

TIGHTENING METHOD

BLT-MK-STUD-DUR-2.0L

Main stud kit.

ISSUE DATE: August 2015

If you are using our main stud kit with our SBD/Titan dry sump system, please ensure you read the dry sump fitting instructions before continuing.

METHOD

ARP lubricant must be used on all threads and underneath face of nut and washer.

BEFORE CRADLE IS INSTALLED: -

- 1. Ensure threads in block & on stud are completely clean**
- 2. Apply lubricant to stud threads & screw stud into block finger tight only.**

Once crank and cradle is installed, fit nut & washer then: -

STAGE 1---25 LB/FT

STAGE 2---Back off ½ turn

STAGE 3---25 LB/FT

STAGE 4---60 LB/FT

STAGE 5---Back off ¼ turn

STAGE 6---60 LB/FT

DURATEC MAIN STUD TIGHTENING SEQUENCE

8	4	1	5	9
7	3	2	6	10

DURATEC MAIN STUD REMOVAL SEQUENCE

3	7	10	6	2
4	8	9	5	1

Please be aware that Technical Support involving our Technicians is chargeable



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