

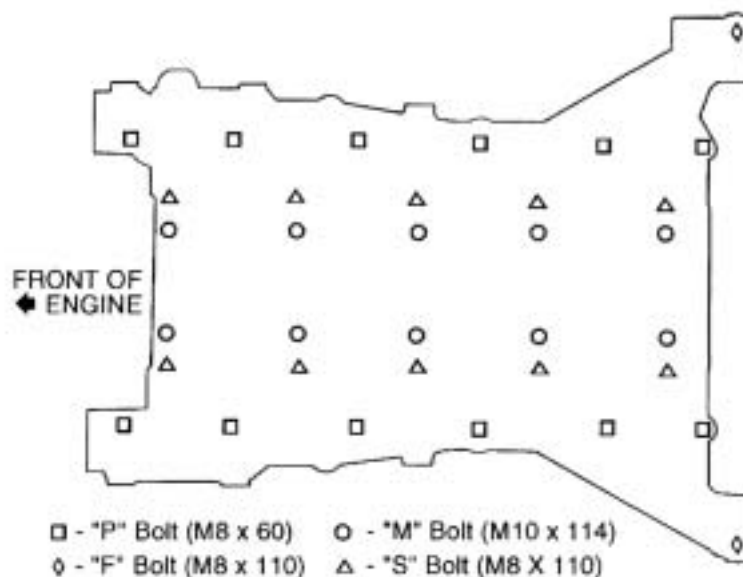
Bedplate Installation Caution For 1997-2000 Jaguar 4.0L V8 Engines

The AERA Technical Committee offers the following information regarding a main bearing bedplate installation caution for 1997-2000 Jaguar 4.0L V8 engines. This engine uses three different bolt thread sizes and if the improper torque is used on certain bolts, lower end failure of the engine could result.

Jaguar uses 34 bolts to hold the bedplate onto the cylinder block and there are four different size bolts used. The bedplate is to be installed after piston and connecting rod assemblies are installed and all bolts **MUST BE** replaced after each use. To install the bedplate correctly, follow the procedure listed below and refer to Figure 1 below for the proper bolt locations.

- | | |
|------------|--|
| Step 1 | Install "P" bolts and torque to 10-12 ft/lbs |
| Step 2 | Install "F" bolts and torque to 18-19 ft/lbs |
| Step 3 | Install "M" bolts and torque to 18-19 ft/lbs |
| Step 4 | Install "S" bolts and torque to 10-12 ft/lbs |
| Step 5-6 | Torque "M" bolts to 25-27 ft/lbs + 135° |
| Step 7-8 | Torque "S" bolts to 14-15 ft/lbs + 150° |
| Step 9-10 | Torque "P" bolts to 14-15 ft/lbs + 90° |
| Step 11-12 | Torque "F" bolts to 14-15 ft/lbs +150° |

To complete the installation, center-punch each bolt head after torque sequence is complete.



Information is from best available sources and is accurate at the time of publication. However, Jasper Engines & Transmissions ASSUMES NO RESPONSIBILITY and cannot be held liable for any results or consequences regarding the use of this information.