



MAIN STUD KIT

KIT NUMBER

K033-M02S

APPLICATION

CHRYSLER GEN III HEMI, DART
IRON BLOCK MAIN STUD KIT,
12PT NUTS, S220 SERIES, BLACK
OXIDE FINISH

MAILING

PO BOX 677
ROGERSVILLE, MO, 65742

SHIPPING

11 WHITE OAK ROAD,
ROGERSVILLE, MO, 65742



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www.p1mfg.com

(417) 753-5174

FASTENER INSTALLATION

KIT CONTENTS

TORQUE RECOMMENDATION

1. Inspect kit contents for damage and confirm quantities.
2. Thoroughly clean all debris from engine block holes and threads.
3. Ensure all mating deck surfaces and fastener bearing surfaces are flat, free of debris and dry of any cleaning related products.
4. Inspect all deck gaskets for damage, fitment, & suitability.
5. Remove washers from packaging and remove rust preventative coating from all faces of washers, place on clean rag (petroleum-based solvent is recommended).
6. Remove remaining fasteners and place on clean shop rag, clean threads as required, (do not unnecessarily remove rust preventative).
7. Without lube, washers, gaskets or heads, thread studs into their intended holes by hand only until stud bottoms or thread run-out occurs (do not use tools). Achieving smooth installation without tools is necessary. Remove fasteners and clean or repair threads if needed.
8. Remove fasteners from their holes and apply TORQUEPOINT assembly lube to entire length of block end threads of the fastener using included brush. Work lube into threads all the way around the threaded sections so lube is nearly flush with outer diameter of thread face.
9. Install studs into block by hand or using hex key with light force only.
10. Thoroughly clean any visible fastener lube from mating surfaces and fit gasket and head on block and install washers onto studs. The washers should be dry during installation. DO NOT USE LUBE ON THE WASHERS.
11. Apply TORQUEPOINT assembly lube to entire length of nut end threads of the fastener using included brush. Work lube into threads all the way around the threaded sections so lube is nearly flush with outer diameter of thread face. Lube should be evenly distributed and not excessive.
12. Apply TORQUEPOINT lube to each nut's bearing surface only. Do not use lube on the washers. Install nuts with washers, hand tight. The washer should not rotate during torque procedure.

SE5S (10)	STUD - 7/16-14 UNJC x 7/16-20 UNJF x 3.75 [95.3] OAL, S220, BLACK OXIDE
SS4S (6)	STUD - 7/16-14 UNJC x 7/16-20 UNJF x 3.46 [87.9] OAL, S220, BLACK OXIDE
SKLS (4)	STUD - 3/8-16 UNJC x 3/8-24 UNJF x 2.25 [57.2] OAL, S220, BLACK OXIDE
WB1T (16)	WASHER - FLAT - M11-7/16 NOMINAL x .750 O.D. x .12 THK, HARDENED & GROUND, BLACK OXIDE
NB4F (16)	NUT -12PT FLANGE, 7/16-20 UNJF-3B, 1/2 WRENCH, .700 FL Ø, BLACK OXIDE
NA9F (4)	NUT -12PT FLANGE, 3/8-24 UNJF-3B, 7/16 WRENCH, .625 FL Ø, BLACK OXIDE
WC7T (4)	WASHER - FLAT - M9-3/8 NOMINAL x .640 O.D. x .12 THK, HARDENED & GROUND, BLACK OXIDE
TP0S (1)	TORQUEPOINT FASTENER ASSEMBLY LUBE, 0.5oz PACKET
LBBR (1)	LUBE APPLICATION BRUSH

Follow applicable OEM and/or aftermarket manufacturers suggested torque sequence & number of tightening steps.

Point One fasteners, paired with TORQUEPOINT fastener assembly lube, can sustain the following nominal torques and clamp loads while remaining below their minimum proof load rating.

*****DO NOT EXCEED THESE TORQUE INPUT VALUES*****

*****THESE VALUES WILL NOT BE APPLICABLE WHEN USING OTHER LUBRICANTS*****

SE5S, SS4S

Torque: **90 ft-lbs**
Typical Clamp Load: **14500 lbs-force**

SKLS

Torque: **50 ft-lbs**
Typical Clamp Load: **10500 lbs-force**

Note: The number of aftermarket replacement parts and OEM combinations of components is numerous. Use caution as the clamp loads listed above may damage your assembly - use lower installation torques such as those provided by the manufacturer of your components if applicable.