



14MM MAIN STUD KIT – MED & XL

B SERIES CUMMINS ENGINES

PN: 1054005MED PN: 1054005XL



INSTALLATION INSTRUCTIONS

FOR USE ON ENGINES WITH A GIRDLE PLATE

IMPORTANT NOTE:

ALL ENGINE BLOCKS 1997.5 AND NEWER HAVE “ENCORE” BLOCKS (THESE HAVE 2 TURBO OIL RETURN HOLES ON PASSENGER SIDE OF THE BLOCK) AND MUST BE DRILLED & TAPPED TO 14mm X 2.00. THESE MOTORS HAVE 12mm X 1.50 THREADS IN THE BLOCK.

THIS MUST BE DONE BY A QUALIFIED PROFESSIONAL:

- A. DRILL BLOCK WITH A 29/64” DRILL BIT***
- B. WITH A PLUG TAP – TAP 14MM X 2.00***
- C. PROCEED TO STEP 1 BELOW***

WITH MAIN CAPS REMOVED:

1. With a 14mm x 2.00 bottoming tap, re-tap holes in block until bottoming tap bottoms out.
2. Using Brake-Kleen and compressed air, clean and dry all holes.
3. Install a small amount of grease on point of stud. Install by hand a stud in each hole of the block, verifying that the bottom of the stud and not the threads bottom out. If it does not, remove stud, tap hole deeper with the bottoming tap, and re-check for proper fit. If you have to re-tap, repeat Step 2.
4. Coat 14MM X 2.00 threads on stud or motor oil or spray with WD40.
5. With hex allen wrench in broached end of the stud, thread studs into the block, making sure stud bottoms out in block – STUD SHOULD BOTTOM OUT NOT THREADS. Install studs in block SNUG. DO NOT TORQUE STUDS IN BLOCK.
6. Reinstall the Main Caps
7. Place flat washers on studs, lube washer and upper (fine) threads with motor oil. Torque to: 75 Ft Lb, 100 Ft Lb and 150 Ft Lb.
8. Recheck all studs at 150 Ft Lb final torque.
9. Before install the oil pan, you will need to modify the oil pan for the rear 2 studs. Pans can be sent to us for this modification.
10. ANY QUESTIONS CALL 877-948-3164