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INSTALLATION GUIDE FOR MAIN STUD KIT

CHEV-GM LS SERIES PRW PART NUMBER: 1000098 (MCK-346)
& 1000099 SIDE BOLT KIT (MCB-346)

COMPONENT PARTS LIST

ITEM	QTY
PRW PN: 100098 [MCK-346] Assembly & 1000099 (Side Bolts Only)	
M10 Inner Studs (121.2mm Long)	10 each
M10 Outer Studs (115.6mm Long)	10 each
M10 12 pt Head Nuts	20 each
M8 Windage Tray Serrated Flange Nuts	10 each
M8 – Main Cap Side Bolts (Side Bolt Kit 1000099)	10 each
PRW-CMD Extreme Pressure Assembly Lube (0.5 ounce tube)	1 each
PRW Threadlocker, Blue (2ml tube)	1 each
Installation Guide	1 each

SPECIAL NOTE: In preparation for the installation of this assembly, be aware that it will be necessary to check the main bearing bores for proper size and out of round condition after installation. The high strength alloy fasteners and additional clamping force will alter the factory tolerances and require align boring and honing using the installed assembly components torqued to the recommended preload. Contact a qualified machine shop or engine builder with the proper equipment to complete this task.

TOOLS AND PROCEDURES

1. Proper Installation Tools are required. Do NOT use an impact drive for assembly.
2. Do NOT use standard taps to cleanup cylinder head and/or engine block threads.
3. Read these directions thoroughly before starting the installation.

STOP!

- a. Clean all engine block work areas adjacent to the parts being installed.
- b. Use a thread chaser to clean ALL threads in the block to ensure proper thread engagement.
- c. Check all new studs, nuts and related fasteners for any shipping damage or defects.
- d. Inspect and test install to assure proper dimensions and fitment prior to final installation.
- e. If you are using threadlocker to secure the studs in the block; torque before the sealant cures.
- f. Always install and torque side bolts after applying torque to main cap studs or bolts.

INSTALLATION

Step 1: If using threadlocker, apply to the coarse end of the studs, and hand-tighten into the block.

Step 2: Otherwise, set the threadlocker aside and “**hand-tighten**” by screwing each stud into the block.

Step 3: Carefully install the main caps, checking closely for any misalignment or binding.

Step 4: Lubricate exposed stud threads and nuts with *Extreme Pressure Assembly Lube* provided.

Step 5: Install the nuts on the studs and “hand-tighten” each one onto the mating surface.

Step 6: Apply RTV sealant under the head of the M8 engine side bolts prior to threading into place.

Step 7: Using the preload torque recommendations below, begin the final installation process.

Step 8: If threadlocker is being used, make certain that the torque task is completed before the sealant has cured.

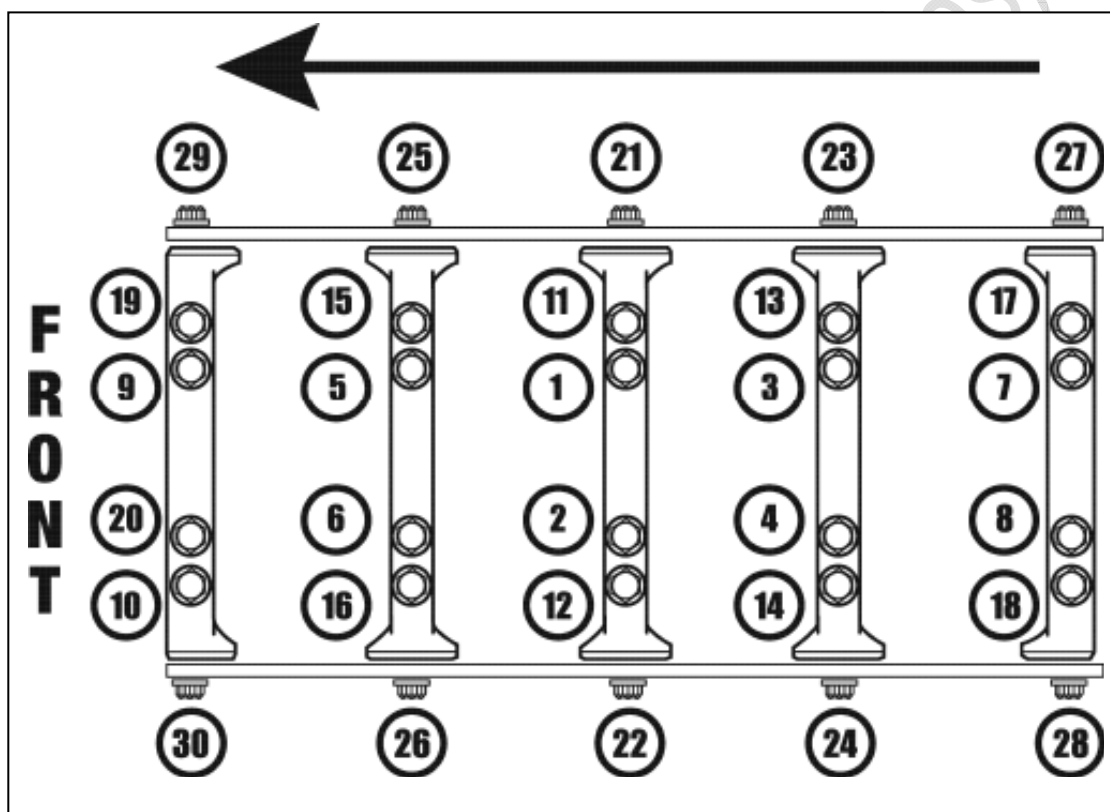
TORQUE RECOMMENDATIONS

Following the manufacturer's recommended torque sequence (see chart below) tighten the nuts and bolts in three equal steps to specifications listed below. All torque specifications listed below are detailed for **PRW-CMD Extreme Pressure Lube** provided with the assembly.

Fastener Component	Torque
<i>M10 Inner Studs</i>	<i>60 Lbs Ft</i>
<i>M10 Outer Studs</i>	<i>50 Lbs Ft</i>

Fastener Component	Torque
<i>M8 Windage Tray Nuts</i>	<i>28 Lbs Ft</i>
<i>Main Cap Side Bolts</i>	<i>20 Lbs Ft</i>

STUD TORQUE SEQUENCE



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