

Enginetech Inc
Tech Assistance 800-410-3664 ext. 340 or 237

TECHNICAL BULLETIN	
	November 1998 TB 1624
Mfg:	GM
Model:	CORVETTE
Liter:	5.7L
V I N:	G
Year:	97-04

Revised Cylinder Head Torque Procedure On
1997-99 GM 5.7L VIN G Engines

The AERA Technical Committee offers the following information on a revised cylinder head torque procedure on 1997-99 GM 5.7L VIN G engines. This procedure should be used anytime the cylinder head is being installed and supersedes information found in 1997-99 service manuals. This engine has an aluminum cylinder head and block and is referenced as the LS1 or Corvette engine.

The reason this procedure has been revised is the bolt material has been modified, which allows additional clamping force. The 11 mm head bolts should be replaced at the time of cylinder head installation and the new bolts come with a pre-applied sealer and lubricant.

1. Tighten new 11 mm bolts (1-10) in sequence to 22 ft/lbs (30 N.m).
2. Rotate those bolts (1-10) in sequence an additional 90° turn using a torque angle meter.
3. Rotate only bolts 1-8 in sequence an additional 90° turn using a torque angle meter.
4. Rotate remaining 11 mm bolts 9 & 10 in sequence an additional 50° turn using a torque angle meter.
5. Apply a .200" (5 mm) bead of locking compound (GM P/N 12345382 or equivalent) to 8 mm bolt threads, and tighten bolts (11-15) in sequence to 22 ft/lbs (30 N.m).

Note: Do not re-use 11mm bolts.

The AERA Technical Committee

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Reference:	
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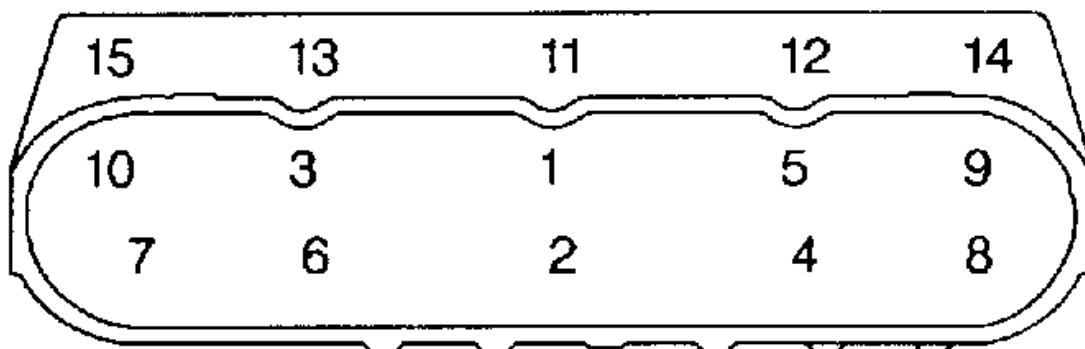


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Bulletin Diagram: FIGURE 1, CYLINDER HEAD BOLT TORQUE SEQUENCE - CYLINDER HEAD



Cylinder Head Bolt Locations

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