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SMALL BLOCK BRODIX CAST IRON ENGINE BLOCK INSTRUCTIONS

PART#		BORE	LIFTER	DECK	REAR SEAL	MAINS	MAIN CAPS
BR S400035842S	SIAMESE	4.000	.842	9.025	2-Piece	350	4-Bolt Nodular
BR S400035842W	WET	4.000	.842	9.025	2-Piece	350	4-Bolt Nodular
BR S412535842S	SIAMESE	4.125	.842	9.025	2-Piece	350	4-Bolt Nodular
BR S412540842S	SIAMESE	4.125	.842	9.025	2-Piece	400	4-Bolt Nodular

Block Applications: BRODIX blocks are designed as a replacement and upgrade of GM small block Chevrolet blocks

Block Material: Premium iron alloy

Oil System Features: Priority main oiling system - the main bearings get oil directly from the oil pump before anything else receives oil. Block is restricted from the front oil galleys.

Deck Height: 9.025

Cam Bearings: Blocks have the same cam housing bore on all five journals; this requires the use of Durabond GMP-8 or equivalent small block Chevy cam bearings NOTE: When installing cam bearings MAKE SURE the oil hole in the bearings is in line with the oil feed hole to the main bearings

Main Bearings: Utilizes standard small block 350 or 400 Chevrolet style main bearings (depending on the part number)

Main Caps: Ductile iron - middle three caps are 4-bolt splayed, all center main bolts use a 7/16 -14 bolt/ All outer main bolts use a 3/8 -16 bolt. Torque specs on main bolts are 75 ft-lb on the inner and 35 ft-lb on the outer with oil; front and rear caps torque at 75 ft-lb

Lifter Bores: Lifter bore size comes .843 +/- .0003 unless other sizes are specifically ordered. A +300 taller lifter is required. Always check for proper lifter clearance before lifter installation (different manufacturer's lifters will vary in size).

Maximum Bore: All 4.000 blocks can be bored to a maximum of 4.060; all 4.125 blocks can be bored to a maximum of 4.180

Freeze Plugs: Stainless steel cup plug installed

Timing Cover: Block will accept an early 10-bolt timing cover. Always check for proper clearance if running a gear or belt drive. Always check for interference with pipe plugs.

Dipstick: Passenger side dipstick only, 1981 to 1985 style for 2-piece rear main seal blocks

Oil Bypass: Integral to the oil filter adapter

Fuel Pump: Standard provision for mechanical fuel pumps utilizing a standard length fuel pump pushrod

Filtration: The oil filter mounting boss is designed for bolt-on oil filter adapter.

Oil Pan Rails: Blocks are clearanced for up to a 3.750 stroke crankshaft with steel rods; any larger stroke may need more clearance, always check before final assembly

Camshaft: Stock location

Starter: Starter mounting pad is drilled for two different bolt patterns

Motor Mounts: Drilled and tapped for side and front mounts in OEM locations

Distributor: Standard length is used, always check for proper engagement

Block Weights: 168 lb to 172 lb

Align Hone: Will come undersized, must be align honed for crankshaft clearance

Block Kits: BRODIX offers a block kit containing dowel pins, cam bearings, rear cam plug, and oil restrictors if needed (please consult your salesman)

Oil Pan Gasket: Fel-Pro 1818 or Fel-Pro 1881

Timing Chain Gasket: Fel-Pro 2335

Rear Main Seal: 350 - Fel-Pro 2900, 400 - Fel-Pro 2909

Head Gaskets: Fel-Pro Composite- FP 1003 or FP 1004 (depending on bore size)

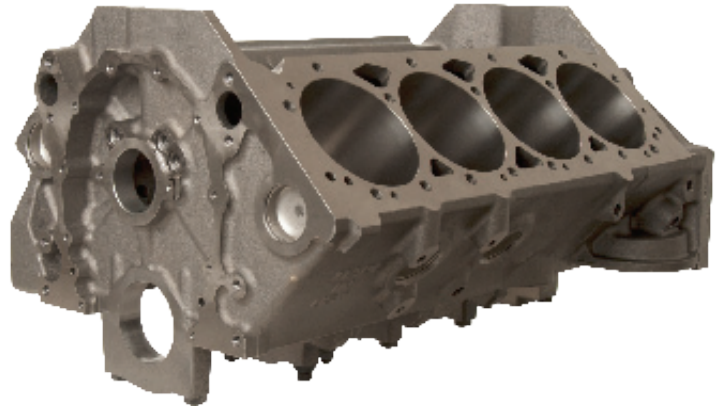
Cometic MLS- CO C5399 (4.030 Bore), CO C5400 (4.125 Bore), CO C5401 (4.135 Bore),
CO C5402 (4.160 Bore), CO C5403 (4.200 Bore)



Thank You For Buying BRODIX!

IF YOU NEED TECHNICAL ASSISTANCE, CALL

(479) 394-1075



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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.

Important Notice

This instruction sheet has been completed using our best efforts. We assume no liability for errors contained herein. Our website is updated on a regular basis and can be used to supplement the information contained herein.

It is the responsibility of the installer to ensure that all of the products are correct before installation. Proper assembly always requires that the installer measure all tolerances for proper clearance. We assume no liability for any errors made in product selection or installation

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