

INSTALLATION METHOD FOR MAIN STUD KITS

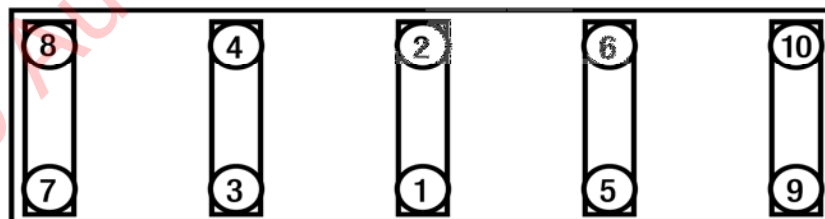
Part Number: 151-5407 Application: Ford 2.3L EcoBoost MSK

1. Inspect all hardware prior to installation. Look for obvious defects or shipping damages. Please call 800-826-3045 with any questions or issues.
2. To ensure proper thread engagement and accurate torque readings, clean all threads in the block. Chase if necessary with ARP Thread Chaser, part number 912-0002 (M10 X 1.25)
3. **Clean the spot faces on the main cap girdle where the washer seats, use of solvent or brake/carb cleaner is recommended.**
4. Install the main cap girdle/beam.
5. Screw the studs into the block, do not apply torque. The hex broach in the end of the stud is designed to assist with installing/removing the studs from the block, not for applying torque.
6. **Then, using a clean, dry rag remove all oil from both sides of each washer. The main girdle/beam and washer mating surfaces must be free of oil/grease/lubricant. Failure to keep these surfaces dry may result in inconsistent preloads.**
7. Place the washers over the studs and on to the **dry, clean spot faces** of the main girdle/beam.
8. Lubricate the stud threads and bottom of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and tighten hand tight.

Torque Procedure

9. Following the manufacturers recommended torque sequence, use a **16mm socket** to torque the nuts per steps 1-3
 - 1- Tighten nuts 1 through 10 to 25 ft-lbs
 - 2- Tighten nuts 1 through 10 to 50 ft-lbs
 - 3- Tighten nuts 1 through 10 to 70 ft-lbs

Torque Sequence



←
Front of engine