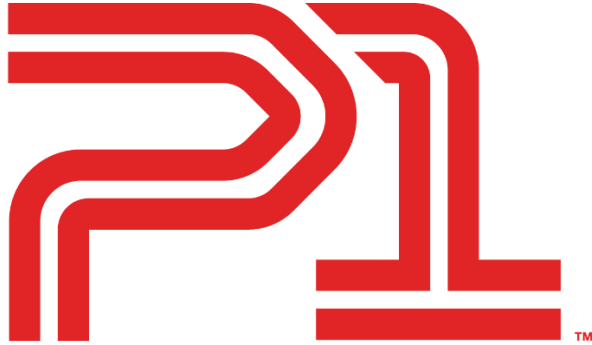




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INSTALLATION METHOD

FOR HEAD STUD KITS

Kit Number: K003-H12S

Application: DART
ALUMINUM LS NEXT, 1/2"
STUDS, 23 STUDS PER HEAD

Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

www.P1mfg.com

417-753-5174



Kit: K003-H12S

Alloy: S220

Sockets Required: 3/8", 7/16", 9/16"

KIT CONTENTS

(10) SA3S Stud, MJ8x1.25 x 5/16-24 threads, 2.52" OAL, S220, black oxide finish

(10) WC4T Flat Washer, M8 or 5/16" diameter, black oxide finish

(8) SH4S Stud, MJ8x1.25 x 5/16-24 threads, 2.73" OAL, S220, black oxide finish

(8) WB2T Flat Washer, M8 or 5/16" diameter, black oxide finish

(18) NA5F 12pt Flange Nut, 5/16-24 threads, 3/8" wrenching, black oxide finish

(8) SG8S Stud, 3/8-16 x 3/8-24 threads, 2.60" OAL, S220, black oxide finish

(8) WC7T Flat Washer, 3/8" diameter, black oxide finish

(8) NA9F 12pt Flange Nut, 3/8-24 threads, 7/16" wrenching, black oxide finish

(20) SR1S Stud, 1/2-13 x 1/2-20 threads, 4.25" OAL, S220, black oxide finish

(20) WA7T Flat Washer, 1/2" diameter, black oxide finish

(20) NB8F 12pt Flange Nut, 1/2-20 threads, 9/16" wrenching, black oxide finish

LBO1 TORQUEPOINT Fastener Assembly Lube, 1oz packet

LBBR Lube application brush

FASTENER INSTALLATION

(NOTE: THIS PROCESS IS IDENTICAL TO WHAT WE DO DURING TORQUE-TENSION TESTING AT P1 HQ)

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 the 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.

TORQUE RECOMMENDATIONS

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

P1 Fasteners, paired with TORQUEPOINT fastener assembly lube, can sustain the following nominal torque inputs 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*****

**SA3S, SH4S Stud w/NA5F Nut
5/16-24 threads**

Torque: **33 ft-lbs**

Typical Clamp Load: **7,300 lbs-force**

**SG8S Stud w/NA9F Nut
3/8-24 threads**

Torque: **50 ft-lbs**

Typical Clamp Load: **10,500 lbs-force**

**SR1S Stud w/NB8F Nut
1/2-20 threads**

Torque: **130 ft-lbs**

Typical Clamp Load: **19,000 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.