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INSTALLATION METHOD

FOR HEAD BOLT KITS

Kit Number: K001



Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

Kit: KO01 Alloy: 8740 Sockets Required: 13mm, 10mm

KIT CONTENTS

(20) BA4E 6pt Flange Bolt, MJ11x2.0 x 103mm length, 13mm wrenching, black oxide finish

(10) BA8E 6pt Flange Bolt, MJ8x1.25 x 48mm length, 10mm wrenching, black oxide finish

(20) WA5T Chamfered Washer, 11mm diameter, black oxide finish

(10) WA2T Chamfered Washer, 8mm diameter, black oxide finish

LBO1 TORQUEPOINT Fastener Assembly Lube, 1oz packet

LBBR Lube application brush

FASTENER INSTALLATION

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 the rust preventative**).

7. WITHOUT LUBE, washers, gaskets or heads, thread the bolts into their intended holes BY HAND ONLY until the bolt 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 the fasteners from their holes and liberally apply TORQUEPOINT assembly lube to the entire length of the threaded section of the fastener using included brush. Work the lube into the threads all the way around the threaded section so the lube is nearly flush with the outer diameter of the thread face.
9. To pre-lubricate the internal threads - install the bolts into their intended holes BY HAND ONLY until the bolt bottoms or thread run-out occurs (DO NOT USE TOOLS).
10. Remove all bolts from the block and place on clean rag. Wipe any excess thread lubricant from the block mating surfaces.
11. Apply TORQUEPOINT assembly lube and/or redistribute existing lubricant on the bolt threads to ensure all thread surfaces contain lubricant.
12. Apply TORQUEPOINT to each bolt's under head surface. **Do not apply any lubricant to the washers.** The washer should not rotate during fastener installation.
13. Fit the Head (and appropriate gasket) on block and install bolts with washers hand tight. **It is imperative that the chamfered side of the washer is "up" and mated against the underside of the bolts.**

TORQUE RECOMMENDATIONS

Follow the 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 torques and clamp loads while remaining at 75-80% of their minimum proof load rating.

BA4E	MJ11x2.0 Bolt
Torque: 74 ft-lbs	
Typical Clamp Load: 11,400 lbs-force	
BA8E	MJ8x1.25 Bolt
Torque: 30 ft-lbs	
Typical Clamp Load: 6,250 lbs-force	

Note: The number of aftermarket replacement parts and OEM combinations of components is numerous. **Use caution as the clamp loads above may damage your assembly - use lower installation torques such as those provided by the manufacturer of your components if applicable.**