

BHJ Products, Inc.

Parts List & Instructions

Product Name: **Blok-Tru Basic Kit**
BHJ Part#: **BT1-B**

Page 1 of 3

Kit Contents:

1x Blok-Tru Index Plate	2x Brass Washers
1x Index Plate Alignment Cone [Front] (Threaded I.D.)	1x 12" Long Threaded Rod
1x Rear Alignment Cone (Smooth I.D.)	1x 6" Long Threaded Rod
	1x Spacer Tube
	1x Jam Nut
	2x Hand Nuts

Optional Accessories:

1. Ford Triton/Modular O.H.C. V8 Hardware Kit
2. Tall Index Plate & Rear Cone for Chrysler/Mopar 5.7L & 6.1L V8 blocks
3. 60mm Roller Cam Tunnel Cone Set (also for use on GM LS Series blocks)
4. 60-Degree V6 Angle Adapter
5. Deck Height Micrometer

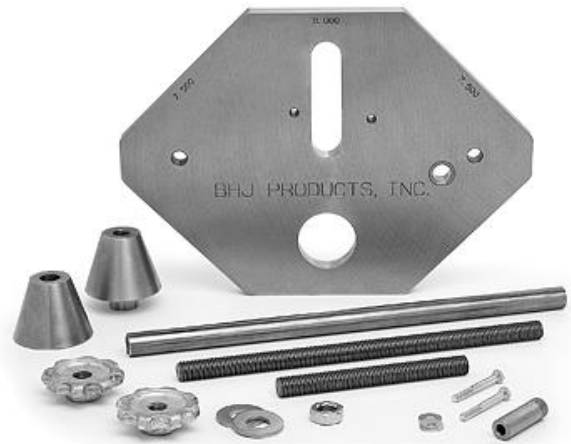
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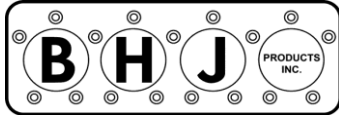
The Blok-Tru Basic Kit is the necessary starting point for tailoring the Blok-Tru to fit resurfacing machines supplied with a 2" diameter support bar from the manufacturer.

The Blok-Tru Basic Kit consists of a precision-machined Index Plate, Cam Tunnel Alignment Cones, Cam Tunnel Clamping Hardware and accommodations for optional hardware to allow machining the Ford Triton/Modular O.H.C. blocks.

Use of the Blok-Tru Basic Kit requires BHJ's 2" Precision Support Bar (or equivalent) and Main Bearing Bore Adapter Rings, which are available separately.

Older Blok-Tru Index Plates may also be upgraded to work with the Ford Triton/Modular, by sending the plate to BHJ for machining and parts. Contact us for more information on this upgrade. A tall version of the Index Plate and rear Cam Tunnel Cone is also available to accommodate the Chrysler/Mopar 5.7 & 6.1 liter V8 blocks.



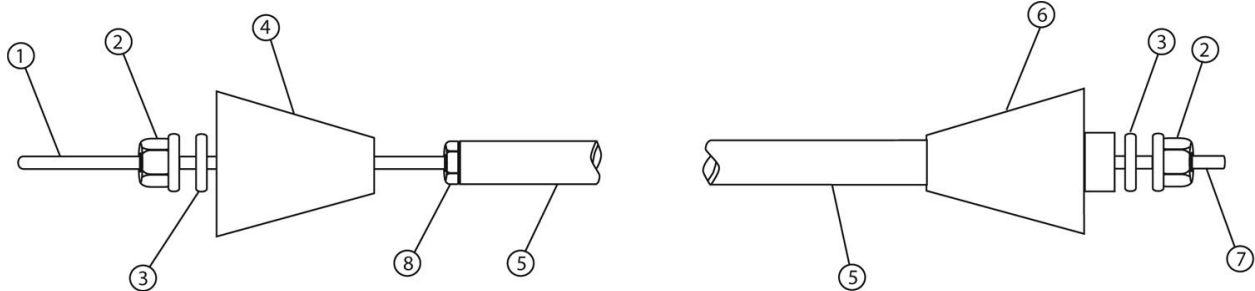


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BHJ Part#: **BT1-B**

Page 2 of 3



Alignment Shaft Assembly Parts Shown Above:

- | | |
|---------------------------------|--------------------------------|
| 1. 12" Long Threaded Rod | 5. Spacer Tube |
| 2. Hand Nut | 6. Front Alignment Cone |
| 3. Brass Washer | 7. 6" Long Threaded Rod |
| 4. Rear Alignment Cone | 8. Jam Nut |

Installation (Typical O.H.V. Applications)

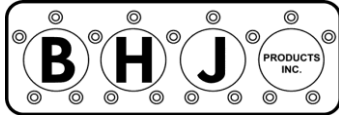
1. Install Cam Tunnel Alignment Shaft into cam bearing bores. Alignment Shaft hardware assembly is shown in the diagram above. Carefully inspect the front and rear cam bore chamfers. Any eccentricity will affect set-up accuracy. If chamfers are bad, install a cam bearing so that the cone contacts the bearing and is clear of the chamfer. Draw sliding (Rear) Cone loosely into place with hand nut.

NOTE: Chrysler/Mopar 5.7 & 6.1L blocks require use of a unique Rear Cone to clear the bellhousing flange.

2. Install 2" Precision Support Bar into main saddles, using the appropriate Main Rings for the application. (The Blok-Tru is designed for a 1.999-2.000 diameter bar).
3. Slide Index Plate onto the Support Bar and onto the nose of the Front Alignment Cone. Install washer and hand nut and tighten firmly.

NOTE: Some blocks require installing the Index Plate on the bellhousing end of the block. The "Front" Cone is always installed on the end of the block where the Index Plate will be used.

4. Tighten sliding (Rear) Cone hand nut.
5. Unit is now ready for use.
6. Using a dial indicator or precision level, the block can be set up for surfacing or boring from either of the three machined surfaces.
7. Deck height may be checked using BHJ's Deck Height Micrometer, available separately.



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BHJ Part#: **BT1-B**

Page 3 of 3

Installation (Ford Triton/Modular O.H.C. Applications)

Ford Triton/Modular O.H.C. Kit Parts:

1x Alignment Pin **2x** M 6-1.0 x 50mm Bolts with Washers

A. Install 2" Precision Support Bar into main saddles, using the appropriate Main Rings for the application. (The Blok-Tru is designed for a 1.999-2.000 diameter bar).

NOTE: Be sure block's bellhousing flange surface is clean and free of surface irregularities.

B. Slide Index Plate onto Support Bar at rear of block, until bellhousing flange is contacted. Install two M6 bolts and Washers loosely through holes on either side of the Index Plate center slot. Refer to photograph of Index Plate on page 1 of this instruction sheet for locations.

C. Insert Alignment Pin into 5/8" hole (with drill bushing installed) and onto bellhousing alignment dowel.

D. Tighten two M6 bolts enough to securely fasten Index Plate to the block.

E. Unit is now ready for use.

F. Using a dial indicator or precision level, the block can be set up for surfacing or boring from either of the three machined surfaces.

G. Deck height may be checked using BHJ's Deck Height Micrometer, available separately.

Call BHJ at (510) 797-6780 with any questions regarding the part, setup, or operation.