



# INSTRUCTION MANUAL

## CHEVROLET BIG BLOCK MARK IV HEX HEAD BOLT KIT

PART NUMBER XP980

FITS DART IRON, ALUMINUM LATE BOWTIE  
PRO-1/PRO TOPLINE & WORLD PRODUCTS HEADS

### GET TO ACTION!

1. Before installing any components, please check for any product damage, and report to us accordingly.
2. Clean the threads in the block prior to installing the bolts to ensure proper fitment and accurate torque readings. You may purchase our thread chasers separately by searching [CS314](#) in our catalog.
3. Clean the washer seating areas on the cylinder head using a fast-evaporating solvent like non-chlorinated brake cleaner to remove oil, grease, and contaminants. Ensuring a clean surface is essential for achieving proper fastener preload.
4. Install the head gasket and cylinder head.
5. Seat the washers on the cylinder head. Ensure that the chamfered side of the washer faces upward (toward the bolt head).
6. Inspect for any misalignment.
7. Using the fastener assembly lubricant included in the package, apply lubricant to the threads of each head bolt, and the underside of the bolt heads.
8. Hand-tighten the bolts until they are snug.
9. Using the torque recommendations below, tighten the bolts in the following sequence:

FIRST TO 23 FT-LBS, THEN TO 46 FT-LBS, AND FINALLY TO 70 FT-LBS.



#### KIT INCLUDES



**32 X** HEAD BOLTS



**32 X** HARDENED PARALLEL  
WASHERS



**1 X** FASTENER ASSEMBLY  
LUBRICANT



**1 X** SOCKETS



SCAN ME

#### NEED HELP?

For technical support, please email:  
[tech@xotic-performance.com](mailto:tech@xotic-performance.com)



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#### WORKING ON AN EXCITING NEW PROJECT?

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