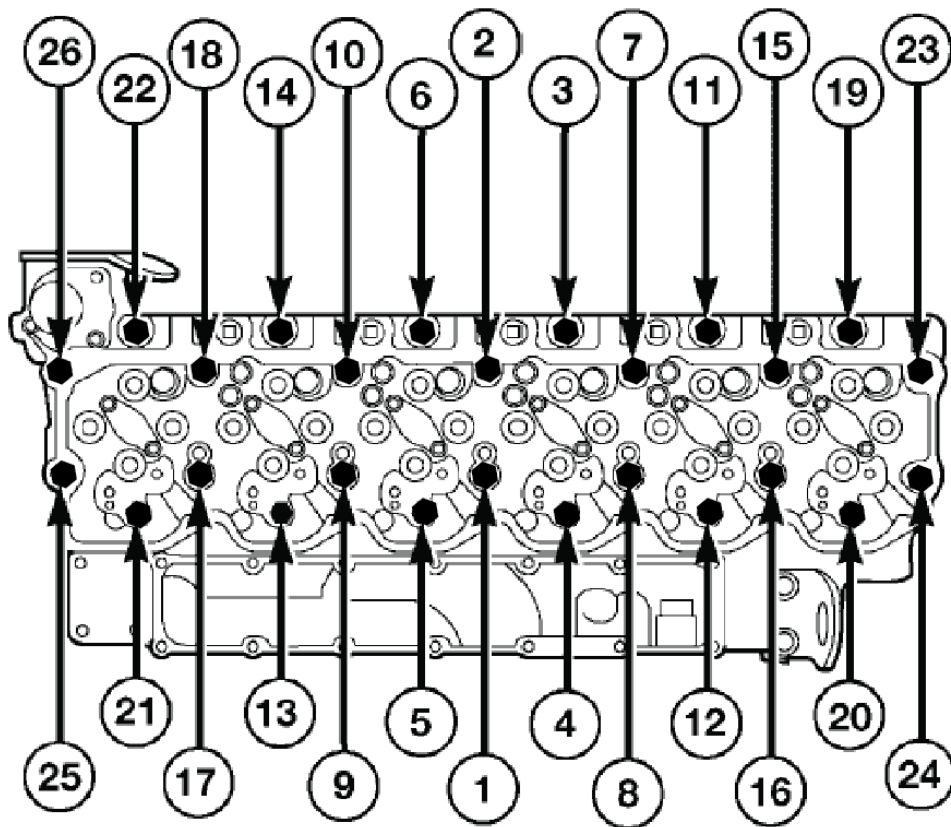


POWER DRIVEN DIESEL 24V HEAD BOLTS

Installation Instructions

Kit Contents:

- 26x Bolts
- 26x Washers
- Lube Packet



To install the bolts one at a time, on a complete engine, follow these steps:

1. Ensure engine is cool and there is no positive pressure in the cooling system.
2. Remove valve cover, rocker box, and exhaust rocker arm.
3. Apply lubricant to new PDD head bolt.
 - a. Lubricate threads and both sides of washer.
 - b. **Chamfered side of washer must be in contact with the bolt head.**
4. Remove one factory head bolt (reference torque sequence for proper order of replacement).

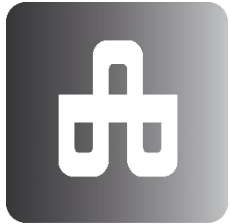


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- a. Clean bolt hole with brake cleaner and compressed air. Ensure threads are completely dry before installing.
5. Install PDD head bolt.
 - a. Torque in one step to 125 ft-lbs.
6. After all bolts have been replaced, torque bolts again in sequence to 125 ft-lbs.
7. Reinstall rocker arms, rocker box, and valve cover.

To install the bolts during an engine build, follow these steps:

1. Ensure all bolt holes in block are clean.
2. Apply lubricant to new PDD head bolt.
 - a. Lubricate threads and both sides of washer.
 - b. **Chamfered side of washer must be in contact with the bolt head.**
3. Install all bolts, finger-tight.
4. Torque in sequence to 50 ft-lbs.
5. Torque in sequence to 100 ft-lbs.
6. Torque in sequence to 125 ft-lbs.
7. Retorque to 125 ft-lbs.
8. Any retorques to follow (such as during engine break-in) should be done at 125 ft-lbs. Always follow your engine builder's advice on retorque procedures.



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