



Our IA II blocks are machined by one of the best aftermarket engine machine shops in the country. All blocks are checked on a CNC coordinate measuring machine with-in process probing during manufacturing. Every block is pressure tested and comes with a sonic test sheet. IA II Blocks come with a full warranty for material and workmanship.

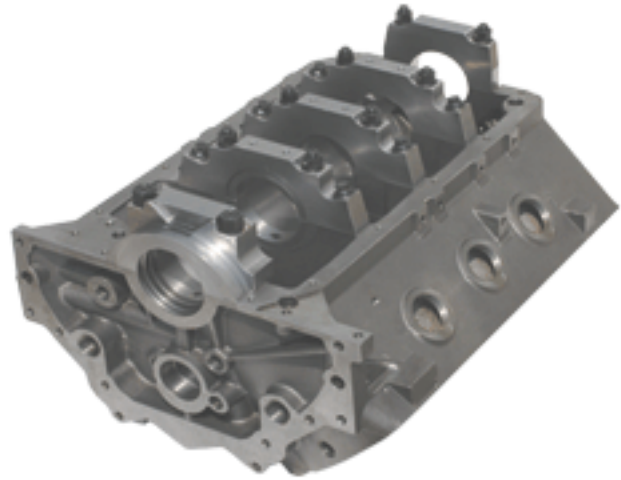
## Engine, Bare Block

### A. APSJB

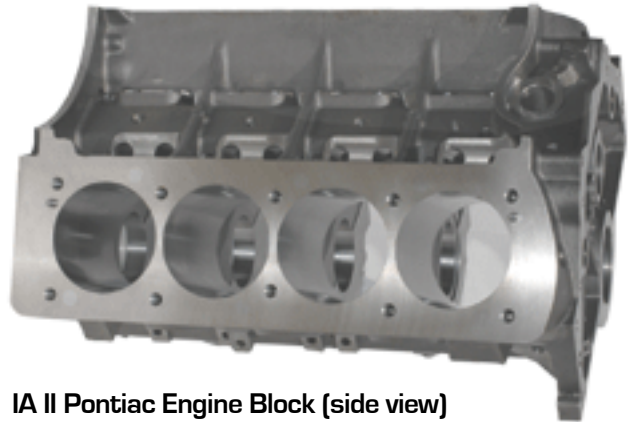
#### Engine & Components, IA II Pontiac Engine Block

- High Alloy Modified
- ASTM class cast iron block
- Siamese Cylinder bores
- Four-bolt steel main caps
- Main webs thickened to the maximum for added strength
- Wider pain rails
- Thicker deck surfaces
- Improved Oiling
- Solid Lifter gallery with drilled oil returns
- Lifter feed oil holes tapped ¼ - 20 for oil restrictors
- Bronze lifter bushings optional
- Redesigned cooling with added water holes in the back for better water flow
- All blocks are dry decked
- Threaded freeze plugs
- Dual bell housing bolt patterns for both Pontiac and "corporate" transmissions
- Bottom of cylinders are notched to clear strokes up to 4.75", 5.0 stroke possible with some grinding
- Motor mounts for the standard Pontiac 5-bolt motor mount pattern
- Accepts all OEM Pontiac parts plus many other improvements

# Engine Blocks



**A** IA II Pontiac Engine Block (rear)



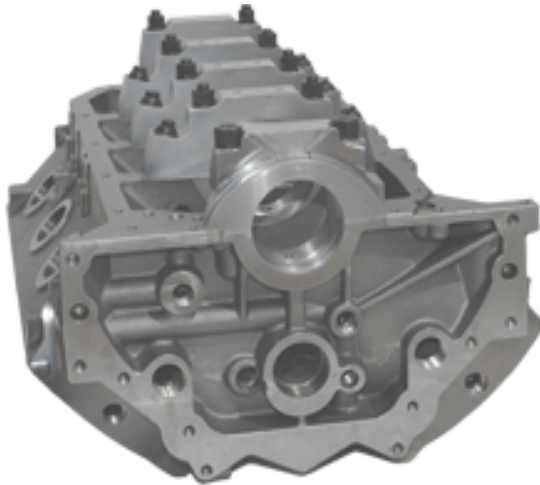
**A** IA II Pontiac Engine Block (side view)



**A** Four-Bolt Splayed Main Caps



**A** Two-Piece Rear Main Seal Cap



IA II Pontiac Engine Block (bottom) **A**

### IA II Pontiac Engine Block

Part Number	APSJJB
Block Material	ASTM Class 35 Cast Iron Tensile Strength 35,000 psi Copper, Chrome, Molybdenum, Vanadium, Nickel, Titanium <sup>(1)</sup> Brinell Hardness Testing
Cylinder Wall Type	Siamese
Cylinder Wall Thickness	.200 <sup>(2)</sup>
Deck Height	10.240"
Cylinder Bore Range	4.120 to 4.400"
Number Main Cap Bolts	4
Main Cap Bolts	Dowel pinned and splayed
Main Cap Type	Billet Steel
Cam Tunnel Options	50 mm or 55 mm
Crank Journal	3"
Crankshaft Seal	2 pc
Max Cylinder Stroke	4.75"

<sup>(1)</sup> A brinell hardness and tensile strength is check on every pour.

<sup>(2)</sup> 200 thick is a target thickness estimated only

A sonic sheet is given with all blocks shipped.

We reserve the right to change the dimensions of the block and materials without notice.

Part No.	Product Line	Part Type	Engine Block Style	Engine Block Material	Siamese Cylinder Bores	Deck Height	Quantity	Price
APSJJB	IA II Pontiac Engine Block	Engine Block, Bare	Standard Deck	Cast Iron	4.400	10.240	Sold individually	\$3,195.00

**Options:**

- Custom Bore Size - N/C
- 3.250 Crank Journal - N/C
- Bronze Lifter Bushings \$250.00
- Roller Cam Bearings \$375.00

**Finishing Kit:**

Includes all pipe plugs, 5/16 dowel pins and Standard screw in Freeze Plugs. \$45.00

Oil Pump Drive Shaft included in price.



# Engine Blocks

No more leaking freeze plugs!

AllPontiac freeze plugs are designed to keep the fluid inside your engine block. This can also eliminate the cost of a machine shop installation. All freeze plug holes are threaded for screw in freeze plugs to protect you in case of a head gasket blowing and pushing out a pressed in freeze plug.

## Expansion Plugs

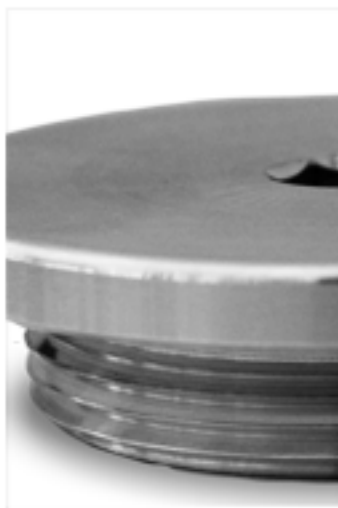
### B. AP-FP

#### Engine & Components, AllPontiac Freeze Plug Set

- With "O" ring insert
- Must use a 10mm Hex Allen Wrench
- Will work on aluminum or cast iron blocks



**B** AllPontiac Freeze Plug Set

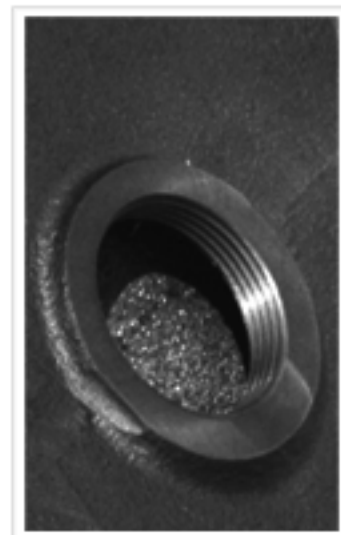


**B** AllPontiac Freeze Plug (closeup)



**B** AllPontiac Freeze Plug (front)

Part No.	Product Line	Part Type	Expansion Plug Style	Expansion Plug Material	Quantity	Price
AP-FP	AllPontiac Freeze Plug Set	Engine Block Expansion Plug	Threaded with "O" ring insert	Aluminum	Sold as a set of 6	\$85.00



**B** Freeze Plug Hole Closeup



IA II Standard Freeze Plug Kit **C**

## Expansion Plugs

**C. AP-FPK**  
 Engine & Components,  
 IA II Standard Freeze Plug Kit

- With "O" ring insert
- Will work on aluminum or cast iron blocks

## Oil Pump Driveshaft

**D. AP-OPS**  
 Engine & Components,  
 IA II Standard Oil Pump Driveshaft

- Designed specifically for the latest production version of the IA II Standard Deck Pontiac Engine Block.



IA II Standard Oil Pump Driveshaft **D**

**IA II Standard Freeze Plug Kit Consists of:**

- (5) - 2 - 3/8" STD NPT black plugs for front oil gallery flush fit  
 2 - 3/8" STD NPT thread for rear gallery  
 1 - 3/8" STD NPT for oil pressure (top of block)
- (4) - 2 - 1/2" STD NPT for oil (rear of block)  
 2 - 1/2" STD NPT for cooling (rear, near deck)
- (3) - 2 - 1/8" STD NPT for cooling drain (lowest side of block)  
 1 - 1/8" STD NPT oil pressure at front
- (2) - 1" Short NPT for cooling at rear of block
- (6) - 1 1/2" STD NPT brass freeze plugs (sides of block)
- (1) - 15/16" STD Expansion plug for oil gallery plug location
- (1) - 2 1/6" STD Expansion plug for camshaft tunnel
- (4) - 5/16 Head dowel pins

Part No.	Product Line	Part Type	Expansion Plug Style	Expansion Plug Material	Quantity	Price
AP-FPK	IA II Standard Freeze Plug Set	Engine Block Expansion Plug	Threaded with "O" ring insert	Brass	Sold as a set of kit	\$45.00

Part No.	Product Line	Part Type	Quantity	Price
AP-OPS	IA II Standard Oil Pump Driveshaft	Engine Block Oil Pump Driveshaft	Sold individually	\$19.00