WARNINGS:
The depths of the primary head bolt holes in Chevrolet 4.8L, 5.3L and 6.0L blocks changed in 2004 so therefore the head bolts and torque specifications required also changed.

This particular block is the 2/2004 & later style that requires (10) 4” medium head bolts for each cylinder head.  This cylinder block does not use 6” long bolts as required for the early style block.

Head Bolt Torque (for OEM head bolts only, if using performance bolts/studs refer to the manufacturer’s specifications): refer to the diagram below for bolt position and torquing sequence

11mm bolts, (1-10) 1st step: 22 ft/lbs
   2nd step: (1-10) turn additional 90 degrees
   3rd step: (1-10) turn additional 70 degrees
8mm bolts, (11-15) 22 ft/lbs, apply liquid teflon paste or similar sealant to these bolts

Main Cap Orientation: caps 1-4 install with the wide section/protrusions of the caps “pointing” to the rear of the engine and cap 5 installs with the wide section of the cap “pointing” to the front of the engine. The main bearing locating grooves do NOT always line up on the same side of the engine like a typical 350 Chevy does, they will be opposite on some positions.