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PROFESSIONAL QUALITY FASTENERS

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INSTALLATION METHOD FOR MAIN STUD KITS

Part Number: 208-5405 Application: Honda CBR1000RR

1. To ensure proper thread engagement and accurate torque readings, clean **ALL** threads in the engine case. Chase the threads if necessary with a Thread Chaser.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
3. Screw the studs into the engine case “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. Assemble the case halves according to OEM procedures and check for binding or misalignment.
5. Apply a small dab of silicone on the bottom of four washers and install the washers on studs 7, 8, 9 & 10 of the bolt torque sequence. These are the studs that locate on the outside of the engine case **(see illustration)**.
6. Install the remaining washers in the center of the case.
7. Lubricate the stud threads, and the nut faces with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the nuts onto the studs and tighten them hand tight. **ARP recommends using the ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT that is provided with each kit 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 other low quality lubricants are used.**

PRELOAD (TORQUE) RECOMMENDATIONS

6. Following the manufacturers recommended torque sequence tighten the nuts **in two equal steps** to the specifications listed below **with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT.**

35 ft-lbs for applications meeting OEM load requirements
48 ft-lbs for applications exceeding OEM load requirements

FOOTNOTE: When changing from factory fasteners to high strength fasteners, clamping force and tolerances will change, therefore it will be necessary to check the main bearing bores for proper size and out of round condition after installation of the studs and align hone the engine case if necessary. The main bores should always be align honed using the same fasteners and lubricant which will be installed during final engine assembly at the recommended preload.

Bolt Torque Sequence