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# INSTALLATION METHOD

FOR MAIN STUD KITS

Kit Number: K003



Point One, LLC

MAILING: PO BOX 677  
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,  
ROGERSVILLE, MO 65742

## Kit: K003 Alloy: 8740 Sockets Required: 14mm, 10mm

### KIT CONTENTS

(10) SA5E Stud, MJ10x2.0 x MJ10x1.25 threads, 116mm length, 8740, black oxide finish

(10) SA6E Stud, MJ10x2.0 x MJ10x1.25 threads, 121mm length, 8740, black oxide finish

(10) BA9E 6pt Flange Bolt, MJ8x1.25 threads, M10 wrenching, 8740, 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

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 the rust preventative**).

5. WITHOUT LUBE, thread the 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 the fasteners from their holes and liberally apply TORQUEPOINT assembly lube to the entire length of the threaded sections of the fastener using included brush. Work the lube into the threads all the way around the threaded sections so the lube is nearly flush with the outer diameter of the thread face.
7. For the bolts, apply TORQUEPOINT assembly lube under the head as well as the threaded area.
8. (DOES NOT APPLY TO SERRATED NUTS for windage tray) Apply TORQUEPOINT to each nut's bearing surface.
9. Install studs into block by hand or using hex key with light force only.
10. Fit the main caps into block and install washers and nuts hand tight.
11. Install main cap side bolts hand tight.

### 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.

#### SA5E Stud w/NE8F Nut MJ10x1.25 thread

Torque: **50 ft-lbs**  
Typical Clamp Load: 9,000 **lbs-force**

#### SA6E Stud w/NE8F Nut MJ10x1.25 thread

Torque: **50 ft-lbs**  
Typical Clamp Load: 9,000 **lbs-force**

#### BA9E Bolt MJ8x1.25 thread

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 above may damage your assembly** - use lower installation torques such as those provided by the manufacturer of your components if applicable.