

Enginetech Inc
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TECHNICAL BULLETIN	
	August 2003
	TB 1952R
Mfg:	GM
Model:	PONTIAC
Liter:	3.8L
V I N:	K
Year:	95-06

Updated Cylinder Head Installation Procedure For
1995-2002 GM 3.8L VIN 1 & K Engines

The AERA Technical Committee offers the following information regarding cylinder head installation for 1995-2002 GM 3.8L VIN 1 & K engines. This bulletin should be used and AERA TB 1952 should be discarded. Various other published service information has been incomplete and this bulletin provides the most up to date information.

The cylinder head bolts used for these engines were designed for a one time use and should be replaced anytime the heads are re-installed. Failure to replace the bolts during head installation will yield an improper assembled torque.

Follow the procedure listed below to install new head bolts on these engines. It is suggested a torque angle meter J36660 (or equivalent) be used.

1. Thoroughly clean the threads in the block using a 7/16–14 tap.
2. Install the head gasket with the arrow pointing to the front of the engine.
Figure 1. Cylinder Head Torque Sequence
3. Install the new cylinder head bolts dry. NOTICE: This bolt is designed to permanently stretch when tightened. The correct part number fastener must be used to replace this type of fastener. Do not use a bolt that is stronger in this application. If the correct bolt is not used, the parts will not be tightened correctly. The system or the components may be damaged.
Step 1. Tighten all bolts in sequence to 35-37 ft/lbs (49-50 Nm).
Step 2. Rotate each bolt 130° in sequence. Use the J36660.
Step 3. Rotate the center four bolts 1,2, 3 & 4 an additional 30°. Use the J36660.

The AERA Technical Committee

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Reference:	
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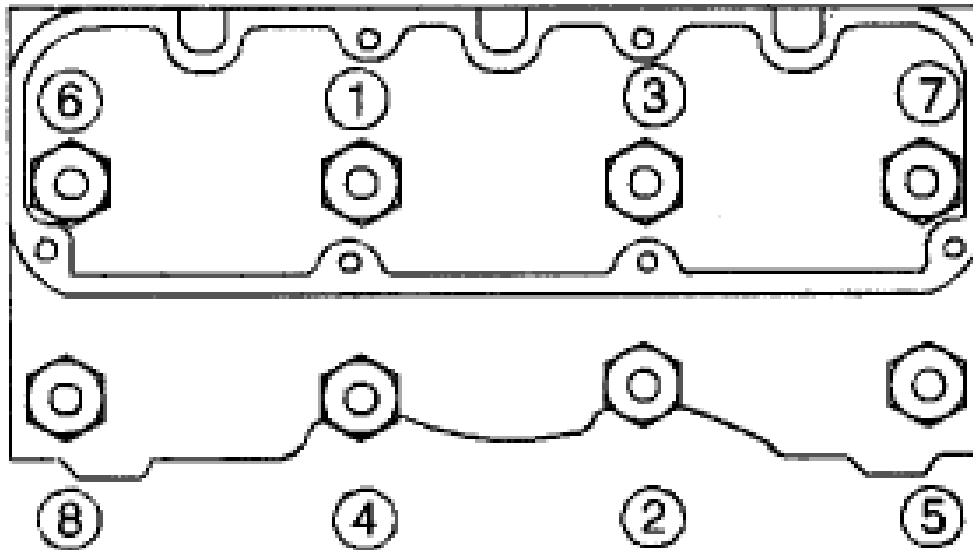
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Bulletin Diagram: FIGURE 1, CYLINDER HEAD TORQUE SEQUENCE. - CYLINDER HEAD



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