



Product Instructions

#21-060 302 MAIN SUPPORT

- 1) Unpack main support and check parts to make sure kit includes main support, 10 main bolts and 10 Washers.
 - 2) Lay main support on main caps. Install bolt and washer on #1 main cap below the oil pump and on #5 main. Tighten snug only.
 - 3) Install oil pump to check for interference. Most will require grinding right above the main bolt.
 - 4) Remove oil pump and modify as needed.
 - 5) Slowly turn crankshaft to check for interference between connecting rod bolts, rods, and the main support. Modify as needed. Will clear most stroke/rod combinations.
 - 6) Install all main bolts & washers. Use the manufacturers torque sequence with the following torque specs: Moly Lube: 30 ft. lbs., then 45 ft. lbs., and final 60 ft. lbs.; 30W Oil: 40 ft. lbs., 60 ft. lbs., 85 ft. lbs.
 - 7) Rotate crankshaft again to check for interference.
 - 8) Install oil pump but do not fully tighten bolts.
- **Note: If using #20-960 windage tray, install at this stage.**
- 9) Remove the main bolt that corresponds with the pickup tube mounting tab. Attach pickup to oil pump and tighten flange. Reinstall main bolt and washer through pickup mounting tab and tighten snug. Torque oil pump mounting bolts to 35 ft. lbs. Retorque main bolt as listed in step #6.
 - 10) Using a straight edge and a ruler, check pickup tube cup height from engine block surface. Lay gasket on oil pan and measure inside sump depth. Distance between pickup cup and pan bottom should be 3/8" to 1/2". Adjust pickup as needed.

****Note: Use with stock oil pans is not recommended.**

