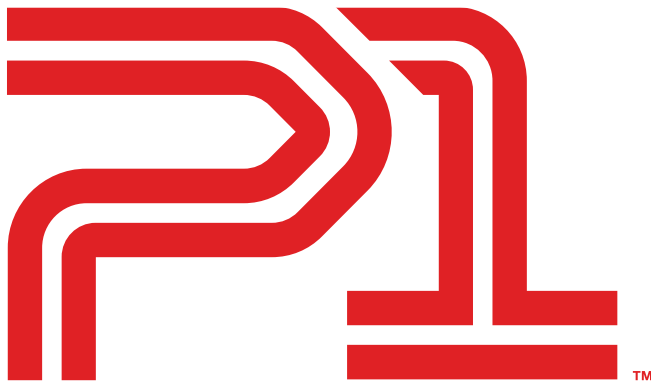




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INSTALLATION METHOD

FOR HEAD STUD KITS

Kit Number: **K003-H24S**

Application: **DART IRON LS
NEXT BLOCK W/ ALL PRO
12-5 HEADS, 1/2" STUDS**



Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

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417-753-5174

Kit: K003-H24S Alloy: S220 Sockets Required: 3/8", 7/16", 1/2", and 9/16"

KIT CONTENTS

(10) SA3S Stud, MJ8x-1.25 x 5/16-24 threads, 2.52" overall length, S220, black oxide finish

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

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

(8) SS6S Stud, 3/8-16 x 3/8-24 threads, 2.25" overall length, S220, black oxide finish

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

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

(8) SE4S Stud, 7/16-14 x 7/16-20 threads, 2.50" overall length, S220, black oxide finish

(8) WA4T Flat Washer, M11-7/16" nominal diameter, black oxide finish

(8) NB4F 12pt Flange Nut, 7/16-20 threads, 1/2" wrenching, black oxide finish

(10) SD4S Stud, 1/2-13 x 1/2-20 threads, 3.62" overall length, S220, black oxide finish

(10) SJES Stud, 1/2-13 x 1/2-20 threads, 5.10" overall length, S220, black oxide finish

(20) WG8T Flat Washer, 1/2" nominal 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.

Point One 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*****

SA3S Stud w/NA5F Nut 5/16-24 threads

Torque: **33 ft-lbs**
Typical Clamp Load: **7,300 lbs-force**

SS6S Stud w/NA9F Nut 3/8-24 threads

Torque: **50 ft-lbs**
Typical Clamp Load: **9,800 lbs-force**

SE4S Stud w/NB4F Nut 7/16-20 threads

Torque: **90 ft-lbs**
Typical Clamp Load: **14,000 lbs-force**

SD4S & SJES 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.