



## **Block Girdle Installation**

*GSR/Type R B18C*

**Part #: Z10-2002**

*\*Special tool required for installation:*

*.510" diameter ream (+ .0000 / -.0005)*

1. Remove oil pan.
2. Remove oil pump pickup.
3. Remove windage tray.
4. Loosen all main bolts on caps 1, 2, 3, 4 & 5. Remove main bolts only on main caps 2, 3 & 4.
5. Remove stock girdle and cap assembly from engine.
6. Remove stock girdle from caps (may require slight prying of caps to separate).
7. \* Ream cap bolt holes in caps 2 & 4. Ream hole to a diameter of .510" and a depth of .560" from top of cap.
8. Coat new dowel pins with anti-seize compound, then install new dowel pins in caps (dowel should require slight press to install).
9. Re-install caps 2, 3 & 4 on block.
10. Place Z10 Block Girdle on top of main caps 2, 3 & 4. Be sure that the 2 notches are on the exhaust side, and that the bosses for the oil pump pickup remain on the oil pump side (may require slight tapping of girdle to seat).
11. Coat the threads of the GSR main bolts with oil and hand-tighten them into main caps 2, 3 & 4.
12. Tighten the caps **FOLLOWING** this sequence:
  - 1) Tighten all bolts to 22-lbs/ft.
  - 2) Tighten caps 1 & 5 to 56 lb/ft, and caps 2, 3 & 4 to 50 lb/ft.
13. Loosen caps 2, 3 & 4 and re-torque to 50 lb/ft. (Recommended line bore be checked at this step, prior to completion of assembly. If found to be within spec engine assembly can be completed).
14. Place GSR windage tray on the block. Bolt in.
15. Place GSR oil pump pickup on the oil pump and girdle. Bolt in.
16. Place GSR oil pan on the block using a new oil pan gasket. Torque oil pan bolts to 10 ft/ft.

*Installation is now complete.*