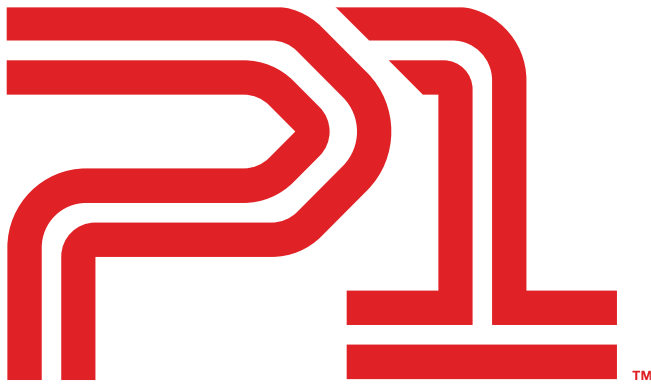




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INSTALLATION METHOD

FOR MAIN STUD KITS

Kit Number: K003-M03E

Application: **Chevrolet LS
GEN 3 & LSX (not for LT1)**



Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

Kit: K003-M03E Alloy: E190 Sockets Required: 14mm, 10mm

KIT CONTENTS

(10) SA5E Stud, MJ10x2.0 x MJ10x1.25 threads, 116mm length, E190, black oxide finish

(10) SA6E Stud, MJ10x2.0 x MJ10x1.25 threads, 121mm length, E190, black oxide finish

(10) BA9E 6pt Flange Bolt, MJ8x1.25 threads, M10 wrenching, E190, black oxide finish

(20) NE8F 12pt Flange Nut, MJ10x1.25 threads, 14mm wrenching, black oxide finish

(10) PNA11 6pt Serrated Flange Nut, M10x1.25 thread, 14mm wrenching, zinc finish (for windage tray)

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, and main cap holes and threads.
3. Ensure all mating surfaces and fastener bearing surfaces are flat, free of debris and dry of any cleaning related products.

4. Remove fasteners from packaging and place on clean shop rag, clean threads as required, (do not unnecessarily remove rust preventative).
5. WITHOUT LUBE, thread studs and bolts into their intended holes BY HAND ONLY until the 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.
6. Remove fasteners from their holes and liberally 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 threaded sections so lube is nearly flush with outer diameter of thread face.
7. Install studs into block by hand or using hex key with light force only.
8. Thoroughly clean any visible fastener lube from fasteners and mating surfaces and fit caps into block.
9. 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.
10. (DOES NOT APPLY TO SERRATED NUTS for windage tray) Apply TORQUEPOINT to each nut's bearing surface only.
11. Install main cap nuts hand tight.
12. For side bolts, apply TORQUEPOINT assembly lube under head bearing surface as well as threaded area.
13. Install side bolts hand tight.

TORQUE RECOMMENDATIONS

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

Point One fasteners, paired with TorquePoint 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*****

**SA5E Stud w/NE8F Nut
MJ10x1.25 threads**

Torque: **50 ft-lbs**

Typical Clamp Load: **9,000 lbs-force**

**SA6E Stud w/NE8F Nut
MJ10x1.25 threads**

Torque: **60 ft-lbs**

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

BA9E Bolt MJ8x1.25 threads

Torque: **25 ft-lbs**

Typical Clamp Load: **5,200 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.