



ENERGY



OFFICIAL LICENSED PRODUCT

Installation Instructions: RB Hemi Engine Block Part Numbers: P5160208AA, P5160210AA, P5160211AA

Read all instructions before beginning installation



Engine Block Components:

- (1) Engine block with main caps and rear oil seal retainer assembled.
- (1) Block plug kit (loose)
- (1) Camshaft bearing kit - #PD-17 (loose)
- (2) 0.040" Oil gallery restrictors (loose)
- (1) 1/2" Oil pickup tube adapter - #27931(loose)
- (4) AN10 Valley plugs (loose)
- (1) Bronze distributor bushing (loose)

Part Number	Material	Delivered Bore Size	Cylinder Hone	Lifters .9061 .9055	Clearance
P5160208AA*	gray iron	4.492-4.495	No	Yes	Yes
P5160210AA*	gray iron	4.242-4.245	No	Yes	Yes
P5160211AA*	gray iron	4.242-4.245	No	No	No

Previous PN	Previous PN	New PN
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P5153862AD → P5160150AC → **P5160208AA***

P5153942AD → P5160151AC → **P5160210AA***

P5153943AE → P5160152AC → **P5160211AA***

***Cylinder bores and lifter bores are not honed.**

For technical assistance regarding the HEMI® Engine Block, please contact Callies Performance Products, Monday-Friday, 8:00am-5:00pm EST at 419-435-2711

Motor Mounts:

Stock Hemi motor mount bosses are provided

Cylinder Bores:

Blocks that are sold without hone must be **finish honed before use**. All blocks have siamese water jackets that accomodate a maximum overbore of 4.600". It is recommended that you sonic check each block if you plan to exceed as shipped bore diameters. Honing with a torque plate is recommended.

Main Caps + Main Bearings:

#1, #2, #3 and #4 main caps are cross bolted. Blocks are machined for stock main bearings. Install main bearing caps with bearing tangs facing the driver's side of the engine. Seat the caps in the block and torque the vertical bolts to 55-65 ft-lbs first to maintain cap alignment and then torque the cross bolts to 35-45 ft-lbs. Finish by torquing the vertical bolts to 95 - 105 ft-lbs.

Bell Housing Pattern:

Blocks are machined to stock Gen II Hemi bell housing pattern.

Deck Height:

Blocks are machined to a stock RB deck height or 10.725". At this height the deck is .600" thick.

Water Pump:

Stock water pump components can be used with these blocks. Torque the water pump to the housing to 30 ft-lbs and torque the housing to block bolts to 30 ft-lbs.

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* Part numbers listed in this document are for reference only, and may not be available through MOPAR. Please check your block's part number against the features listed in the above chart before performing any machining or assembly prep.

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Callies Performance Products - 419-435-2711 - www.callies.com
Energy Manufacturing - www.energymanufacturing.com



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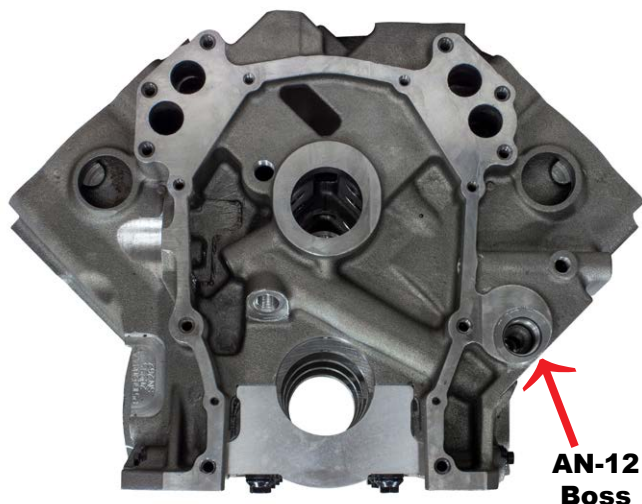
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Oil Pan + Pickup:

Blocks come with an adapter that accommodates the use of stock oil pickup tubes. Stock oil pans will fit as well. Torque oil pan attaching screws to 180 in-lbs.

External Oil Pickup Passage:

The block is prepped to run an externally routed oil pickup tube if crankcase clearance is improper. An AN-12 boss is machined on the front face of the block connecting directly to the inlet side of the oil pump. An AN-12 fitting can be installed here connecting externally to an oil pickup tube installed in your oil pan. You will need to plug the oil pick up tube adapter inside the crankcase with a 1/2" pipe plug (not provided) when making this modification.



External Oil Pick up Passage

Oiling System:

The oil feeds from the deck surfaces that connect to the cylinder heads have .040" restrictions included, but not installed, to control the flow of the oil to the valve train. It is recommended that these are always used. Stock oil pumps will bolt directly to these blocks. Torque oil pump attaching bolts to 30 ft-lbs.

Distributor + Intermediate Shaft:

Blocks are machined to accept stock distributors and related drive components. A bronze intermediate shaft bushing has already been included but not installed in each block and is finished to size.

Camshaft and Front Drive:

Blocks are prepped for stock cam bearings although the cam bearing bores can be machined oversize to allow use of 60mm roller bearings for racing applications. When installing journal bearings be sure to align the oil hole with the bearing shell with the block's oil feed hole. All stock cam drive components can be used with the standard cam height packages. Torque front cover bolts to 15-18ft-lbs.

Lifter Bore Angle and Diameter:

Blocks listed with lifter bores are machined to stock 0.905" diameter and 45° angle, but not honed. Sizing for aftermarket lifters may vary. Please check your specific application. Check your part's clearance. Clearance for tie bar roller lifter has been provided.

Rear Seal Retainer and Seal:

Blocks come with the rear seal retainer installed. Rear seal is offset and unique to this application. Retorque the seal cap retaining bolts to 30 ft-lbs.

Fuel Pump and Drive Pushrod:

Stock fuel pump and drive pushrod components can be used with these blocks. A block-off plate is available if a mechanical fuel pump is not required for your application. Torque fuel pump or block-off plate to 30 ft-lbs.

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