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LS MAIN STUD KIT INSTALLATION GUIDE

PART NUMBER(S): 100098 & 100099

COMPONENTS	QTY
M10 INNER STUDS	10
M10 OUTER STUDS	10
M10 12 PT HEAD NUTS	20
M8 WINDAGE TRAY SERRATED FLANGE NUTS	10
M8 MAIN CAP SIDE BOLTS (100099)	10
ASSEMBLY LUBE	1
BLUE THREADLOCKER	1

SPECIAL NOTE: In preparation for the installation of this assembly, be aware that it will be necessary to check the main bearing bores for proper size and out of round condition after installation. The high strength alloy fasteners and additional clamping force will alter the factory tolerances and require align boring and honing using the installed assembly components torqued to the recommended preload. Contact a qualified machine shop or engine builder with the proper equipment to complete this task.

1. Proper Installation Tools are required. Do NOT use an impact drive for assembly.
2. Do NOT use standard taps to cleanup cylinder head and/or engine block threads.
3. Read these directions thoroughly before starting the installation.

STOP!

- a. Clean all engine block work areas adjacent to the parts being installed.
- b. Use a thread chaser to clean ALL threads in the block to ensure proper thread engagement.
- c. Check all new studs, nuts and related fasteners for any shipping damage or defects.
- d. Inspect and test install to assure proper dimensions and fitment prior to final installation.
- e. If you are using threadlocker to secure the studs in the block; torque before the sealant cures.
- f. Always install and torque side bolts after applying torque to main cap studs or bolts.

INSTALLATION

- Step 1: If using threadlocker, apply to the course end of the studs, and hand-tighten into the block.
- Step 2: Otherwise, set the threadlocker aside and hand-tighten by screwing each stud into the block.
- Step 3: Carefully install the main caps, checking closely for any misalignment or binding.
- Step 4: Lubricate exposed stud threads and nuts with Assembly Lube provided.
- Step 5: Install the nuts on the studs and hand-tighten each one onto the mating surface.
- Step 6: Apply RTV sealant under the head of the M8 engine side bolts prior to threading into place.
- Step 7: Using the preload torque recommendations below, begin the final installation process.
- Step 8: If threadlocker is being used, make certain that the torque task is completed before the sealant has cured.

Torque Recommendations

Follow applicable OEM/aftermarket manufacturers suggested torque sequence and number specifications. Torque fasteners in 3 equal incremental steps until final torque specification is reached. The torque values provided are for the supplied lubricant only, other lubricants may need more or less torque and are not recommended.

M10 STUDS:
Torque: 60ft/lb

M8 WINDAGE TRAY NUTS:
Torque: 28ft/lb

MAIN CAP SIDE BOLTS (100099)
Torque: 20ft/lb

STUD TORQUE SEQUENCE

