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engines, (i. e. GM uses 1.6L VIN 6) these engines that are manufactured by four different engine companies, Daewoo, Isuzu, Suzuki & Toyota. Others such as the Ford 5.0L VIN F have seven different records according to years used. Those different records are necessary as engine specifications or castings changed significantly

Cylinder Head and Block Manual April 2006

Technical Resource Manual This manual was created from technical articles that were published in Engine Professional magazine. The AERA Technical Department reviewed the first 10 years of the magazine, selected articles they felt would be beneficial to the machine shop, and created this manual.

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Engines. AERA Torque Specs 4 . Locate the specific engine desired . Correct torque specifications are shown in foot-pounds in bold type . Torque specifications are shown either as an exact figure, or a specific range . Follow any special instructions or multi-step directions carefully to assure correct

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© AERA Engine Builders Association. All rights reserved. Follow the detailed 9 steps below to correctly tighten the main bearing bolts using a 12MM socket wrench. 1. TORQUE ALL BOLTS IN SEQUENCE TO 26 FT/LBS 2. LOOSEN ALL BOLTS IN SEQUENCE 180° 3. TORQUE ALL BOLTS IN SEQUENCE TO 26 FT/LBS 4. LOOSEN 4 BOLTS IN SEQUENCE 180° 5.

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Engine Torque Specs Engine Bolt Torque Specs... Alternately tighten new torque-to-yield bolts in several passes to 40-45 N-m (30-33Lb-Ft). Rotate bolts an additional 90-120 degrees. (3) Tighten in sequence in two steps: Tighten to 7-12 N-m (62-106 Lb-In). Tighten to

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