



**KIT INCLUDES**

 **20 X** HEAD BOLTS

 **20 X** HARDENED PARALLEL WASHERS

 **1X** FASTENER ASSEMBLY LUBRICANT

 **1X** SOCKET

# INSTRUCTION MANUAL

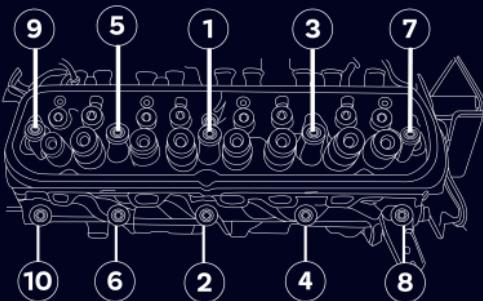
## HEAD BOLT KIT FOR FORD SMALL BLOCK 289-302

PART NUMBER XP985 | 1963-2001

### 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 accurate fitment and precise torque readings. You may purchase a thread chaser separately by searching [CS314](#) in our catalog.
3. Using a clean cloth, remove all oil from the washers, and the surface of the cylinder head where the washers are placed. Cleaning debris will ensure accurate preloads.
4. Install the head gasket and cylinder head.
5. Seat the washers on the cylinder head. The inner diameter of the chamfer side should be facing the ceiling.
6. Inspect for any misalignment.
7. Using the fastener assembly lubricant included in the package, lubricate the threads of the head bolts and the underside of each bolt.
8. Install the bolts as tight as can be made by hand.
9. Using the torque recommendations below, tighten the bolts in the following sequence:

Tighten to a final torque of **80 ft-lbs** in three equal steps:  
First to **25 ft-lbs**, then to **50 ft-lbs**, and finally to **80 ft-lbs**.



SCAN ME

#### NEED HELP?

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



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