

[Table Of Contents](#)

**Acknowledgments**

**Introduction**

**Chapter 1:**

Flaw Detection  
Sonic Testers  
Hand-Held Magnetic Particle Testers  
Wet Mag Bench Testers  
Dye Penetrant  
Pressure Testing

**Chapter 2:**

Engine Blocks  
Flaw Checking the Block  
Decking the Block  
Correcting Cylinder Bores  
Oil Restrictors and Screens  
Lifter Valley Surface  
Rod and Crank Clearance  
Oil Hole Alignment  
Threaded Holes

**Chapter 3:**

Block Machining  
Main Bore Align Honing  
Deck Resurfacing  
Cylinder Honing  
Cylinder Boring  
Plateau Finishing  
Cylinder Bore Distortion  
Lifter Bores  
Hot Honing  
Camshaft Bore

**Chapter 4:**

Oiling Systems  
Wet Sump Systems  
Dry Sump Systems  
External Oil Coolers

Oil Restrictors  
Oil Drainback  
Intermediate Shaft  
High-Pressure High-Volume Pumps  
Pre-Lube Before Initial Startup

## **Chapter 5:**

Engine Math  
Bore and Stroke  
Connecting Rod Length  
Rod Ratio  
Piston Compression Height  
Compression Ratio (part 1)  
Combustion Chamber Volume  
Piston Dome Volume  
Head Gasket Volume  
Deck Height Volume  
Cylinder Swept Volume  
Compression Ratio (part 2)

## **Chapter 6:**

Crankshafts  
Crankshaft Types  
Surface Hardening  
Reducing Rotating Mass  
Inspection  
Stroker Clearance  
Shot Peening  
Stress Relieving  
Counterweight Modifications  
Cross Drilling  
Chamfering Oil Holes

## **Chapter 7:**

Connecting Rods  
Rod Types  
Center-to-Center Length  
Piston-to-Rod Clearance  
Rod-to-Block Clearance  
Rod-to-Camshaft Clearance  
Rod Bearing Clearance  
Rod Side Clearance  
Beam Design

Rod Bolt Tightening  
Connecting Rod Inspection

## **Chapter 8:**

Pistons  
Performance Pistons  
Piston-to-Wall Clearance  
Piston Diameter  
Piston Skirt to Crankshaft Clearance  
Coatings  
Piston Pins  
Ring Grooves  
Piston-to-Head Clearance  
Piston-to-Valve Clearance  
Piston Compression Distance  
Compression Ratio  
Deck Height  
Gasket Volume  
Piston Dome Volume  
Combustion Chamber Volume  
Valve Pockets  
Ordering Custom Pistons

## **Chapter 9:**

Piston Rings  
Ring Types  
Tension and Gap  
Piston Ring Trends  
Determining Ring Depth  
Ring Installation Method

## **Chapter 10:**

Camshafts  
Cam Types  
Protecting the Cam  
Cam Runout  
Cam Endplay  
Degreeing the Cam  
Adjusting Cam Timing  
Lobe Separation Angles  
GM LS Cam Lifters  
Special Firing Order Camshafts

Camshaft Needle Bearings  
Distributor Gears

### **Chapter 11:**

Cylinder Heads  
Cast Iron versus Aluminum  
Deck Surface Finish  
Deck Flatness  
Valves  
Ports and Runners  
Finishing Bare Cylinder Heads  
Inspection and Reconditioning  
Flow Bench Testing  
Cylinder Head Installation

### **Chapter 12:**

Valves, Springs, Retainers and Locks  
Valve Inspection  
Valve Seats  
Performance Valve Technology  
Valvesprings  
Retainer Fit  
Valvespring Seats  
Retainers and Locks

### **Chapter 13:**

Rocker Arms  
Rocker Arm Ratio  
Guideplates  
Roller Rockers  
Rocker Arm Materials  
OHC Followers  
Valve Cover Clearance  
Upgrading OEM LS Rocker Arm Trunnions

### **Chapter 14:**

Pushrods  
Check for Runout  
Pushrod Length  
Guideplates  
Pushrod Diameter  
Pushrod Wall Thickness

Pushrod End Types  
Clean the Pushrods

### **Chapter 15:**

Intake Manifolds  
Manifold Types  
Port Matching  
Intake Plenum  
Intake Port Surface  
Manifold Bolts  
Converting LS to Carb  
Manifold Surface Protections  
Carb Spacers

### **Chapter 16:**

Balancing  
Internal versus External Balance  
Weight Matching  
Bobweights  
Balancing Procedures

### **Chapter 17:**

Timing Systems  
Chain Drive  
Belt Drive  
Gear Drive

### **Chapter 18:**

Engine Performance Coatings and Treatments  
Coating Types  
Cryogenic Stress Relief  
Vibratory Stress Relief  
Hard Cylinder Coating

### **Source Guide**