

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. (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 crank for bending or misalignment.
5. Lubricate the stud threads and the nuts with AAP UL-TRAL TORQUE ASSEMBLY LUBRICANT. These caps and nuts are the studs and tighten them from front side. 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 to the specifications listed below with AAP UL-TRAL TORQUE FASTENER ASSEMBLY LUBRICANT.

Inner studs – 8.775 long .50 8 lbs

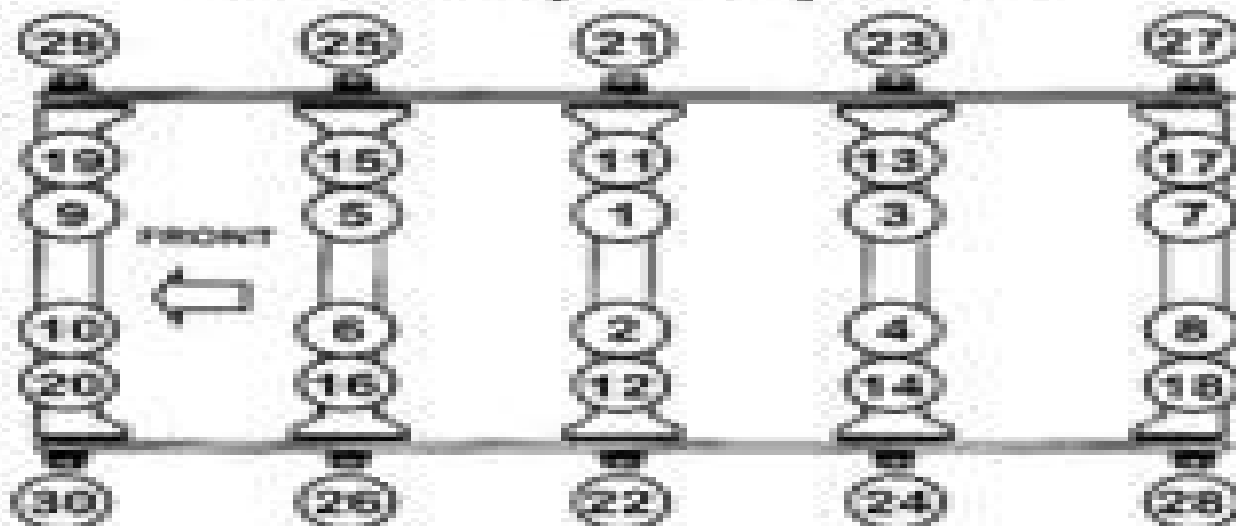
MS outer bolts .20 8 lbs use 17% overtorque the head of bolt

Outer studs – 8.550 long .50 8 lbs

Windage long nuts .25 8 lbs

FOOTNOTE: When changing from factory fasteners to high strength fasteners, changing from steel and aluminum 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 from the cylinder bank if necessary. The main frame should always be align from cylinder cover fasteners and adjuster which will be checked during final engine assembly at the recommended level.

Bolt Torque Sequence



Bolt Torque Sequence Arp

Julia Schneider



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Table of Contents Bolt Torque Sequence Arp

1. Understanding the eBook Bolt Torque Sequence Arp
 - The Rise of Digital Reading Bolt Torque Sequence Arp
 - Advantages of eBooks Over Traditional Books
2. Identifying Bolt Torque Sequence Arp
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Bolt Torque Sequence Arp
 - User-Friendly Interface
4. Exploring eBook Recommendations from Bolt Torque Sequence Arp
 - Personalized Recommendations
 - Bolt Torque Sequence Arp User Reviews and Ratings
 - Bolt Torque Sequence Arp and Bestseller Lists
5. Accessing Bolt Torque Sequence Arp Free and Paid eBooks
 - Bolt Torque Sequence Arp Public Domain eBooks
 - Bolt Torque Sequence Arp eBook Subscription Services
 - Bolt Torque Sequence Arp Budget-Friendly Options

6. Navigating Bolt Torque Sequence Arp eBook Formats
 - ePub, PDF, MOBI, and More
 - Bolt Torque Sequence Arp Compatibility with Devices
 - Bolt Torque Sequence Arp Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Bolt Torque Sequence Arp
 - Highlighting and Note-Taking Bolt Torque Sequence Arp
 - Interactive Elements Bolt Torque Sequence Arp
8. Staying Engaged with Bolt Torque Sequence Arp
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Bolt Torque Sequence Arp
9. Balancing eBooks and Physical Books Bolt Torque Sequence Arp
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Bolt Torque Sequence Arp
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Bolt Torque Sequence Arp
 - Setting Reading Goals Bolt Torque Sequence Arp
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Bolt Torque Sequence Arp
 - Fact-Checking eBook Content of Bolt Torque Sequence Arp
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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