

## INSTALLATION METHOD FOR MAIN STUD KITS

**Part Number: 224-5000 Application: Chevy Cam 350L Series small block**

1. To assure proper thread engagement and accurate initial loadings, clean ALL threads in the block. Clean the threads (Pressure wash with a Thread Chaser)
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damage. (Use proper fit, length and direction)
3. Remove the studs (do not touch heads) from the block.  
**NOTE: A LOCKTITE MAY BE USED IF A PROFESSIONAL INDUSTRIAL OR THE STUDS IS RECOMMEND.**  
**THE FASTENERS, HOWEVER, MUST BE TORQUED PROPER TO THE LOCKTITE INSTRUCTIONS.**
4. Inspect the main caps and check for bending or misalignment
5. Lubricate the stud threads and the nuts with AAP UL-TRAL TORQUE ASSEMBLY LUBRICANT. These caps and nuts into the studs and tighten them hand tight. AAP recommends using the AAP UL-TRAL 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, tighten the caps and nuts in three equal steps in the quantities listed below with AAP UL-TRAL TORQUE FASTENER ASSEMBLY LUBRICANT.

Inner studs – 4.775 long .50 8 lbs

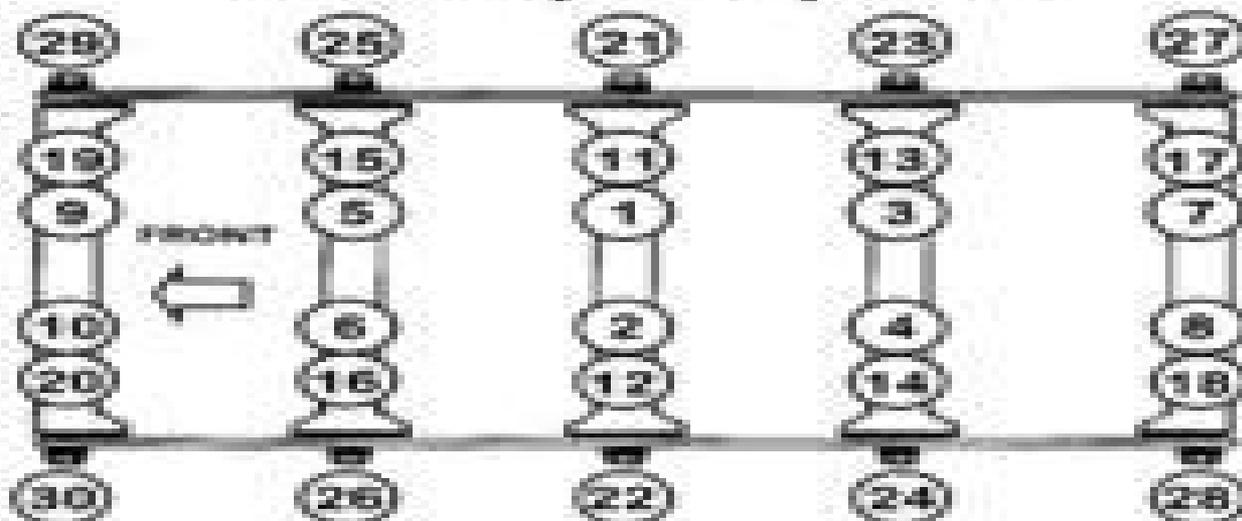
MS outer bolts .20 8 lbs use 17% overtorque the head of bolt

Outer studs – 4.550 long .50 8 lbs

Windage long nuts .25 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 fasteners after installation of the studs and align them to the cylinder bank if necessary. The main frame should always be align front integral case fasteners and tighten which will be checked during final engine assembly at the recommended level.

## Bolt Torque Sequence



# Bolt Torque Sequence Arp

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