAD BOLTS
P/N HBS-003ERL & TBS-003ERL
Installation Instructions 199R11248**

Small Block Chevy Engines - 170,000 PSI – 7/16"-14 Bolts

Fits: OEM 23° Cast Iron, Gen II Vortec/Truck, Most Edelbrock®, AFR LT®, Brodix® -8/-10/-11/-11xb, LT-1, Dart Pro-1

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. The head bolt holes in most small block Chevy engines go right into the water jacket and the threads must be sealed to avoid leaking (Earl's Pipe Sealant D024ERL is recommended for sealing the threads). 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 seal the threads, and 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.

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