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INSTALLATION METHOD FOR MAIN STUD KITS
190,000 Psi 7/16-inch Diameter

- [1] To ensure proper thread engagement and accurate torque readings, clean and re-tap ALL threads in the block. Re-tap only if necessary.
- [2] Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
- [3] Screw studs into the block "HAND TIGHT ONLY".
Note: LOCTITE MAY BE USED IF A PERMANENT MOUNTING OF THE STUDS IS PREFERRED. THE FASTENERS, HOWEVER, MUST BE TORQUED PRIOR TO THE LOCTITE SETTING UP.
- [4] Install main caps and check for binding or misalignment. Lubricate the threads of the studs, nuts and washers with ARP Moly Assembly Lubricant or 30wt motor oil.
- [5] ARP recommends using the **ARP MOLY LUBRICANT** or at the very least, a good quality Moly Lubricant as opposed to motor oil. This is due to higher friction on the studs as well as inconsistencies in the clamping force of the fasteners when motor oil (or a low quality lubricant) is used.

PRELOAD (TORQUE) RECOMMENDATIONS:

- [A] Torque values are based on 75% of the fasteners yield strength. Use the manufacturers torque sequence but do not use the engine manufacturers torque specs. Torque the nuts to 70 ft lbs for **ARP MOLY ASSEMBLY LUBRICANT** or torque to 85 ft lbs with 30wt motor oil.

FOOTNOTE: When changing from factory fasteners to high strength fasteners, clamping force and tolerances will change. The main bore should be align honed using the same fasteners which will be installed at the recommended preload.

NOTE: Do not use any other Moly Lube. Use only ARP Moly Lube or main cap walk failure can result.