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INSTALLATION METHOD FOR MAIN STUD KITS

Part Number: 258-5601 Application: FORD 7.3L GODZILLA

TOOLS NEEDED:

12mm, 14mm socket
4mm, 5mm Allen wrench

1. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. 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 block hand tight, do not apply torque. The hex broach in the end of the stud is designed to assist with installing/removing the studs from the block, not for applying torque.
4. Install the main caps and check for binding or misalignment.
5. Lubricate the stud threads and bottom of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and thread down by hand.
   Lubricate bolt threads with Ultra-Torque and RTV sealant below bolt head.

TORQUE PROCEDURE

6. Following the sequence below, tighten the nuts and bolts in three equal steps to:
   1. Tighten nuts 1 - 10 to **40 ft-lbs**
   2. Tighten nuts 11 - 20 to **25 ft-lbs**
   3. Tighten nuts 1 - 10 to **80 ft-lbs**
   4. Tighten nuts 11 - 20 to **50 ft-lbs**
   5. Tighten nuts 1 - 10 to **120 ft-lbs**
   6. Tighten nuts 11 - 20 to **70 ft-lbs**
   7. Tighten bolts 21 - 30 to **60 ft-lbs**

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 cylinder block 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.

TORQUE SEQUENCE