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INSTALLATION METHOD

FOR HEAD STUD KITS

Kit Number: K006



Point One, LLC

MAILING: PO BOX 677
ROGERSVILLE, MO 65742

SHIPPING: 11 WHITE OAK ROAD,
ROGERSVILLE, MO 65742

Kit: K006 Alloy: 6304 Sockets Required: 14mm, 10mm

KIT CONTENTS

(19) SA7S Stud, MJ12x1.75 x MJ12x1.25 threads, 153mm length, 6304, black oxide finish

(1) SA8S Stud, MJ12x1.75 x MJ12x1.25 threads, 117mm length, 6304, black oxide finish

(4) SA4S Stud, MJ8x1.25 x MJ8x1.0 threads, 67mm length, 6304, black oxide finish

(20) NE9F 12pt Flange Nut, MJ12x1.25 threads, 14mm wrenching, black oxide finish

(4) NE7F 12pt Flange Nut, MJ8x1.0 threads, 10mm wrenching, black oxide finish

(20) WA6T Flat Washer, 12mm diameter, black oxide finish

(4) WB2T Flat 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 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.

SA7S Stud w/NE9F Nut MJ12x1.25 thread

Torque: **110 ft-lbs**
Typical Clamp Load: **15,850 lbs-force**

SA8S Stud w/NE9F Nut MJ12x1.25 thread

Torque: **110 ft-lbs**
Typical Clamp Load: **15,850 lbs-force**

SA4S Stud w/NE7F Nut MJ8x1.0 thread

Torque: **30 ft-lbs**
Typical Clamp Load: **6,600 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.