

## **HARD BLOK® Water Jacket Filler**

### **INSTALLATION INSTRUCTIONS**

1. Clean engine block. Hot tank cleaning is recommended. Blow dry with compressed air. Insure that water jacket is dry.
2. Minimum recommended temperature for installation is 50°. If temperature is below 65°, double all set-up times stated below.
3. Install freeze plugs. Mount block on engine stand. Torque main cap bolts (if desired).
4. Turn block with one deck facing up. Level deck with bubble level.
5. **ACCURATELY MEASURE MIXING WATER WITH A GRADUATED MEASURING CUP!**

	SHORT-FILL UNIT (Two 6-1/4 lb. bags)	TALL-FILL UNIT (Two 14 lb. bags)
--Suggested starting water content---	16 to 18 fluid oz. <u>per bag</u>	36 to 42 fluid oz. <u>per bag</u>

Place water in bucket first. While mixing with Jiffy-type mixer on an electric drill, slowly pour contents of **one bag** of **HARD BLOK** into water. Mix thoroughly for **5 minutes**. Mix should be creamy and of such consistency to pour through a 1/2" funnel. If mix is too stiff, add additional water one ounce at a time and re-mix. Again, mix should be consistent with no water on top, with even distribution of the heavier particles. If any settlement of heavier particles is noticeable, too much water has been added. Working time after mixing is 30-45 minutes. If mix begins to stiffen, you may re-mix, but **do not** add additional water. It must be discarded.

6. When **HARD BLOK** is thoroughly mixed, pour into water jacket through several holes in the deck using a 1/2" funnel. Fill to the desired height for your application. Work **HARD BLOK** with a stiff wire to assist in consolidation around cylinder walls and to eliminate any air pockets. Gentle vibration of the block will level the surface. We do not recommend strong vibration from air or impact tools.
7. Install torque plate and torque head bolts if desired.
8. Allow to set undisturbed overnight (24 hours if temperature is between 50 and 65°).
9. Turn block on engine stand and repeat steps 4 through 8. (V-8 or V-6 blocks)
10. After set-up time, machine and/or hone cylinders. Block is ready for assembly.

\* Yield: One Short-Fill Unit -- approximately 3 fluid quarts.  
One Tall-Fill Unit -- approximately 6-2/3 fluid quarts.

\* Block castings are not precise. One side may vary from the other. Variance between blocks can be considerable. We cannot be responsible for this variance.

\* Unless precision balance-beam scales are used, we recommend that you do not attempt to split the contents of one bag. **HARD BLOK** cannot be accurately measured by "volume".

\* To avoid coolant flow restrictions, please check the flow requirements and pattern of your particular block before filling. **HARD BLOK** becomes permanent and cannot be removed after hardening. We cannot be responsible for any coolant blockage nor overheating problem caused by filling the water jacket.