



12MM MAIN STUD KIT B SERIES CUMMINS MATERIAL: L-19, 240 KSI



INSTALLATION INSTRUCTIONS

APPLICATION

- ALL ENGINE BLOCKS 1997.5 AND NEWER:
 - ENCORE BLOCKS HAVE 2 TURBO OIL RETURN HOLES ON PASSENGER SIDE OF THE BLOCK.
- ALL COMMON RAIL CUMMINS ENGINE BLOCKS

1. Apply engine oil (or you may spray with WD40) to the bottom threads of the stud (block end). Install into block by hand until snug, **DO NOT TORQUE**.
2. Apply ARP ULTRA TORQUE to bottom of nut, washer and upper threads of stud.
3. Place flat washers and nuts on studs.
4. Torque to: 50 Ft Lb, 100 Ft Lb and 130 Ft Lb.
5. Recheck all studs at 130 Ft Lb final torque.

FOR EXTRA LONG MAIN STUDS

1. Install girdle or block stiffener onto block
2. Apply engine oil (or you may spray with WD40) to the bottom threads of the stud (block end). Install into block by hand until snug, **DO NOT TORQUE**.
3. Apply ARP ULTRA TORQUE to bottom of nut, washer and upper threads of stud.
4. Place flat washers and nuts on studs.
5. Torque to: 50 Ft Lb, 100 Ft Lb and 130 Ft Lb.
6. Recheck all studs at 130 Ft Lb final torque.

FOR INSTALLATION WITH ENGINE IN THE TRUCK:

1. Follow instructions above installing/replacing one stud at a time.