

ENGINE

Engine Mechanical - 6.2L (LT1) - Specifications - Corvette

SPECIFICATIONS

FASTENER TIGHTENING SPECIFICATIONS

Fastener Tightening Specifications

Application	Specification	
	Metric	English
Accessory Drive Belt Tensioner Bolt - Lower	22 N.m	16 lb ft
Accessory Drive Belt Tensioner Pulley Bolt	58 N.m	43 lb ft
Automatic Transmission Flex Plate Bolts ¹		
• First Pass ¹	15 ¹	11 lb ft ¹
• Second Pass ¹	30 N.m ¹	22 lb ft ¹
• Final Pass 1	45 degrees ¹	
Flywheel Bolts		
• First Pass	30 N.m	22 lb ft
• Final Pass	45 degrees	
Camshaft Position (CMP) Actuator Magnet Bolts	10 N.m	88 lb in
Camshaft Position (CMP) Actuator Solenoid Valve ¹		
• First Pass ¹	65 N.m ¹	48 lb ft ¹
• Final Pass ¹	90 degrees ¹	
Camshaft Position (CMP) Sensor Bolt	25 N.m	18 lb ft
Camshaft Position (CMP) Sensor Wire Harness Bolt	25 N.m	18 lb ft
Camshaft Retainer Bolts - TORX Head Bolts	15 N.m	11 lb ft
Connecting Rod Bolts ¹		
• First Pass ¹	20 N.m ¹	15 lb ft ¹
• Final Pass ¹	85 degrees ¹	
Coolant Temperature Sensor	20 N.m	15 lb ft
Crankshaft Balancer Bolt - Installation Pass with Used Bolt - to Ensure the Balancer is Completely Installed	330 N.m	243 lb ft
Crankshaft Balancer Bolt - New Bolt P/N 11570046 ¹		
• First Pass ¹	150 N.m ¹	111 lb ft ¹

• Second Pass ¹	Loosen 360 degrees ¹	
• Third Pass ¹	80 N.m ¹	59 lb ft ¹
• Final Step ¹	200 degrees ¹	
Crankshaft Bearing Cap Bolts ¹		
• Inner Bearing Cap Bolts - First Pass in Sequence ¹	20 N.m ¹	15 lb ft ¹
• Inner Bearing Cap Bolts - Final Pass in Sequence ¹	110 degrees ¹	
• Outer Bearing Cap Bolts - First Pass in Sequence ¹	20 N.m ¹	15 lb ft ¹
• Outer Bearing Cap Bolts - Final Pass in Sequence ¹	80 degrees ¹	
• Bearing Cap Side Bolts - First Pass in Sequence	30 N.m ¹	22 lb ft ¹
• Bearing Cap Side Bolts - Final Pass in Sequence	60 degrees ¹	
Crankshaft Oil Deflector Bolts	10 N.m	88 lb in
Crankshaft Position (CKP) Sensor Bolt	25 N.m	18 lb ft
Crankshaft Rear Oil Seal Housing Bolts	25 N.m	18 lb ft
Cylinder Head Bolts ¹		
• Cylinder Head Bolts - Internal Hex - First Pass in Sequence ¹	80 N.m ¹	59 lb ft ¹
• Cylinder Head Bolts - Internal Hex - Second Pass in Sequence ¹	90 degrees ¹	
• Cylinder Head Bolts - Internal Hex - Final Pass in Sequence ¹	40 degrees ¹	
• Short Bolts Final Pass in Sequence ¹	55 degrees ¹	
• Cylinder Head Bolts - First Pass in Sequence ¹	80 N.m ¹	59 lb ft ¹
• Cylinder Head Bolts - Second Pass in Sequence ¹	90 degrees ¹	
• Cylinder Head Bolts - Final Pass in Sequence ¹	60 degrees ¹	
Engine Block Coolant Drain Hole Plug	60 N.m	44 lb ft
Engine Block Coolant Heater	50 N.m	37 lb ft
Engine Block Oil Gallery Plugs	30 N.m	22 lb ft
Exhaust Manifold Bolts		
	23 N.m	17 lb ft

cylinder head		
• Exhaust Manifold Bolts- If installing on NEW cylinder head	27 N.m	20 lb ft
Exhaust Manifold Heat Shield Bolts	10 N.m	88 lb in
Front Cover Bolts	25 N.m	18 lb ft
Low Pressure Fuel Feed Pipe to Rocker Arm Cover Bolt	10 N.m	88 lb in
Fuel Pump Bolts	25 N.m	18 lb ft
High Pressure Fuel Feed Pipe Fittings ¹	30 N.m ¹	22 lb ft ¹
Low Pressure Fuel Feed Pipe to Rocker Arm Cover Bolt	10 N.m	88 lb in
Fuel Injection Fuel Rail Bolts	25 N.m	18 lb ft
Fuel Injection Fuel Rail Crossover Pipe Bolt	10 N.m	88 lb in
Generator Bracket Bolts	50 N.m	37 lb ft
Ignition Coil Bracket-to-Valve Rocker Arm Cover Bolts	10 N.m	88 lb in
Intake Manifold Bolts		
• First Pass in Sequence	5 N.m	44 lb in
• Final Pass in Sequence	10 N.m	88 lb in
Intake Manifold Cover Studs	4.5 N.m	40 lb in
Intake Manifold Cover Bolts	4.5 N.m	40 lb in
Knock Sensor Bolts	25 N.m	18 lb ft
Knock Sensor Heat Shield Bolt	25 N.m	18 lb ft
Oil Filter	30 N.m	22 lb ft
Oil Filter Fitting	55 N.m	41 lb ft
Oil Level Indicator Tube Bolt	10 N.m	88 lb in
Oil Pan Cover Bolts	10 N.m	88 lb in
Oil Pan Drain Plug	25 N.m	18 lb ft
Oil Pan Bolts - Oil Pan-to-Rear Housing	12 N.m	106 lb in
Oil Pan Bolts - Oil Pan-to-Rear Housing	12 N.m	106 lb in
Oil Pan Bolts - Oil Pan-to-Engine Block and Oil Pan-to-Front Cover	25 N.m	18 lb ft
Oil Pan Bolts - Lower Oil Pan to Upper Oil Pan	10 N.m	88 lb in
Oil Pressure Sensor	35 N.m	26 lb ft
Oil Level Sensor Bolts	10 N.m	88 lb in
Oil Pump Screen Bolts	10 N.m	88 lb in
Oil Pump-to-Engine Block Bolts	25 N.m	18 lb ft
Spark Plugs	20 N.m	15 lb ft
Throttle Body Bolts	10 N.m	88 lb in
Map Sensor Bolt	4.5 N.m	40 lb in
Evap Purge Valve Bolt	4.5 N.m	40 lb in

Timing Chain Tensioner Bolts	25 N.m	18 lb ft
Valley Cover Bolts	25 N.m	18 lb ft
Valve Lifter Guide Bolts	12 N.m	106 lb in
Valve Lifter Oil Manifold Bolts	25 N.m	18 lb ft
Valve Lifter Oil Manifold Filter Plug	30 N.m	22 lb ft
Valve Rocker Arm Bolts	30 N.m	22 lb ft
Valve Rocker Arm Cover Bolts - In Sequence	10 N.m	88 lb in
Water Inlet Housing Bolts	10 N.m	88 lb in
Water Pump Impeller Bolts	10 N.m	88 lb in
Engine Coolant Manifold Bolts	25 N.m	18 lb ft
Engine Coolant Manifold Bolt at Tensioner		
• First Pass	25 N.m	18 lb ft
• Final Pass	30 N.m	22 lb ft
Vacuum Pump Bolt	25 N.m	18 lb ft
Starter Heat Shield Bolt - Side	10 N.m	88 lb in
Starter Heat Shield Bolt - Rear	25 N.m	18 lb ft
1. Use NEW fastener.		

ENGINE MECHANICAL SPECIFICATIONS

Engine Mechanical Specifications

Application	Specification	
	Metric	English
General		
• Engine Type	V8	
• Displacement	6.2L	376 CID
• RPO	LT1	
• VIN	7	
• Bore	103.0 mm	4.055 mm
• Stroke	92.0 mm	3.622 in
• Compression Ratio	11.0:1	
• Firing Order	1-8-7-2-6-5-4-3	
• Spark Plug Gap	0.95-1.10 mm	0.037-0.043 in
Block		
• Camshaft Bearing Bore 1 and 5 Diameter	59.58-59.63 mm	2.345-2.347 in
• Camshaft Bearing Bore 2 and 4 Diameter	59.08-59.13 mm	2.325-2.327 in
• Camshaft Bearing Bore 3 Diameter	58.58-58.63 mm	2.306-2.308 in

• Crankshaft Main Bearing Bore Out-of-Round	0.008 mm	0.00031 in
• Cylinder Bore Diameter	103.239-103.261 mm	4.0645-4.0654 in
• Cylinder Head Deck Height - Measuring from the Centerline of Crankshaft to the Deck Face	234.575-234.825 mm	9.235-9.245 in
• Cylinder Head Deck Surface Flatness - Measured Within a 150.00 mm (5.9 in) Area	0.05 mm	0.002 in
• Cylinder Head Deck Surface Flatness - Measuring the Overall Length of the Block Deck	0.1 mm	0.0039 in
• Valve Lifter Bore Diameter	21.417-21.443 mm	0.843-0.844 in
• Valve Lifter Follower Bore Diameter	29.187-29.213 mm	1.149-1.150 in
Camshaft		
• Camshaft End Play	0.025-0.305 mm	0.001-0.012 in
• Camshaft Journal Diameter	54.990-55.015 mm	2.164-2.166 in
• Camshaft Bearing Diameter	55.063-55.088 mm	2.1678-2.1688 in
• Camshaft Journal-to-Bearing Clearance	0.048-0.098 mm	0.0019-0.0038 in
• Camshaft Journal Out-of-Round	0.006 mm	0.0002 in
• Camshaft Lobe Lift - Exhaust Non AFM	7.360 mm	0.290 in
• Camshaft Lobe Lift - Exhaust AFM	7.490 mm	0.295 in
• Camshaft Lobe Lift - Intake Non AFM	7.760 mm	0.306 in
• Camshaft Lobe Lift - Intake AFM	7.890 mm	0.311 in
• Fuel Pump Lobe Lift	5.70 mm	0.224 in
• Camshaft Runout - Measured at the Intermediate Journals	0.05 mm	0.002 in
Camshaft Position Actuator		
• Range of Authority	62 degrees	
• Park Position	7 degrees Advanced	
Connecting Rod		
• Connecting Rod Bearing Clearance - Production	0.024-0.064 mm	0.0009-0.0025 in
• Connecting Rod Bearing Clearance - Service	0.023-0.076 mm	0.0009-0.0029 in
• Connecting Rod Bore Diameter - Bearing End	56.505-56.525 mm	2.224-2.225 in
• Connecting Rod Bore Out-of-Round - Bearing End - Production	0.006 mm	0.00023 in
• Connecting Rod Bore Out-of-Round - Bearing End - Service	0.008 mm	0.0003 in
• Connecting Rod Side Clearance	0.125-0.495 mm	0.004-0.019 in

Crankshaft

• Connecting Rod Journal Diameter - Production	53.320-53.336 mm	2.0992-2.0998 in
• Connecting Rod Journal Diameter - Service	53.31 mm	2.0996 in
• Connecting Rod Journal Out-of-Round - Production	0.005 mm	0.0002 in
• Connecting Rod Journal Out-of-Round - Service	0.01 mm	0.0004 in
• Connecting Rod Journal Taper - Maximum for 1/2 of Journal Length - Production	0.008 mm	0.0003 in
• Connecting Rod Journal Taper - Maximum for 1/2 of Journal Length - Service	0.015 mm	0.00059 in
• Crankshaft End Play	0.040-0.220 mm	0.0015-0.0086 in
• Crankshaft Main Bearing Clearance - Production	0.02-0.052 mm	0.0008-0.0021 in
• Crankshaft Main Bearing Clearance - Service	0.02-0.065 mm	0.0008-0.0025 in
• Crankshaft Main Journal Diameter - Production	64.992-65.008 mm	2.558-2.559 in
• Crankshaft Main Journal Diameter - Service	64.982 mm	2.558 in
• Crankshaft Main Journal Out-of-Round - Production	0.005 mm	0.00019 in
• Crankshaft Main Journal Out-of-Round - Service	0.01 mm	0.0004 in
• Crankshaft Main Journal Taper - Production	0.008 mm	0.0003 in
• Crankshaft Main Journal Taper - Service	0.015 mm	0.00059 in
• Crankshaft Rear Flange Runout	0.025 mm	0.00098 in
• Crankshaft Reluctor Ring Runout - Measured 1.0 mm (0.04 in) Below Tooth Diameter	0.7 mm	0.028 in
• Crankshaft Thrust Surface - Production	26.14-26.22 mm	1.029-1.0315 in
• Crankshaft Thrust Surface - Service	26.22 mm	1.0315 in
• Crankshaft Thrust Surface Runout	0.04 mm	0.002 in

Cylinder Head

• Cylinder Head Height/Thickness - Measured from the Cylinder Head Deck to the Valve Rocker Arm Cover Seal Surface	132.5 mm	5.216 in
• Surface Flatness - Block Deck - Measured Within a 152.4 mm (6.0 in) Area	0.05 mm	0.0019 in
• Surface Flatness - Block Deck - Measuring the Overall Length of the Cylinder Head	0.1 mm	0.004 in
• Surface Flatness - Exhaust Manifold Face	0.1 mm	0.004 in
• Surface Flatness - Intake Manifold Face	0.1 mm	0.004 in

• Valve Guide Installed Height - Measured from the Spring Seat Surface to the Top of the Guide	17.05-17.55 mm	0.671-.691 in
• Injector Bore Diameter	7.65-7.87 mm	0.301-0.309 in
Intake Manifold		
• Surface Flatness - Measured at Gasket Sealing Surfaces and Measured Within a 200 mm (7.87 in) Area that Includes 2 Runner Port Openings	0.3 mm	0.118 in
Lubrication System		
• Oil Capacity - with Filter	6.6 liters	7.0 quarts
• Oil Capacity - with Filter (with Z52 - Dry Sump Oil Tank)	9.3 liters	9.8 quarts
• Oil Capacity - without Filter	6.2 liters	6.5 quarts
• Oil Capacity - without Filter (with Z52 - Dry Sump Oil Tank)	9.0 liters	9.5 quarts
• Oil Pressure - Minimum - Hot	152 kPa at 1, 000 engine RPM 207 kPa at 2, 000 engine RPM 228 kPa at 3, 000 engine RPM	22 psig at 1, 000 engine RPM 30 psig at 2, 000 engine RPM 33 psig at 3, 000 engine RPM
• Active Fuel Management Relief Valve Oil Pressure - as Measured at Oil Pressure Sensor Location	379-517 kPa Maximum	55-75 psig Maximum
Oil Pan		
• Front Cover Alignment - at Oil Pan Surface	0.0-0.5 mm	0.0-0.02 in
• Crankshaft Rear Oil Seal Housing Alignment - at Oil Pan Surface	0.0-0.5 mm	0.0-0.02 in
• Oil Pan Alignment - to Rear of Engine Block at Transmission Bell Housing Mounting Surface	0.0-0.1 mm	0.0-0.004 in
Piston Rings		
• Piston Ring End Gap - First Compression Ring - Measured in Cylinder Bore - Production	0.23-0.39 mm	0.009-0.0153 in
• Piston Ring End Gap - First Compression Ring - Measured in Cylinder Bore - Service	0.23-0.45 mm	0.009-0.0177 in
• Piston Ring End Gap - Second Compression Ring - Measured in Cylinder Bore - Production	0.32-0.63 mm	0.0126-0.0248 in
• Piston Ring End Gap - Second Compression Ring - Measured in Cylinder Bore - Service	0.32-0.69 mm	0.0126-0.0272 in
• Piston Ring End Gap - Oil Control Ring -	0.22-0.79 mm	0.0086-0.0311 in

• Piston Ring End Gap - Oil Control Ring - Measured in Cylinder Bore - Service	0.22-0.85 mm	0.0086-0.0335 in
• Piston Ring-to-Groove Clearance - First Compression Ring - Production	0.040-0.083 mm	0.0016-0.0033 in
• Piston Ring-to-Groove Clearance - First Compression Ring - Service	0.040-0.083 mm	0.0016-0.0033 in
• Piston Ring-to-Groove Clearance - Second Compression Ring - Production	0.040-0.083 mm	0.0016-0.0033 in
• Piston Ring-to-Groove Clearance - Second Compression Ring - Service	0.040-0.083 mm	0.0016-0.0033 in
• Piston Ring-to-Groove Clearance - Oil Control Ring - Production	0.013-0.201 mm	0.0005-0.0079 in
• Piston Ring-to-Groove Clearance - Oil Control Ring - Service	0.013-0.201 mm	0.0005-0.0079 in
Pistons and Pins		
• Pin - Piston Pin Clearance-to-Piston Pin Bore - Production	0.002-0.01 mm	0.00008-0.0004 in
• Pin - Piston Pin Clearance-to-Piston Pin Bore - Service	0.002-0.015 mm	0.00008-0.0006 in
• Pin - Piston Pin Diameter	23.952-23.955 mm	0.9430-0.9431 in
• Pin - Piston Pin Fit in Connecting Rod Bore - Production	0.007-0.02 mm	0.00027-0.00078 in
• Pin - Piston Pin Fit in Connecting Rod Bore - Service	0.007-0.022 mm	0.00027-0.00086 in
• Piston - Piston Diameter - Measured Over Skirt Coating	103.258-103.289 mm	4.0653-4.0665 in
• Piston - Piston to Bore Clearance - Production	-0.048 to +0.001 mm	-0.0019 to +0.000 in
• Piston - Piston to Bore Clearance - Service Limit With Skirt Coating Worn Off	0.052 mm	0.0020 in
Valve System		
• Valves - Valve Face Angle	45 degrees	
• Valves - Valve Face Width	1.25 mm	0.05 in
• Valves - Valve Lash	Net Lash - No Adjustment	
• Valve Lift - Exhaust Non AFM	13.250 mm	0.521 in
• Valve Lift - Exhaust	13.503 mm	0.531 in
• Valve Lift - Intake Non AFM	14.000 mm	0.551 in
• Valve Lift - Intake	14.253 mm	0.561 in

• Valves - Valve Seat Angle	45 degrees	
• Valves - Valve Seat Runout	0.05 mm	0.002 in
• Valves - Valve Seat Width - Exhaust	2.52 mm	0.099 in
• Valves - Valve Seat Width - Intake	1.98 mm	0.078 in
• Valves - Valve Stem Diameter - Production	7.955-7.976 mm	0.313-0.314 in
• Valves - Valve Stem Diameter - Service	7.95 mm	0.313 in
• Valves - Valve Stem-to-Guide Clearance - Production - Exhaust	0.025-0.066 mm	0.001-0.0026 in
• Valves - Valve Stem-to-Guide Clearance - Service - Exhaust	0.093 mm	0.0037 in
• Valves - Valve Stem-to-Guide Clearance - Production - Intake	0.025-0.066 mm	0.001-0.0026 in
• Valves - Valve Stem-to-Guide Clearance - Service - Intake	0.093 mm	0.0037 in
• Valves - Valve Stem Height - Measured from Spring Seat - Intake and Exhaust	51.945-52.695 mm	2.045-2.074 in
• Rocker Arms - Valve Rocker Arm Ratio	1.80:1	
• Valve Springs - Valve Spring Free Length	56.2 mm	2.21 in
• Valve Springs - Valve Spring Installed Height	47.75 mm	1.87 in
• Valve Springs - Valve Spring Load - Closed	400 N at 47.75 mm	90 lb at 1.9 in
• Valve Springs - Valve Spring Load - Open	1175 N at 35.05 mm	264 lb at 1.38 in

ENGINE CONTENT SPECIFICATIONS

Engine Content Specifications

RPO	VIN	Displacement	Camshaft Position (CMP) Actuator Control System	Active Fuel Management Control System	E85 Capable	Block Material
LT1	7	6.2L	Yes	Yes	No	Aluminum

ADHESIVES, FLUIDS, LUBRICANTS, AND SEALERS

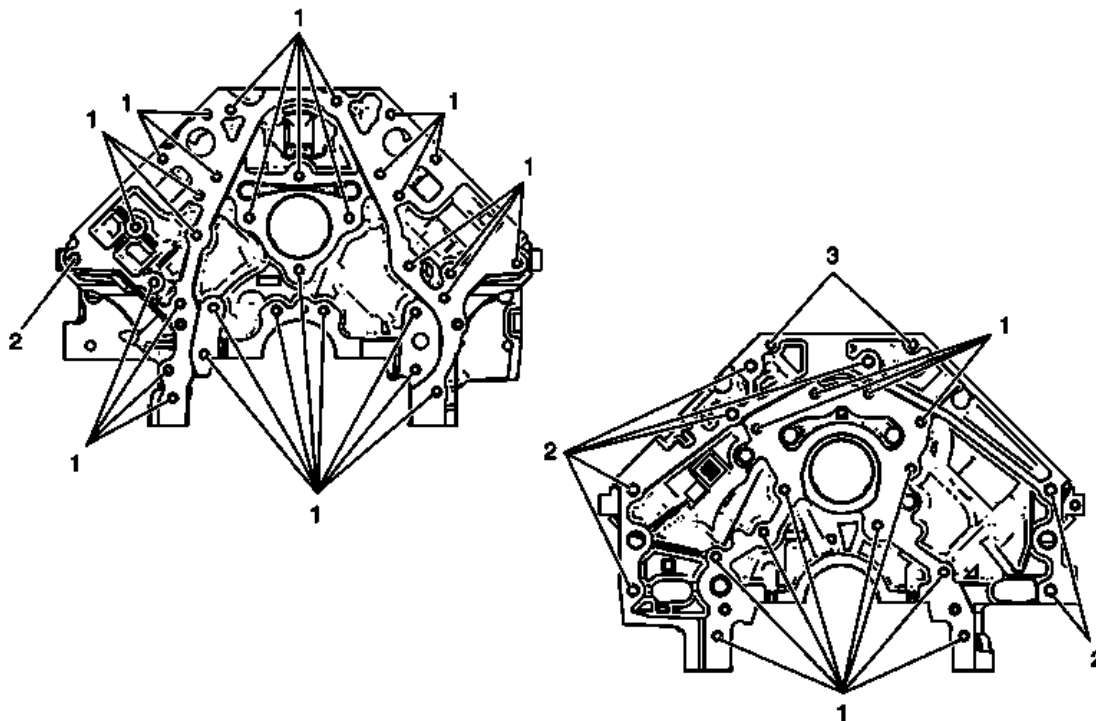
Adhesives, Fluids, Lubricants, and Sealers

Application	Type of Material	GM Part Number	
		United States	Canada

Camshaft Retainer Bolts	Threadlocker	12345382	10953489
Engine Block to the Crankshaft Rear Oil Seal Housing	Sealant	12378521	88901148
Engine Block to the Engine Front Cover	Sealant	12378521	88901148
Engine Block to Oil Pan	Sealant	12378521	88901148
Lower Oil Pan to Upper Oil Pan	Sealant	12378521	88901148
Engine Block Coolant Drain Hole Plug	Sealant	12346004	10953480
Engine Block Oil Gallery Plug	Sealant	12346004	10953480
Engine Oil	5W-30	19293000	19386321
Engine Oil Pressure Sensor Threads	Sealant	12346004	10953480
Engine Coolant Temperature (ECT) Sensor	Sealant	12346004	10953480
Exhaust Manifold Bolts	Threadlocker	89021297	10953488
Engine Coolant Manifold Bolt	Threadlocker	12345382	10953489
Fuel Rail Bolts	Threadlocker	12345382	10953489
Intake Manifold Bolts	Threadlocker	12345382	10953489
Spark Plug Wires	Lubricant	19260901	19260902
Valve Lifter Oil Filter Plug	Sealant	12346004	10953480

THREAD REPAIR SPECIFICATIONS

Engine Block- Front/Rear Views



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Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth- Maximum mm (in)	Tap Depth- Maximum mm (in)
J-42385-								
1	M8 x 1.25	210	206	207	208	209	23.0 (0.907)	23.0 (0.907)
2	M10 x 1.5	420	211	212	213	214	34.0 (1.35)	34.0 (1.35)
3	M8 x 1.25	61	206	207	208	209	29.0 (1.14)	29.0 (1.14)

Engine Block- Left/Right Side Views								
Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth- Maximum mm (in)	Tap Depth- Maximum mm (in)
Standard Bolts J-42385-								

1	M8 x 1.25	210	206	207	208	209	23.0 (0.907)	23.0 (0.907)
2	M10 x 1.25	420	211	212	213	214	34.0 (1.35)	34.0 (1.35)
3	M8 x 1.25	61	206	207	208	209	29.0 (1.14)	29.0 (1.14)
4	M12 x 1.75	865	856	857	858	859	16.0 (0.629)	16.0 (0.629)
Head Bolts EN-42385-								
5	M12 x 1.75	62	856	857	858	859	23.0 (0.907)	23.0 (0.907)
6	M12 x 1.75	58	51	N/A	52	53	58.0 (2.28)	58.0 (2.28)
7	M12 x 1.75	58	51	57 (Stop Collar)	52	53	58.0 (2.28)	58.0 (2.28)
Cylinder head bolt hole (7) has a unique shallow depth. Use stop collar EN-42385-57 . Stop tap and driver at first line. Refer to Thread Repair for head bolt thread repair hardware and procedure.								

Engine Block- Top/Bottom Views

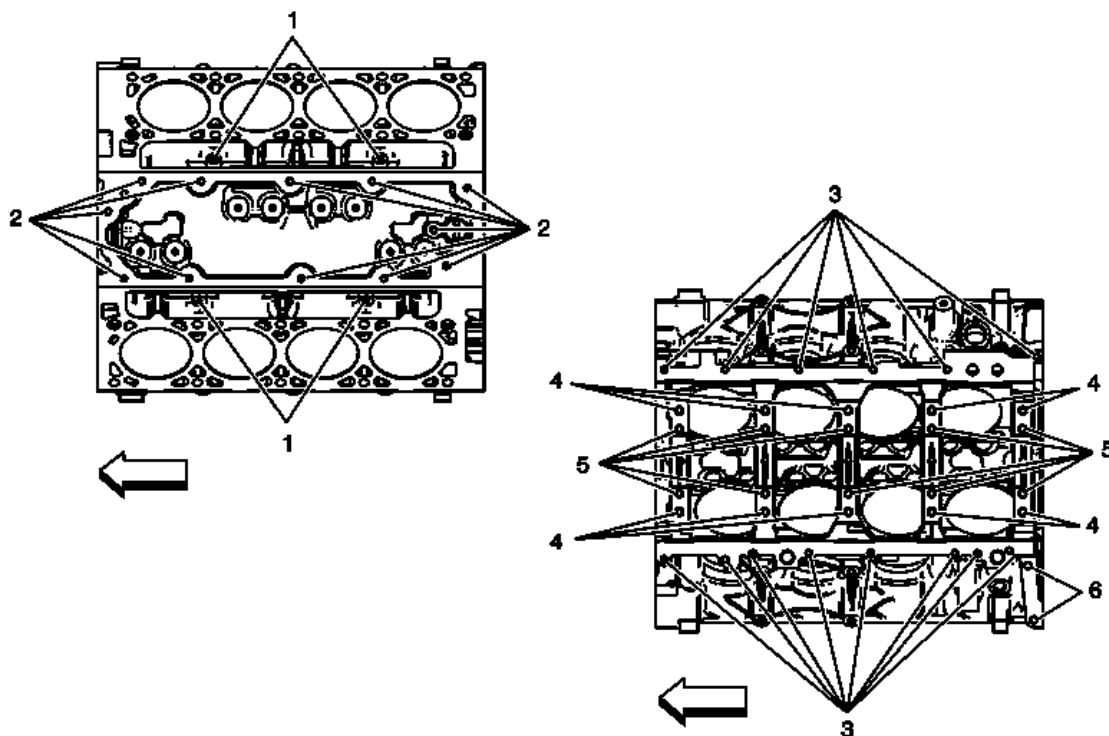


Fig. 3: Engine Block- Top/Bottom Views
Courtesy of GENERAL MOTORS COMPANY

Engine Block- Top/Bottom Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth- Maximum mm (in)	Tap Depth- Maximum mm (in)
J-42385-								
1	M6 x 1.0	63	201	202	203	204	23.0 (0.907)	23.0 (0.907)
2	M8 x 1.25	61	206	207	208	209	29.0 (1.14)	29.0 (1.14)
3	M8 x 1.25	210	206	207	208	209	23.0 (0.907)	23.0 (0.907)
4	M10 x 2.0	104	101	N/A	102	103	30.0 (1.18)	30.0 (1.18)
5	M10 x 2.0	104	101	N/A	102	103	52.0 (2.05)	52.0 (2.05)
6	M10 x 1.5	N/A	N/A	N/A	N/A	N/A	34.0 (1.35)	34.0 (1.35)
- Bolt hole 4 has a 1.5 mm (0.059 in) counterbore included in the 30.0 mm (1.18 in) drill depth. Use sleeve J-42385-316 with the drill tap. For the proper hardware and procedure, refer to Thread Repair. - Bolt hole 5 has a 15.5 mm (0.807 in) counterbore included in the 52.0 mm (2.05 in) drill depth. For the proper hardware and procedure, refer to Thread Repair.								

Cylinder Head- Top/End Views

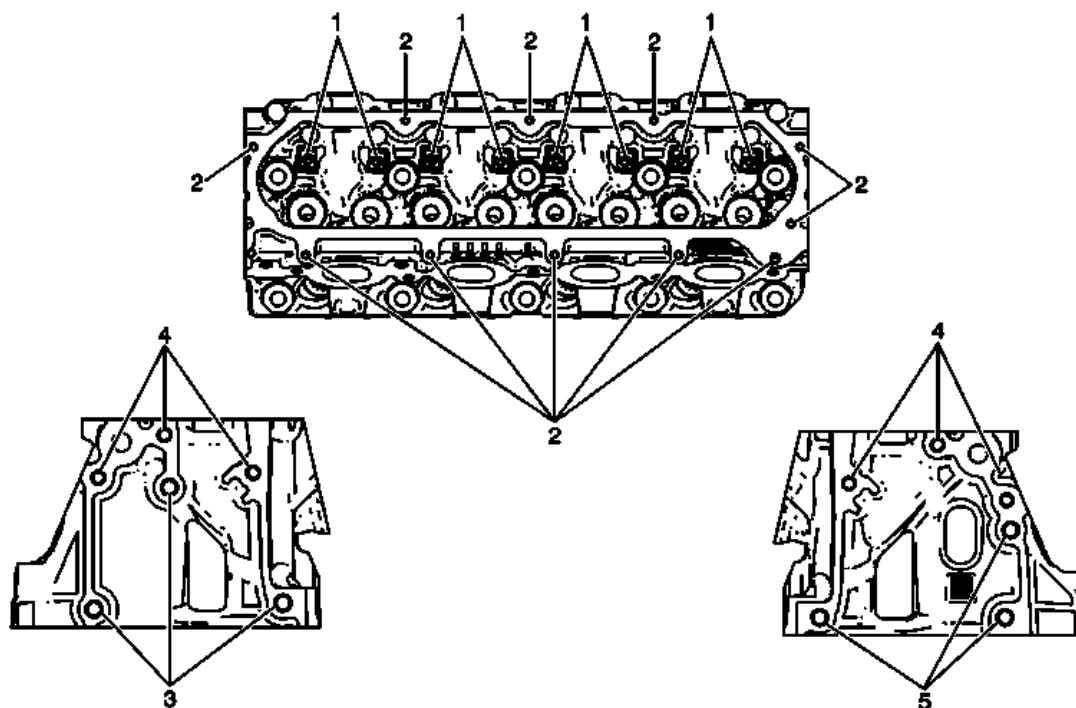


Fig. 4: Cylinder Head- Top/End Views

Cylinder Head- Top/End Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth- Maximum mm (in)	Tap Depth- Maximum mm (in)
J 42385-								
1	M8 x 1.25	N/A	N/A	N/A	N/A	N/A	23.0 (0.907)	23.0 (0.907)
2	M6 x 1.0	205	201	202	203	204	23.0 (0.907)	23.0 (0.907)
3	M10 x 1.5	420	211	212	213	214	30.0 (1.18)	30.0 (1.18)
4	M8 x 1.25	210	206	207	208	209	23.0 (0.907)	23.0 (0.907)
Bolt Hole 1 (Rocker Arm Supports) are not serviceable.								

Cylinder Head- Intake/Exhaust Side Views

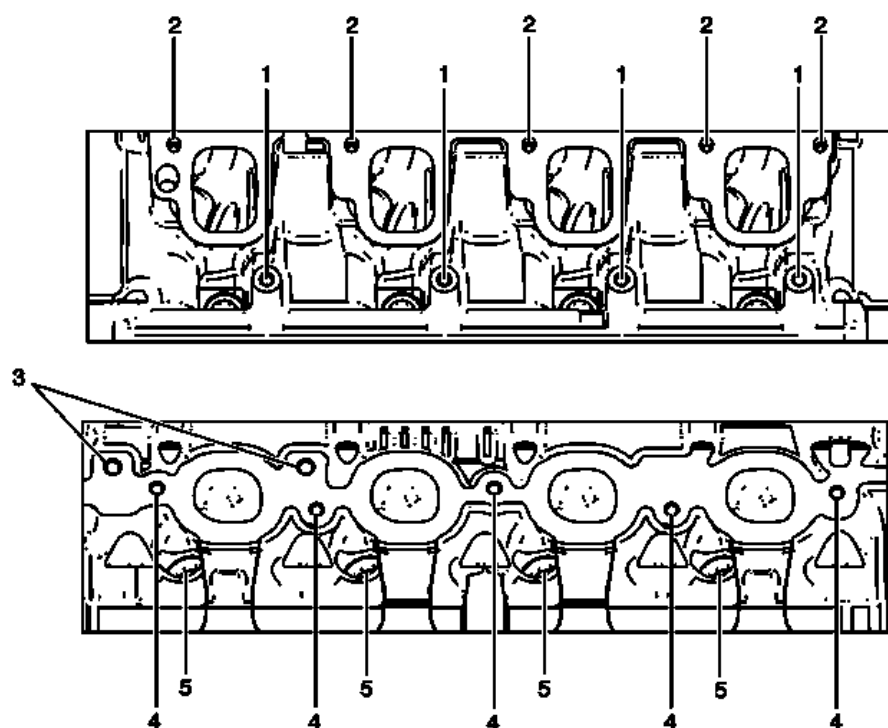


Fig. 5: Cylinder Head- Intake/Exhaust Side Views
Courtesy of GENERAL MOTORS COMPANY

Cylinder Head- Intake/Exhaust Side Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth- Maximum mm (in)	Tap Depth- Maximum mm (in)
J 42385-								

1	1.25	210	206	207	208	209	23.0 (0.907)	23.0 (0.907)
2	M6 x 1.0	205	201	202	203	204	21.0 (0.825)	21.0 (0.825)
3	M10 x 1.5	420	211	212	213	214	34.0 (1.35)	34.0 (1.35)
4	M8 x 1.25	210	206	207	208	209	29.0 (1.14)	29.0 (1.14)
5	M14x 1.25	N/A	N/A	N/A	N/A	N/A	26.0 (1.023)	26.0 (1.023)
Bolt Hole 5 (Spark Plug Port) is not serviceable.								