

1994-2003 Ford 7.3L Power Stroke Main Stud Kit

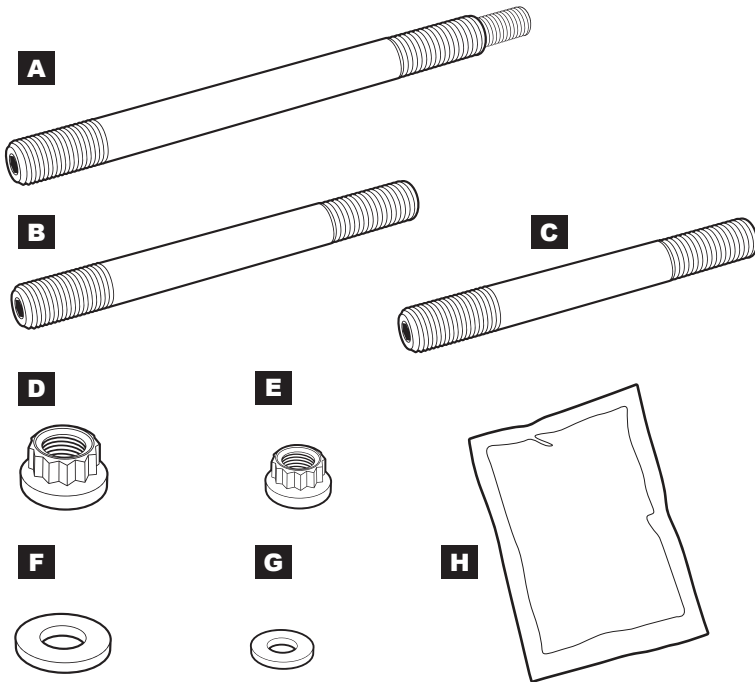
(318035000)

Installation Guide



ATTENTION: We recommend the installation of this part be done by a trained professional Ford technician. PPE will not accept liability for damage resulting from incorrect assembly. These instructions are not intended as a service or overhaul manual. These instructions are intended to facilitate the modification of non-factory parts installation by a trained professional.

NOTE: Tolerances will change when changing from factory to high-strength fasteners. It will be necessary to check main bearing bores for proper size and out-of-round condition after installation of the studs. Hone the cylinder block if necessary. Main bores should always be align-honed using the same fasteners and lubricant which will be installed, at the recommended preload, during the final engine assembly.



CONTENTS:

- A: (1) M12 X 166 MML STUDS
- B: (9) M12 X 146 MML STUDS
- C: (10) M12 X 120.6 MML STUDS
- D: (20) M12 FLANGE NUTS
- E: (1) M10 FLANGE NUT
- F: (20) M12 WASHERS
- G: (1) M10 WASHER
- H: (1) 1-OZ. FASTENER ASSEMBLY LUBRICANT

Prior to installation, please inspect for any damage or defects and clean all hardware. Verify product part number matches your application. Make sure kit is complete with no missing parts.

NOTE:

Loctite may be used for permanent mounting. Torque sequences must be complete prior to Loctite hardening.

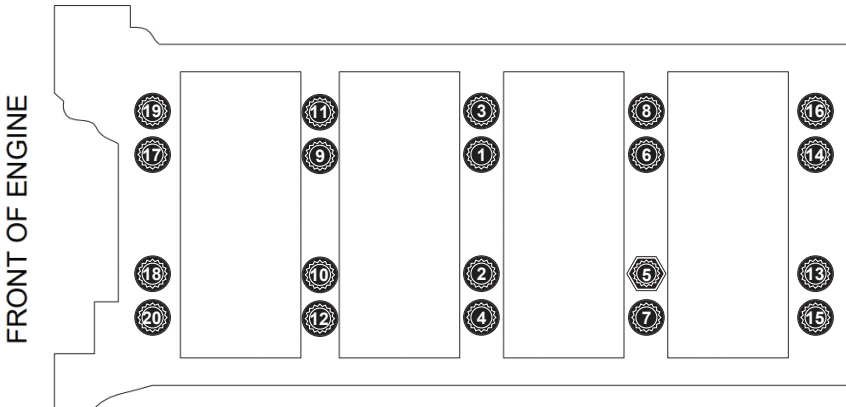
Clean all threads in the engine block. Use a bottoming thread chaser if necessary. This would ensure thread engagement and more accurate torque readings.

Install M12 Studs into the block and hand-tighten without tools (equivalent of 20-30 lb-in.). *Inner studs are 146 mm long. Note: Install M12 X 166 (A) into Position #5. This will be for the oil pickup mount. Outer studs are 120.6 mm long.* Install main caps and check for proper alignment.

Lubricate the threads of all M12 Nuts with the Assembly Lubricant provided. Install the M12 Washers and Nuts onto the Studs.

Tighten Nuts in three steps using the torque sequence shown in the image below. Torque specs for each step are: 40 lb-ft, 80 lb-ft, and 125 lb-ft (final).

BOLT TORQUE SEQUENCE



Install the Oil Pickup Tube, make sure the mount is installed over the stud on Position #5. Lubricate the M10 Nuts with the Assembly Lubricant provided. Install the M10 Nut and M10 Washer onto the stud in Position #5.

Tighten the M10 Nut using the torque spec below: M10 Nut = 45 lb-ft (use M10 washer for spacer under oil pick up mount)

DISCLAIMER OF LIABILITY

Performance products can increase horsepower above and beyond factory specifications. Additional horsepower creates more stress on the drive-train components, which could result in drive-train failure.

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