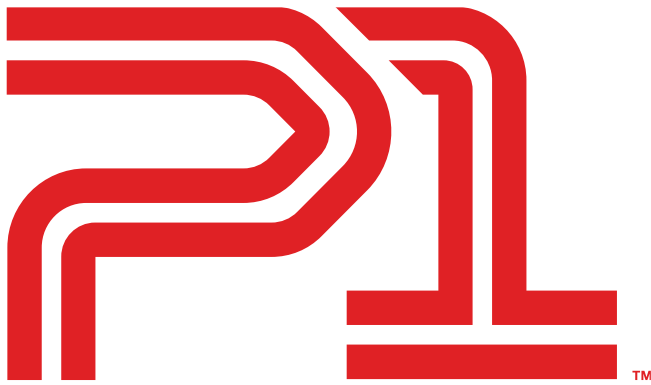




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INSTALLATION METHOD

FOR MAIN STUD KITS

Kit Number: **KO44-MO1S**

Application: **Dodge
Cummins 5.9L, 2003-
2007 W/Factory Block
Stiffener**

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: KO44-MO1S Alloy: S220 Sockets Required: 16mm, 15mm

KIT CONTENTS

(14) SF5S Stud, MJ12x1.5 x MJ12x1.25, 134mm length, S220, black oxide finish

(14) NF8F 12pt Flange Nut, MJ12x1.25 threads, 16mm wrench, black oxide finish

(14) PBA2Z 6pt Flange Bolt, MJ10x1.5 threads, 15mm wrench, black oxide finish

(1) (OPTIONAL USE) PBA3Z Button Hex Drive Bolt, MJ10x1.5 threads, 6mm hex drive wrench, 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, and main caps.
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. Apply TORQUEPOINT to each nut's bearing surface only.
11. Install main cap nuts hand tight.
12. Install block stiffener bolts after main caps are fully tightened.
13. For stiffener bolts, apply TORQUEPOINT assembly lube under head bearing surface as well as threaded area.
14. Install stiffener bolts hand tight.
15. (OPTIONALLY) Use button head bolt under oil pickup tube if required for clearance.

TORQUE RECOMMENDATIONS

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

Point One fasteners, paired with TORQUEPOINT thread 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*****

SF5S Stud w/NF8F Nut
MJ12x1.25 thread

Torque: **125 ft-lbs**
Typical Clamp Load: **19,300 lbs-force**

PBA2Z OR BPA3Z Bolt
MJ10x1.5 thread

Torque: **40 ft-lbs**
Typical Clamp Load: **8,000 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.