



General Instructions for Big Block Chevy Compatible Blocks

WARNING!

PLEASE CHECK THE BLOCK THOROUGHLY IN EVERY POSSIBLE WAY. IF YOU SUSPECT A DEFECT, CONTACT BRODIX, INC. OR THE DEALER IT WAS PURCHASED FROM BEFORE ANY WORK HAS BEGUN. BRODIX® WILL NOT BE RESPONSIBLE FOR VISIBLE DEFECTS AFTER ANY WORK HAS BEEN STARTED.

INSPECT THE BLOCK FOR DAMAGE FROM SHIPPING. INSPECT THE BLOCK OIL PASSAGES AND THREADED HOLES.

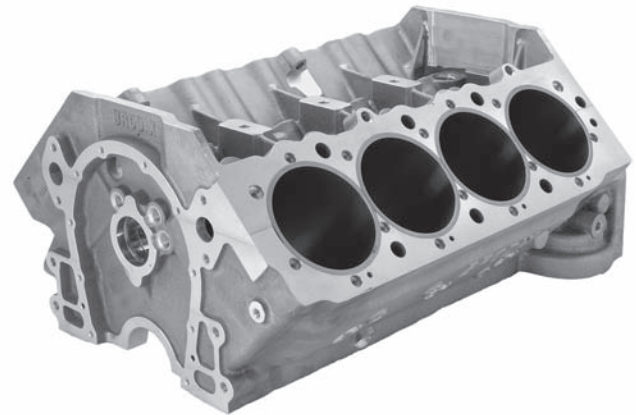
WARNING!

THE SLEEVES ARE LEFT ABOVE THE DECK OF THE BLOCK INTENTIONALLY. IT IS THE ENGINE BUILDER'S PREFERENCE WHETHER OR NOT TO SURFACE THE SLEEVES FLAT WITH THE DECK OF THE BLOCK.

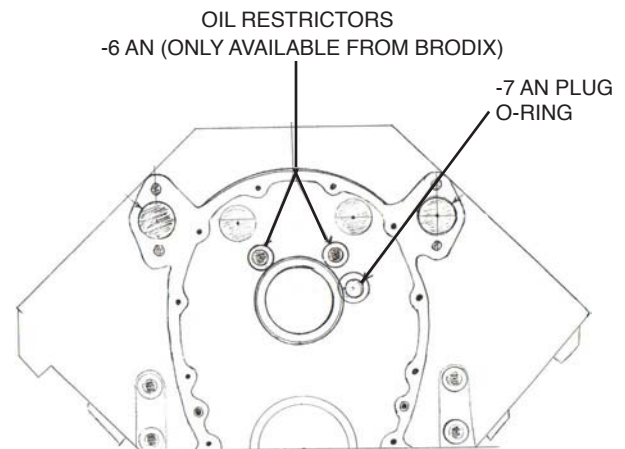
ALL PLUGS, LOCKS, AND SCREWS MUST HAVE ANTI-SEIZE ON THE THREADS.

- The sleeves must be clearanced before initial installation of crank and rods.
- The block must be align honed and checked for bearing clearance.
- The cylinders must be finish bored and honed.
- You must check clearance before the final installation of crank, rods, pistons, and cam in the block.
- Wash the block thoroughly with soap and water, and blow dry with air.
- Install the rear cam plug with the o-ring and snap ring in place.
- Install all required water and oil plugs.
- Apply anti-seize to all main and head stud threads before installation. Hand tighten only.
- It is recommended that a 3/8 x 4 1/2 allen head cap screw is used in starter bolt location. This length allows proper thread engagement.

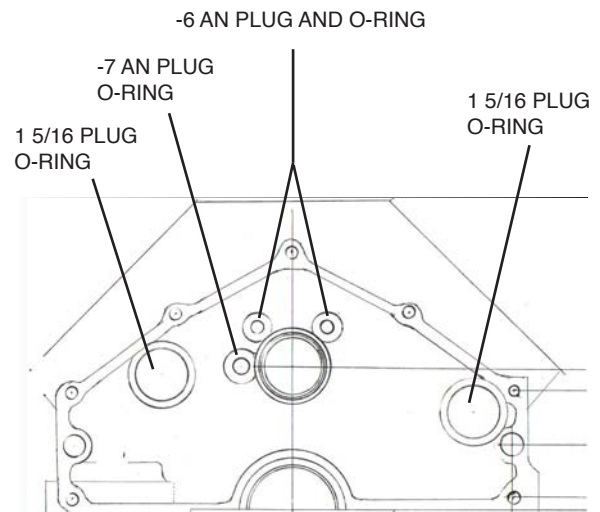
The BRODIX® babbit cam bearing, part number FM 1874, uses three 1/4 inch allen head cap screws to lock the center three bearings in place. The allen head cap screws must be fitted for the proper length. The front and the rear bearing will use spiral locks. Roller bearings are held into place on both sides with spiral locks.



**IF YOU NEED TECHNICAL ASSISTANCE,
CALL (479) 394-1075**



Thank You For Buying BRODIX!



ORDER, TECH, AND INFORMATION: (479) 394-1075 • FAX: (479) 394-1996



301 MAPLE AVENUE • P.O. BOX 1347 • MENA, AR 71953

www.brodix.com

CAM LOCATION AND SPECS

- STANDARD CAM LOCATION
- RAISED CAM LOCATION .400
- AVAILABLE WITH ROLLER CAM BEARINGS
- REQUIRES SPECIAL CAM BEARINGS AVAILABLE FROM BRODIX
- 55 mm ROLLER CAM BEARINGS AVAILABLE
- 60 mm BABBIT BEARINGS AVAILABLE

ACCESSORIES

- AVAILABLE WITH ALL IRON BLOCK ACCESSORIES DIRECT REPLACEMENT
- STARTER BOSS ON RIGHT SIDE
- OIL FILTER IN STANDARD LOCATION
- SPECIAL HEAD STUDS AVAILABLE FROM BRODIX
- PLUG KITS INCLUDED FOR BLOCKS
- INTERNAL HEAD STUD LUG INCLUDED

MAIN CAPS

- STANDARD BIG BLOCK MAINS
- BILLET STEEL MAIN CAPS STANDARD
- 12 POINT MAIN STUD NUTS
- ALIGN HONE AVAILABLE
- ALL CAPS ARE WET SUMP - MUST BE PLUGGED TO RUN DRY SUMP

HEIGHTS OF BLOCKS

- 9.800 - 10.200 STANDARD BLOCK
- 9.800, 10.200, OR 10.700 RAISED CAM
- 11.100 - 11.200 RAISED CAM
- 11.500 - 11.625 RAISED CAM

TORQUE SPECS

- CENTER 95 ft-lb
- OUTSIDE 85 ft-lb
- VALLEY LUG BOLTS 50 ft-lb
- TORQUE WITH 30W MOTOR OIL

STROKE CLEARANCE

- STANDARD CAM LOCATION - 4.750
- RAISED CAM LOCATION 4.750 WITH SLEEVE NOTCH, 5.00 WITH SOME BLOCK CLEARING AND SLEEVE NOTCH
- PAN RAIL DRILLED FOR DUAL PATTERN (STD & WIDE)

SLEEVES

- 4.250 i.d. MAX BORE 4.500
- STANDARD o.d. 9.800 DECK 4.725 X 6.300
- STANDARD o.d. 10.200 DECK 4.725 X 6.600
- STANDARD o.d. 11.100 & 11.200 DECK 4.725 X 7.100
- STANDARD o.d. 11.500 & 11.625 DECK 4.725 X 7.600
- STANDARD o.d. 10.700 DECK RAISED CAM 4.725 X 7.100
- REPAIR SLEEVES AVAILABLE
- SMALLER o.d. SLEEVES AVAILABLE 4.695 X 6.300 OR 4.695 X 6.600

BLOCK PART NUMBERS

8B 2000 A

- 4.230 BORE, STD CAM LOCATION, 9.800 DECK HEIGHT
- 4.480 BORE, STD CAM LOCATION, 9.800 OR 10.200 DECK HEIGHT
- 4.590 BORE, STD CAM LOCATION, 9.800 OR 10.200 DECK HEIGHT

8B 2000 C

- 4.480 BORE, RAISED CAM LOCATION, 9.800, 10.200, OR 10.700 DECK HEIGHT
- 4.590 BORE, RAISED CAM LOCATION, 9.800, 10.200, OR 10.700 DECK HEIGHT

8B 2100 C

- 4.480 BORE, RAISED CAM LOCATION, 11.100 OR 11.200 DECK HEIGHT
- 4.590 BORE, RAISED CAM LOCATION, 11.100 OR 11.200 DECK HEIGHT

8B 2200 C

- 4.480 BORE, RAISED CAM LOCATION, 11.500 OR 11.625 DECK HEIGHT
- 4.590 BORE, RAISED CAM LOCATION, 11.500 OR 11.625 DECK HEIGHT

MUST SPECIFY DECK HEIGHT, CAM BEARING STYLE, LIFTER SIZE, BORE SIZE, LENGTH OF STROKE, AND CAM LOCATION.

MAIN CAPS

8B MC 454 ST-S-C-GO
8B MC 454 ST-S-C-PF
8B MC 454 ST-S-F-GO
8B MC 454 ST-S-F-PF
8B MC 454 ST-S-R-GO
8B MC 454 ST-S-R-PF

MAIN STUDS AND NUTS

8B MS 4.650 1/2
8B MS 4.050 1/2
8B MS 4.250 1/2

SLEEVES

8B SL 44-315: 4.230 i.d., 4.695 o.d., 6.000 o.a.l.
8B SL 44-318: 4.480 i.d., 4.725 o.d., 6.300 o.a.l.
8B SL 44-317: 4.480 i.d., 4.725 o.d., 6.600 o.a.l.
8B SL 44-322: 4.480 i.d., 4.725 o.d., 7.100 o.a.l.
8B SL 44-500; 4.590 i.d., 4.725 o.d., 7.600 o.a.l.

OTHER SIZES AVAILABLE,

CALL FOR DIMENSIONS AND PART NUMBERS

HEAD STUDS

SK HS BIG BLOCK
SK HS BIG BLOCK DART
SK HS BIG DUKE
SK HS PB 2005 / 1200
SK HS BIG BLOCK RR

PLUGS AND O-RINGS

8B PLUG BLOCK L
8B O-RING BLOCK PLUG
8B PLUG 814-6C
8B PLUG 814-7C
8B O-RING / RCAM PLUG BB
8B O-RING / RCAM PLUG 55

DOWELS

8B DOW TC FRONT
8B HEAD DOW BB
8B DOW BH 1.25
8B DOW RING BB
8B DOW PULL

CAM PLUGS

8B RCAM PLUG 55
8B RCAM PLUG BB
(SNAP RINGS AND
SPIRAL LOCKS)
8B RCAM BB RING
8B SPIRAL LOCK BB
8B SPIRAL LOCK 55
8B SPIRAL LOCK RB

CAM BEARINGS

8B CAM BEARINGS STD BB
8B CAM BEARINGS 55 mm
8B CAM BEARINGS 60 mm BABBIT
8B CAM BEARINGS BB 50 mm

OIL RESTRICTORS

8B BB OIL RESTRICTORS
(CUSTOM FOR BRODIX
BLOCK)

WARRANTY DISCLAIMER

No warranties of any nature (expressed, implied, fitness of usage or merchantability) are given on these products. Seller undertakes no responsibility for any product sold. Additional disclaimers are within and are binding upon this contract. Due to the intended usage of products offered, all products are sold on an "as-is" basis, and no warranties of any kind, whether written or oral are made by BRODIX, Inc., its agents or employees. All implied warranties, including the implied warranties of merchantability and fitness are expressly excluded, and the buyer bears the entire risk as to quality performance and use of these products. BRODIX, Inc. will assume no responsibility of personal injury, labor or other injury arising out of the usage of high performance racing parts or products. Any defective part will be handled between the original manufacturer and the buyer. BRODIX, Inc. reserves the right to change specifications, prices and discontinue parts without notice. Installation of BRODIX heads may adversely affect the vehicle manufacturer's warranties, and may violate State and Federal laws when vehicles so equipped are operated other than strictly off-highway. BRODIX reserves the right to discontinue any product at its sole discretion and without any liability with respect to similar products already in the field. Some parts are not legal for sale or use on pollution controlled motor vehicles.

WHILE OUR PRODUCTS ARE USED ON MANY SUPER-CHARGED APPLICATIONS SUCCESSFULLY, PLEASE BE AWARE THAT THERE IS A GREATER POTENTIAL FOR ENGINE DAMAGE DUE TO THE POSSIBILITY OF TUNING ERRORS.

PRICES ARE SUBJECT TO CHANGE WITHOUT NOTICE. ALWAYS CONFIRM PRICE WHEN PLACING YOUR ORDER. WE WILL MAKE EVERY EFFORT TO KEEP YOU INFORMED OF INCREASES.

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