



## R Model Honing Plate Instructions

### Tips For Best Results Using A BHJ R Model Honing Plate

1. Use the identical type fasteners in the Honing Plate that will be used in the final engine assembly. Experience has shown that various types of head bolts, i.e. Stock, 12 Point, Allen Head, Studs, have different stretch ratios and therefore different clamping values.
2. Due to design and production tolerances on the various head bolts available and production variations on the spacer tubing, it sometimes may be necessary to slightly enlarge the I.D. of the spacers.
3. Use the identical type head gasket that will be used in the final engine assembly. Experience indicates that gaskets can be used repeatedly without loss of accuracy.
4. Always install main caps and tighten to operating torque value.
5. Install any other accessory whose attachment bolts impinge on the cylinder walls. This may include water pump, bellhousing, motor mounts, etc.
6. Install bolt spacer tubes the same way up. The bolt head end may become grooved and should not be reversed and placed against the plate.
7. Always use head bolt washers under bolts without spacers.
8. Check that the bolt penetration into the block is comparable between the Honing Plate and the heads to be used. Most shops use +/- 1/32" as a workable tolerance. If cylinder heads have been severely milled, adjustments may be necessary.

The foregoing is intended as a basic guideline. It should not be considered as criteria for a perfect result. Each and every Honing Plate user has their own method and the above tips should be adjusted accordingly.