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INSTALLATION METHOD

FOR HEAD STUD KITS

Kit Number: K005



Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

Kit: KO05 Alloy: 8740 Sockets Required: 9/16, 3/8

KIT CONTENTS

(4) SA1E Stud, MJ11x2.0 x 7/16-20 threads, 131mm length, 8740, black oxide finish

(16) SA2E Stud, MJ11x2.0 x 7/16-20 threads, 186mm length, 8740, black oxide finish

(10) SA3E Stud, MJ8x1.25 x 5/16-24 threads, 64mm length, 8740, black oxide finish

(20) NB5F 12pt Flange Nut, 7/16-20 threads, 9/16 wrenching, black oxide finish

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

(20) WB4T Flat Washer, 7/16 diameter, black oxide finish

(10) WB2T Flat Washer, 5/16 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 studs 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.
8. 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.
9. Install studs into block by hand or using hex key with light force only.
10. Apply TORQUEPOINT to each nut's bearing surface. **Do not apply any lubricant to the washers.** The washer should not rotate during fastener installation.
11. Clean any visible fastener lube from mating surfaces and fit the gasket and head on block and install washers and nuts 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.

SA1E Stud w/NB5F Nut 7/16-20 thread

Torque: **62 ft-lbs**
Typical Clamp Load: **11,400 lbs-force**

SA2E Stud w/NB5F Nut 7/16-20 thread

Torque: **62 ft-lbs**
Typical Clamp Load: **11,400 lbs-force**

SA3E Stud w/NA5F Nut 5/16-24 thread

Torque: **28 ft-lbs**
Typical Clamp Load: **6,500 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.