

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

TECHNICAL BULLETIN	
	July 2002 TB 1993
Mfg:	GM
Model:	C-SERIES
Liter:	6.0L
V I N:	U
Year:	99-06

Revised Cylinder Head Installation Procedure For
1999-2002 GM 4.8, 5.3 & 6.0L VIN V, T, Z, S, U & N Engines

The AERA Technical Committee offers the following information on a revised cylinder head installation procedure for 1999-2002 GM 4.8 5.3 6.0L VIN V, T, Z, S, U & N engines. This procedure should be used any time the cylinder head is being installed and supersedes information found in earlier published service manuals.

Previously, it was published in service information that it was acceptable to reuse the 8 mm cylinder head bolts. It is now recommended all cylinder head bolts should be replaced at the time of cylinder head installation. The new 11 mm bolts come with a pre-applied sealer and lubricant and no other sealant should be used on them.

1. Tighten new 11 mm bolts (1-10) in sequence to 22 ft/lbs (30 Nm).
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 the new 8 mm bolt threads, and tighten bolts (11-15) in sequence to 22 ft/lbs (30 Nm).

AERA is unaware of an aftermarket supplier for these bolts.

Note: Do not re-use either the 8mm or 11mm head bolts.

The AERA Technical Committee

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Reference:	
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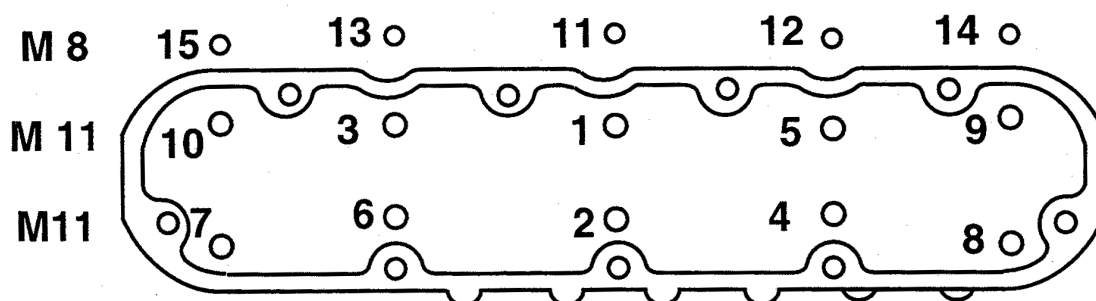


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Bulletin Diagram: FIGURE 1, CYLINDER HEAD BOLT TORQUE SEQUENCE - CYLINDER HEAD



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