INSTALLATION - SERVICE INSTRUCTIONS

MARK WILLIAMS ENTERPRISES

PART NUMBERS : DESCRIPTION :

53950	8-3/4" Mopar STEEL MAIN CAP, with 3.265 Bore
57502	9" Ford steel main cap, with 2.891" Bore
57503	9" Ford steel main cap, with 3.0625" Bore
58502	'57-'64 Olds steel main cap with 3.265 Bore

PARTS INCLUDED :

53950	1ea-Cap, 2ea-1/2"-13 X 21/2" socket head cap screws, 2ea-1/2" washers
57502	1ea-Cap, 2ea-1/2"-13 X 21/2" socket head cap screws, 2ea-1/2" washers
57503	1ea-Cap, 2ea-1/2"-13 X 21/2" socket head cap screws, 2ea-1/2" washers
58502	1ea-Cap, 2ea-1/2"-13 X 21/2" socket head cap screws, 2ea-1/2" washers

APPLICATIONS :

To replace a broken cap or upgrade from an o.e.m. cast-iron cap.

INSTALLATION OVERVIEW :

1) Insert by hand the two furnished bolts until they bottom out. Measure the distance from the bottom of the bolt head to the mating surface between cap and case. This distance can not be greater than 1-9/16". (figure A) If it is over 1-9/16" it will be necessary to drill and tap the threads deeper.

2) Place the cap on the case and start the main bolts. Observe that there is enough movement to align the threads in the cap with the threads in the case. If the threads will not align it will be necessary to change caps or use a different case that aligns.

3) Remove the cap, and place the adjuster nut in the threaded cap. with the adjuster in the cap place the cap on the case using the adjuster to align the threads in the case. hand tighten the cap making sure that the adjuster is aligning with the threads in the case. Torque the bolts to 85 ft lbs.

4) Using an inside micrometer, measure the bore dimension as shown (figure B).

5) Subtract the final bore dimension from the measured bore dimension to determine how much needs to be removed from the cap parting surfaces. The cap can be milled or ground in a rod cap grinder to remove the excess material. Carefully de-burr the threads and edges. Reinstall the cap, aligning the cap with the adjuster and the housing bore then re-torque the bolts. Check the final bore size. (figure B)

TORQUE SPECS :

85-90 Ft Lbs

MAINTENANCE REQUIREMENTS :

Periodically check the cap bolt to ensure that they are properly tightened.