

INSTALLATION METHOD FOR PRO SERIES MAIN BOLT KITS

Part Number: 140-5002 & 5003 **Application:** Chrysler 273-440 CID V8

1. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages.
2. To ensure proper thread engagement and accurate torque readings, clean all threads in the block. Chase if necessary with ARP Thread Chaser, part number 911-0005 (1/2-13).
3. Apply ARP Ultra-Torque Fastener Assembly Lubricant to the bottom side of the bolt head. Place the washer on the bolt with the inside diameter chamfer facing the bolt head. Lubricate the bolt threads then install in the block hand tight.

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TORQUE PROCEDURE

4. Following the manufacturer's recommended torque sequence, tighten the bolts per the steps below
 - 1- Torque bolts to 35 ft-lbs
 - 2- Torque bolts to 70 ft-lbs
 - 3- Torque bolts to 110 ft-lbs

FOOTNOTE: When changing from factory fasteners to high strength fasteners, clamping force and tolerances will change, therefore it will be necessary to check the main bearing bores for proper size and out of round condition after installation of the bolts and align hone the cylinder block if necessary. The main bores should always be align honed using the same fasteners and lubricant which will be installed during final engine assembly at the recommended preload.

NOTE: Use of a washer on the bolt located below the oil pump is optional. Check for adequate clearance between the bolt head and oil pump. Remove material from the pump to create adequate clearance.

