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## **INSTALLATION METHOD FOR MAIN STUD KITS**

**Part Numbers: 156-5404 Application: Ford Modular 5.0L M-6010-BOSS50 V8**

1. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages. Please call 800-826-3045 with any questions or issues.
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 912-0003 (M10 x 1.5).
3. Screw the studs into the block, do not apply torque. The hex broach in the end of the stud is designed to assist with installing / removing the studs from the block, not for applying torque.
4. Install the main caps and check for binding or misalignment.
5. Install the washers. Lubricate the stud threads, and bottom side of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and tighten them hand tight.

### **TORQUE PROCEDURE**

6. Following the manufacturer's recommended torque sequence, tighten the nuts per the steps below:
  1. Torque nuts to 20 ft-lbs
  2. Torque nuts to 40 ft-lbs
  3. Torque nuts to 60 ft-lbs

**NOTE:** The oil pickup mount stud will affect clearance to oil pan. Check clearance and adjust as needed before final assembly.

**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 studs 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.