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INSTALLATION METHOD

FOR MAIN STUD KITS

Kit Number: **K063-M01S**

Application: **FORD
GODZILLA 7.3L**



Point One, LLC

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Kit: KO63-M01S Alloy: S220 Sockets Required: 1/2", 10MM

KIT CONTENTS

(10) ST7S Stud, MJ10x1.5 x MJ10x1.25 x 4.85" OAL, S220, Black Oxide Finish

(10) ST8S Stud, MJ12x1.75 x MJ12x1.25 s 5.14" OAL, S220, Black Oxide Finish

(10) BG7S 12PT Flange Bolt, MJ10x1.5 threads, 40.1mm UHL, 12mm wrench, S220, black oxide finish

(10) NF7F 12pt Flange Nut, MJ10x1.25 threads, 12mm wrenching, black oxide finish

(10) NE9F 12pt Flange Nut, MJ12-x1.25 threads, 14mm wrenching, black oxide finish

(10) WD2T Flat Washer, M10 nominal, hardened and ground, black oxide finish

(10) WA6T Flat Washer, M12 nominal, hardened and ground, black oxide finish

(10) WD1T Chamfered Washer, M10 nominal, hardened and ground, black oxide finish

LB01 TORQUEPOINT Fastener Assembly Lube, 1oz packet

LB8R Lube application brush

FASTENER INSTALLATION

(NOTE: THIS PROCESS IS IDENTICAL TO WHAT WE DO DURING TORQUE-TENSION TESTING AT P1 HQ)

1. Inspect kit contents for damage and confirm quantities.
2. Thoroughly clean all debris from engine block holes and threads, and main cap holes and threads.
3. Ensure all mating surfaces and fastener bearing surfaces are flat, free of debris and dry of any cleaning related products.
4. Remove fasteners from packaging and place on clean shop rag, clean threads as required, (do not unnecessarily remove rust preventative).

5. WITHOUT LUBE, thread studs into their intended holes BY HAND ONLY until the stud bottoms or thread run-out occurs (DO NOT USE TOOLS). Achieving smooth installation without tools is necessary. Remove fasteners and clean or repair threads if needed.
6. WITHOUT LUBE, thread side bolts into their holes into the main cap holes BY HAND ONLY until thread run out occurs (DO NOT USE TOOLS). Achieving smooth installation without tools is necessary. Remove fasteners and clean or repair threads if needed.
7. Remove fasteners from their holes and liberally apply TorquePoint assembly lube to entire length of block end threads of the studs using included brush. Work lube into threads all the way around threaded sections so lube is nearly flush with outer diameter of thread face.
8. Install studs into block by hand or using hex key with light force only.
9. Thoroughly clean any visible fastener lube from fasteners and mating surfaces and fit caps into block.
10. Install washers on main studs (DO NOT APPLY LUBE TO THE WASHERS)
11. Apply TorquePoint assembly lube to entire length of nut end threads of the fastener using included brush. Work lube into threads all the way around the threaded sections so lube is nearly flush with outer diameter of thread face. Lube should be evenly distributed and not excessive.
12. Apply TorquePoint to each nut's bearing surface only.
13. Install main cap nuts hand tight (firmly). Washers should not rotate during torque procedure.
14. Apply TorquePoint assembly lube to side bolt threads and under bolt head. Do not apply lube to washers. Observe the chamfered side of washer and be sure the chamfered side is facing the under head of the bolt. Install side bolts with washers BY HAND. Washers should not rotate during torque procedure.

TORQUE RECOMMENDATIONS

Follow applicable OEM and/or aftermarket manufacturers suggested torque sequence & number of tightening steps.

Point One fasteners, paired with TorquePoint assembly lube, can sustain the following nominal torques and clamp loads while remaining below their minimum proof load rating.

*****DO NOT EXCEED THESE TORQUE INPUT VALUES*****

*****THESE VALUES WILL NOT BE APPLICABLE WHEN USING OTHER LUBRICANTS*****

**ST7S Stud w/NF7F Nut
MJ10x1.25 threads**

Torque: **65 ft-lbs**
Typical Clamp Load: **11,200 lbs-force**

**ST8S Stud w/NE9F Nut
MJ12x1.25 threads**

Torque: **120 ft-lbs**
Typical Clamp Load: **16,200 lbs-force**

**BG7S Side Bolt
MJ10x1.25 threads**

Torque: **60 ft-lbs**
Typical Clamp Load: **10,750 lbs-force**

Note: The number of aftermarket replacement parts and OEM combinations of components is numerous. **Use caution as the clamp loads listed above may damage your assembly** – use lower installation torques such as those provided by the manufacturer of your components if applicable.