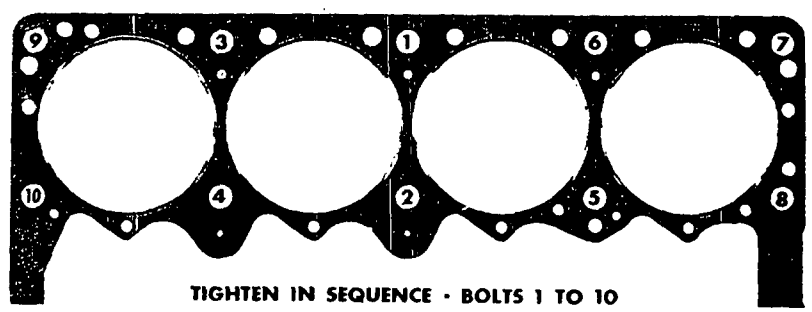
S.A.E. GRADE AND BOLT CHART

FIGURE 7

S.A.E. GRADE	1 or 2	5	6	8	RECOMMENDED FOR COMPETITION AND CRITICAL USE
1/4 DIA.	5 Ft. lbs.	7 Ft. lbs.	10 Ft. lbs.	10.5 Ft. lbs.	11 Ft. lbs.
5/16 "	9 "	14 "	19 "	22 "	24 "
3/8 "	15 "	25 "	34 "	37 "	40 "
7/16 "	24 "	40 "	55 "	60 "	65 "
1/2 "	37 "	60 "	85 "	92 "	97 "
9/16 "	53 "	88 "	120 "	132 "	141 "
5/8 "	74 "	120 "	167 "	180 "	192 "
3/4 "	120 "	220 "	280 "	286 "	316 "
7/8 "	190 "	302 "	440 "	473 "	503 "
1 "	282 "	466 "	660 "	714 "	771 "



TIGHTEN IN SEQUENCE · BOLTS 1 TO 10

FIGURE 8

cork/rubber is the preferred material because it possesses the compressive characteristics of cork and the dimensional stability of rubber. These gaskets will not shrink, crack or become brittle in storage. Cork/rubber gaskets will seal tight without spreading, and need not be glued to the cover to prevent gasket slippage. Victor cork/rubber gaskets are durable, impervious to liquids and withstand the high heat ranges found in today's engines. This material is most suitable for valve cover, push rod cover and oil pan applications.

Victor Rubber gaskets also may be used on valve cover, push rod cover and oil pan applications. Because of the characteristics of rubber, however, additional care should be exercised during installation. Since rubber will not envelop or absorb foreign particles, mating surfaces must be *thoroughly* cleaned and trued before installation. In addition, most rubber gaskets must be positioned on the application by the use of small, quarter-inch droplets of common trim cement spaced at two-inch intervals on the gasket.

Installation procedures for valve cover and push rod cover gaskets are as follows:

- Clean all surfaces on cover and block.
- Check cover for dents or unevenness by placing it on the head without a gasket and checking for rocking action. Straighten any irregularities with a hammer while the flange is secured to a flat narrow bar stock.
- Check the fit and alignment of the gasket; when using a rubber gasket, it is necessary to glue the gasket to prevent slippage.
- Uniformly, tighten the bolts to the manufacturer's recommended specifications to insure proper seating and sealing of the gasket.

A simple rule of thumb is that a gasket expected to function under extreme heat and pressure is generally metal or a metal core-supported composition sheet; a gasket sealing a standing fluid under controlled loading is usually a treated sheet stock; and a gasket expected to seal a splashing fluid under lightly loaded conditions is usually cork/rubber, cork or rubber.

Good gasket design requires extensive research and development engineering. However, even the finest gasket design will perform only as well as it is installed.

By following these procedures and paying strict attention to manufacturers' specifications, you can perform long lasting and trouble-free sealing jobs. ●