



Gator Fasteners Heavy Duty Main Stud Kit

Fits: Ford 1983-1994 6.9L & 7.3L IDI Diesel • Part Number: MSK6973IDI

Parts Included:

- (20) Main Studs
- (21) Main Stud Nuts
- (21) Main Stud Washers

Tools Needed:

- Socket Set
- Torque Wrench
- Thread Chaser

Please Read Instructions before starting installation. If you don't feel confident that you can complete this task, do not start it and seek professional help!

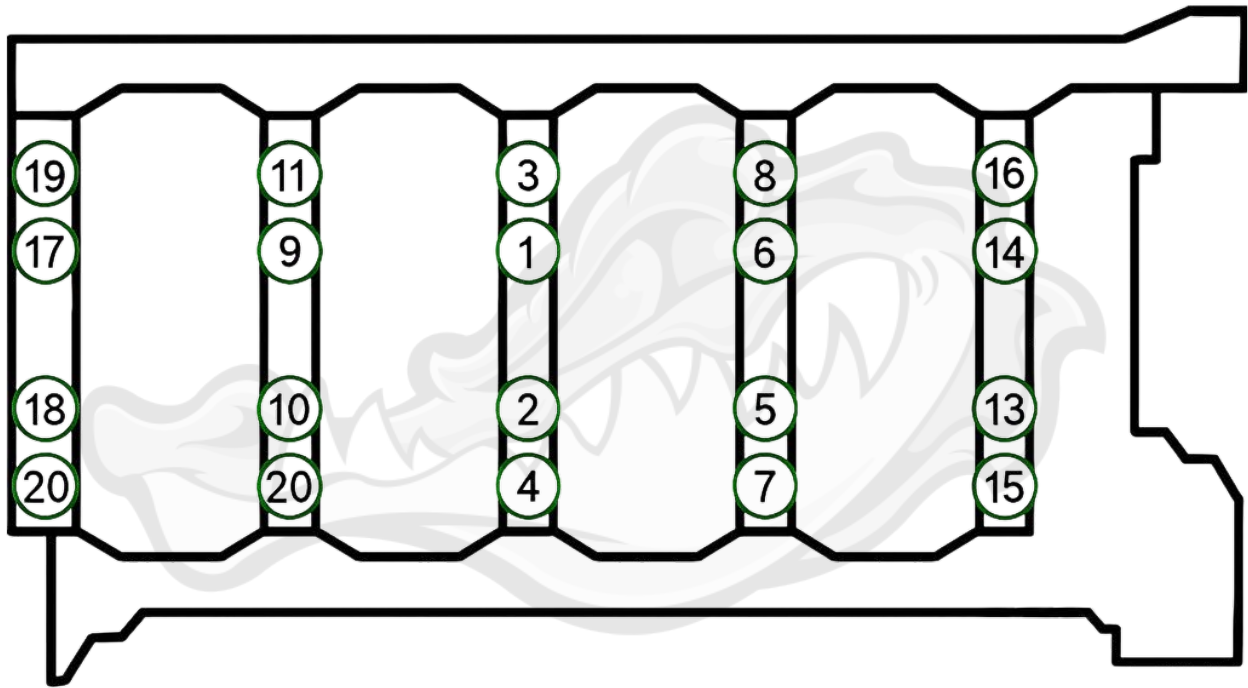
- ☐ These instructions only cover the installation and torque sequence/technique of the Main Stud Kit. *(If you are installing this Main Stud Kit with a girdle, use the installation instructions that came with the girdle)*
- ☐ Clean and inspect the Studs and Nuts to ensure they are free of shipping damage and obvious defects.
- ☐ If you are installing this Main Stud Kit without a girdle, the oil pickup support bracket must be drilled out to the larger 0.5" main stud diameter.
- ☐ Clean all threads in the block. It is recommended to use a Thread Chaser on the threads of the block so that they are completely clean to ensure proper thread engagement and accurate torque reading.
- ☐ Lubricate the threads of the main studs and install them into the block. **(HAND TIGHT ONLY)** Look across the tops of the main studs to see that they all appear to be the same length. If one is taller, remove the stud, clean the threads in the block and re- install. *Be very careful to not oversaturate the studs with lubricant when going into the holes as excessive liquid can cause cracking in the block's main webbing when torqued.*
- ☐ Install the main caps and check for binding or misalignment.
- ☐ Install the Main Stud Washers onto the studs ensuring there is no lubricant between the washer and the surface of the head.
- ☐ Lubricate the Main Stud threads with Assembly Lube.
- ☐ Lubricate the mating face and threads of the Head Stud Nuts with Assembly Lube and install them onto the studs **(HAND TIGHT ONLY)**.

❑ Follow the torque sequence below in the diagram and tighten the nuts in three equal steps to these specifications:

Step One - 45 ft-lbs

Step Two - 90 ft-lbs

Step Three - 125 ft-lbs



Disclaimer and Liabilities

Seller disclaims any responsibility/ liability for improper, incorrect, or inexperienced installation of products by the purchaser or installer resulting in damage or loss. Buyer affirms by purchase of this product that it is fit for intended use and accepts all liability. Buyer affirms products are used at buyers own risk and accepts full responsibility.

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