

## 6.2/6.5L Main Stud Installation

**These instructions are intended for our custom-engineered kits only. Do not use these instructions for any sort of kit from another supplier. We also do not recommend the use of any type of girdle with these that could compromise stud clamping ability to prevent main cap 'walking'.**

With the main bearing caps in place, screw the studs in gently until they bottom out.. Longer studs go down the center and shorter studs go in the outside holes. Next, use the supplied ARP thread lube coat the threads, washers and nuts. It is important that the stud threads and all load-bearing surfaces of the washers and nuts be coated lightly with the supplied lube. This ensures you get consistent torque readings.

### **Torque settings:**

First round of torque is done at 20 lbs ft. Each additional round is done in 10 lb ft increases.

#### For blocks with all 12mm studs:

Final torque is 90 lbs. on all inner 12mm studs.

Final torque is 80 lbs. on all outer 12mm studs.

#### For 506 blocks with 12 mm and 10mm outer studs:

Final torque is 90 lbs. on all inner 12mm studs.

Final torque is 80 lbs. on the 4 outer 12mm studs.

Final torque is 50 lbs on the 6 outer 10mm studs.

### **Torque sequence:**

The main caps are numbered 1-5. #1 is at the front of the block (See Image Below). For all nut torquing, the proper cap sequence is as follows: #3, #2, #4, #1, #5.

Start with main bearing #3. This bearing is the 'thrust' bearing for the crankshaft. After all bearing caps are in place, tighten the #3 inner nuts to 10 lb ft. Using a soft mallet, tap the crankshaft back and forth to locate the #3 thrust cap. Torque the #3 cap inner nuts to 20 lbs ft and with the crankshaft forced forward, check crankshaft endplay to ensure there is .004 - .010" clearance.

Next, rotate through the sequence setting all inner nuts to 20 lbs ft. Then, in the recommended cap sequence, torque all outer nuts to 20 lbs ft.

Continue to rotate through the sequence (#3, #2, #4, #1 & #5) first inner then outer nuts, increasing torque in 10 lb ft increments until you reach the final torque settings listed above for your respective block style.

### **Main Cap Identification**

