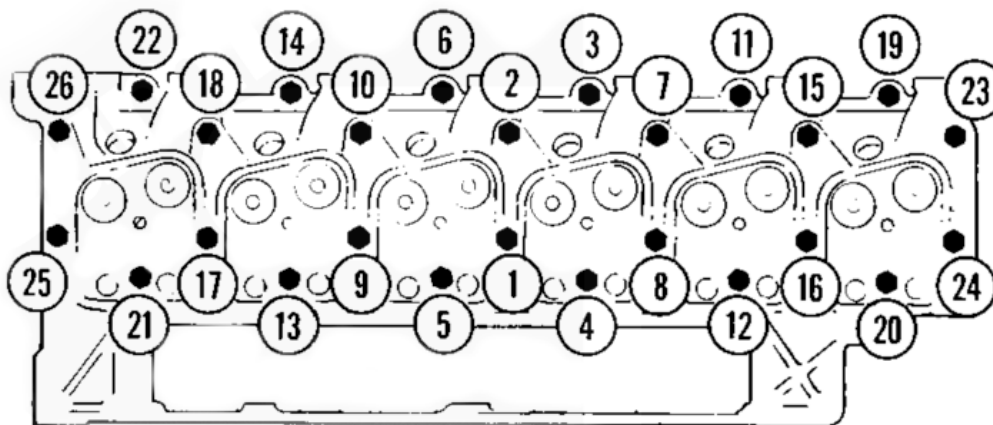


POWER DRIVEN DIESEL I2V HEAD BOLTS

Installation Instructions

Kit Contents:

- 6x Short Bolts (for locations 3, 6, 11, 14, 19, 22)
- 14x Medium Bolts (for locations 1, 2, 7, 8, 9, 10, 15, 16, 17, 18, 23, 24, 25, 26)
- 6x Long Bolts (for locations 4, 5, 12, 13, 20, 21)
- 20x Washers (for all locations EXCEPT 4, 5, 12, 13, 20, 21)
- 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 injection lines and valve covers.
3. Select correct length of new PDD head bolt and apply lubricant.
 - a. Lubricate threads and both sides of washer.
 - b. **Chamfered side of washer must be in contact with the bolt head.**
 - c. DO NOT use washers on rocker tower bolts (4, 5, 12, 13, 20, and 21).
4. Remove one factory head bolt (reference torque sequence for proper order of replacement).

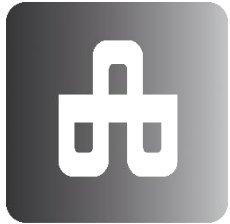


**POWER DRIVEN
DIESEL**

- 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 injection lines and valve covers.

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

1. Ensure all bolt holes in block are clean.
2. Select correct length of new PDD head bolt and apply lubricant.
 - a. Lubricate threads and both sides of washer.
 - b. Chamfered side of washer must be in contact with the bolt head.**
 - c. DO NOT use washers on rocker tower bolts (4, 5, 12, 13, 20, and 21).
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 and with the engine cold. Always follow your engine builder's advice on retorque procedures.



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