

12 & 14 mm Cummins 12 & 24 Valve Gorilla Girdle Kit



This kit includes 1 Gorilla Girdle, 14 top spacers, (large hole) 12 bottom spacers (small hole) 1 rear main spacer bar, new oil pan bolts and lock washers, 2 rear main stud nuts (12 point), oil pickup spacer with bolts, and 12 main stud nuts (Nylock).

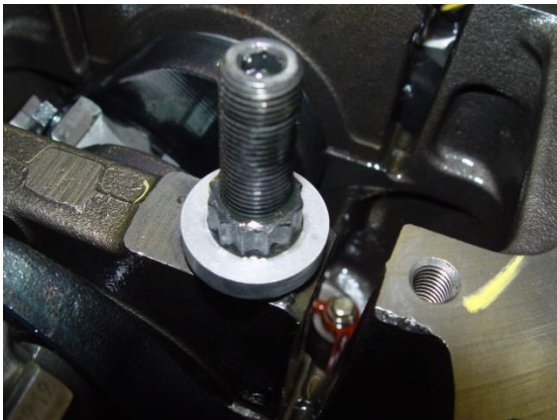
Before you start, READ AND UNDERSTAND THESE INSTRUCTIONS.

First check the torque on the main studs.

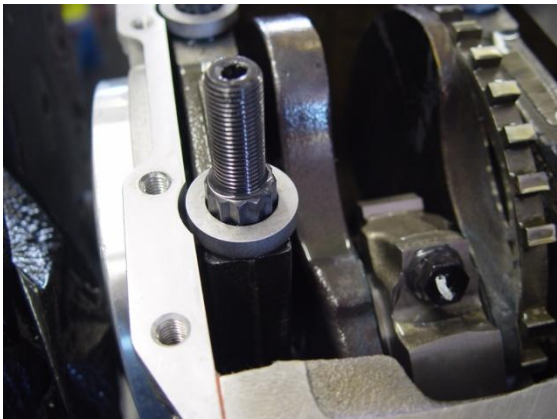
(12mm ARP 2000, 125 ft lbs)

(12mm A1 H11, 135 ft lbs)

(14mm A1, 150 ft lbs)



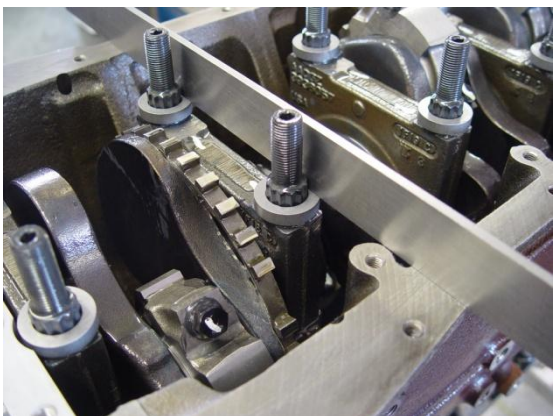
(1) Install top spacer on the 12 front main studs.



(2) Install top spacer on rear main stud.

NOTE

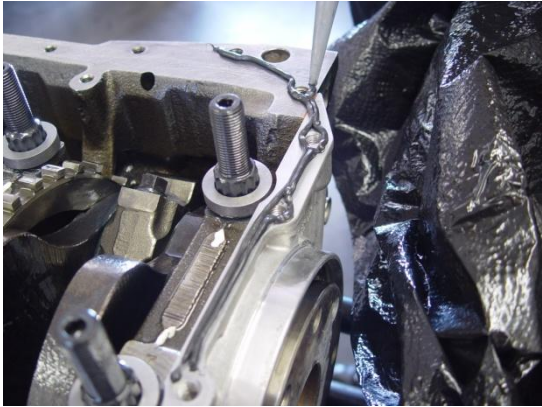
(This spacer may need to be ground flat on one side to clear the rear main seal plate. Do not remove more than is needed)



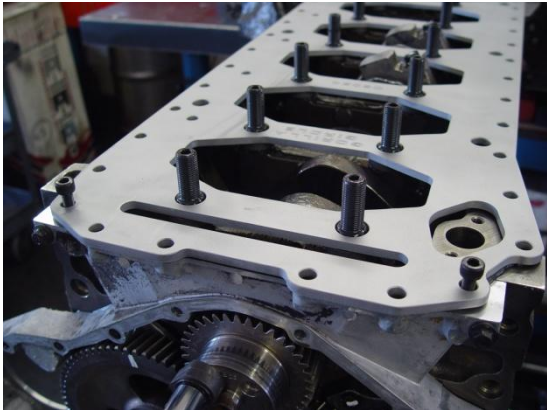
(3) Using a straight edge check the spacer height. The spacers should be even with the oil pan rail, plus or minus .010

NOTE

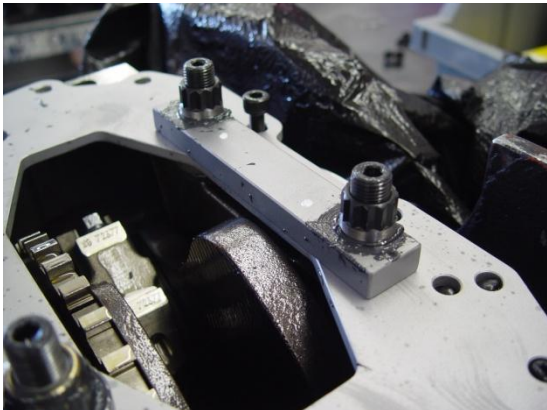
(TRIAL FIT THE GIRDLE BEFORE GOING ON TO THE NEXT STEP, CHECK ALIGNMENT OF ALL BOLT HOLES DUE TO FACTORY BLOCK TOLERANCES)



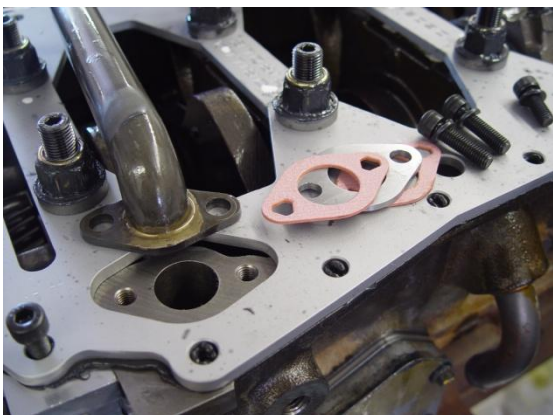
(4) Clean the block and girdle with brake cleaner and apply two 1/16 inch beads of silicone to the block, one inside and one outside the pan bolt holes.



(5) Install the girdle with 4 oil pan bolts for alignment. Next install the lower spacers and Ny-lock nuts on the front 6 main caps.



(6) Install the rear main spacer bar with 12 point nuts. Torque all main girdle nuts.
WARNING DO NOT OVER TORQUE
(14mm Ny-lock nuts to 120 ft lbs **FRONT SIX MAINS**)
(14mm modified 12pt nuts to 120 ft lbs **REAR MAIN**)
(12mm Ny-lock and 12pt nuts to 85 ft lbs.)
(12mm modified 12pt nuts to 85 ft lbs **REAR MAIN**)



(7) Using the 8 x 1.25 x 30 mm Allen headed bolts and lock washers Install oil pump pickup tube using the spacer with a gasket on the top and bottom. Torque the pickup tube bolts to 18 ft lbs.



(8) Modify oil pan to clear rear main studs.

(We can stamp these notches in the oil pan for you for a small fee; this makes the installation much easier and looks great.)

Clean the girdle and oil pan then Apply 2 beads of silicone to the girdle as before, then install the oil pan using the 8 x 1.25 x 22mm Allen headed bolts.

For any questions on the install call 435-896-4801

FOR INSTALATION VIDEO GO TO

http://www.youtube.com/watch?v=v2f_bOco8N0

NOTE

*THESE SPECIFICATIONS AND INSTRUCTIONS
SUPERSEDE THE VIDEO.*