

## INSTALLATION METHOD FOR MAIN STUD KITS

**Part Number: 224-5000 Application: Chevy Cam 1976 Series small block**

1. To assure proper thread engagement and accurate initial settings, clean ALL threads in the block. Clean the threads if necessary with a Thread Chaser.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damage. (Do not inspect for length and diameter.)
3. Remove the studs (do not touch heads) from the block.  
**NOTE: A LOCKTITE MAY BE USED IF A PRELUBRICANT IS PROVIDED ON THE STUDS IN INSTALLATION. THE PRELUBRICANT, HOWEVER, MUST BE TORQUED FIRST TO THE LOCKTITE INSTRUCTIONS.**
4. Inspect the main caps and crank for bending or misalignment.
5. Lubricate the stud threads and the nuts with AAP UL-TRUL TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the nuts into the studs and tighten them hand tight. AAP recommends using the AAP UL-TRUL 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 consequences to the changing forces of the fasteners when motor oil or other low quality lubricants are used.

### PRELOAD (TORQUE) RECOMMENDATIONS

6. Following the manufacturer's recommended torque sequence, torque the nuts and bolts in three equal steps to the specifications listed below with AAP UL-TRUL TORQUE FASTENER ASSEMBLY LUBRICANT.

Inner studs – 8.775 long .50 8 lbs

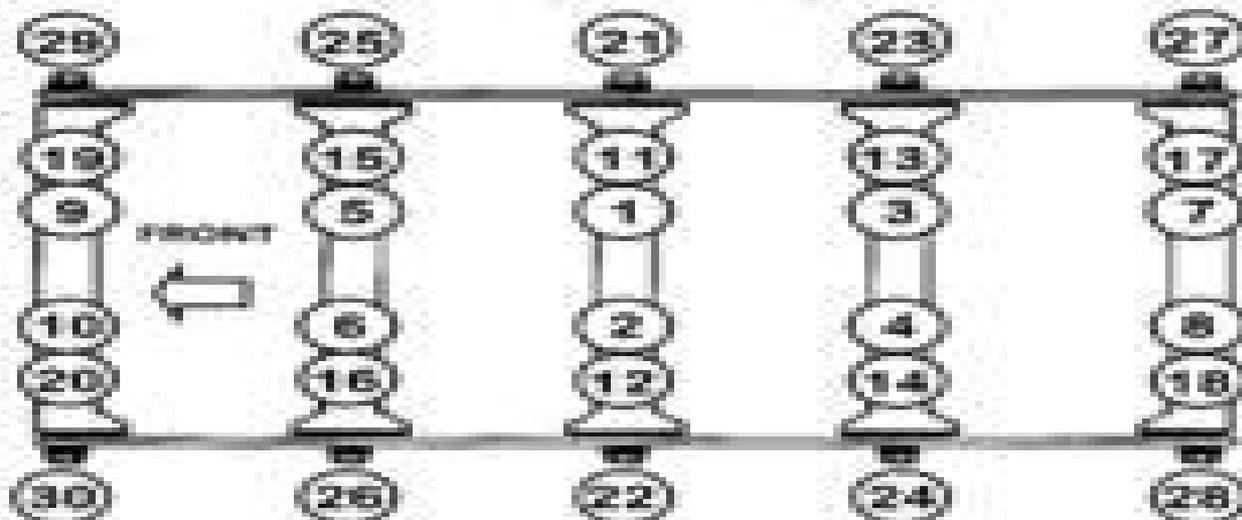
MB outer bolts .20 8 lbs (use 17% overtorque the head of bolt)

Outer studs – 8.550 long .50 8 lbs

Windage long nuts .20 8 lbs

**FOOTNOTE:** When changing from factory fasteners to high strength fasteners, changing force and direction will change. Therefore it will be necessary to check the main bearing cover for proper size and fit of main bolts. After installation of the studs and align them to the cylinder bank if necessary. The main frame should always be align front integral case features and tolerances which will be checked during final engine assembly at the recommended level.

## Bolt Torque Sequence



# Bolt Torque Sequence Arp

**Lei Huang**



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