

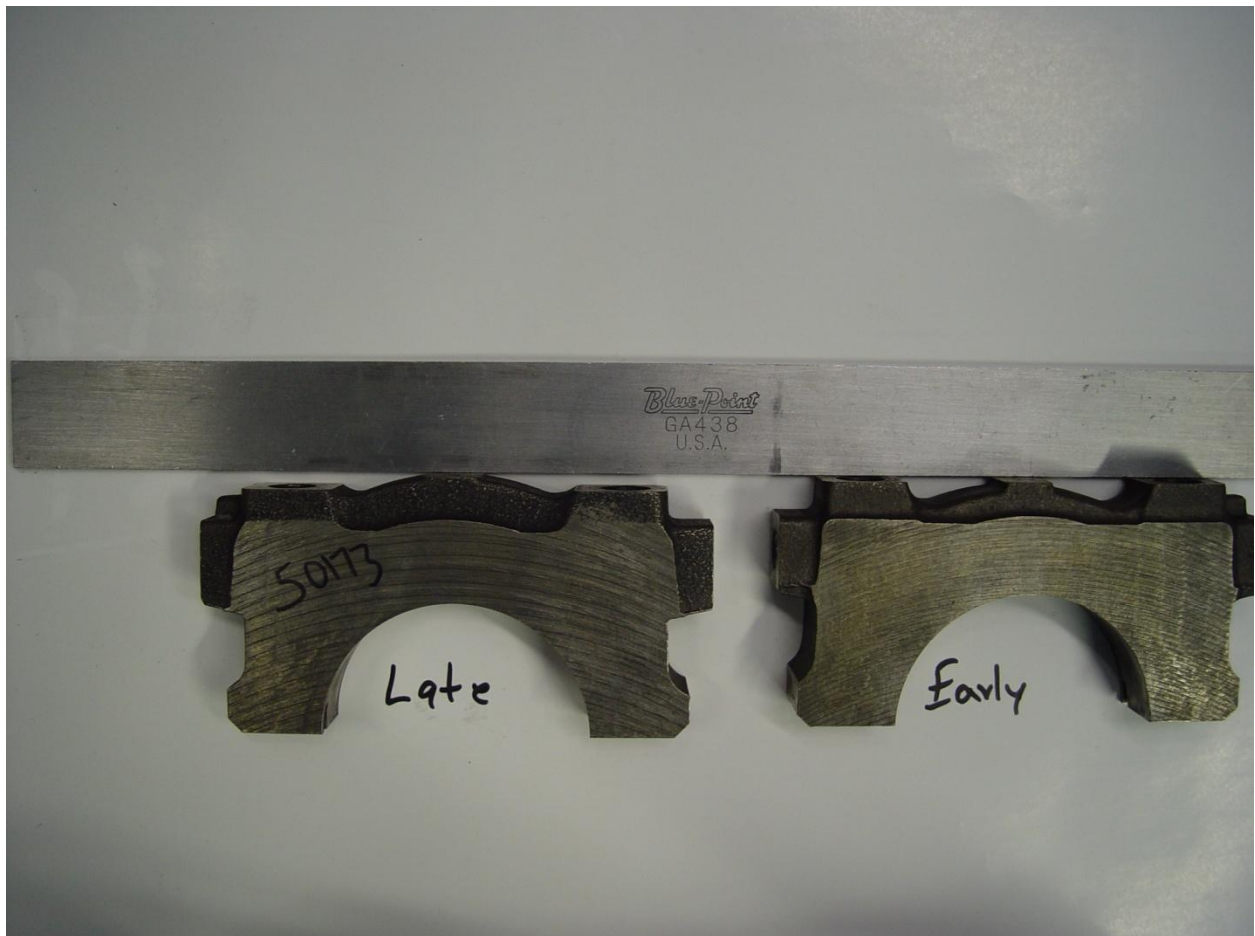
PLEASE READ ALL OF THESE INSTRUCTIONS FIRST.

WARNING

SOME LATE MAIN BEARING CAPS MUST BE MACHINED FLAT
TO ACCOMMODATE THIS GIRDLE.

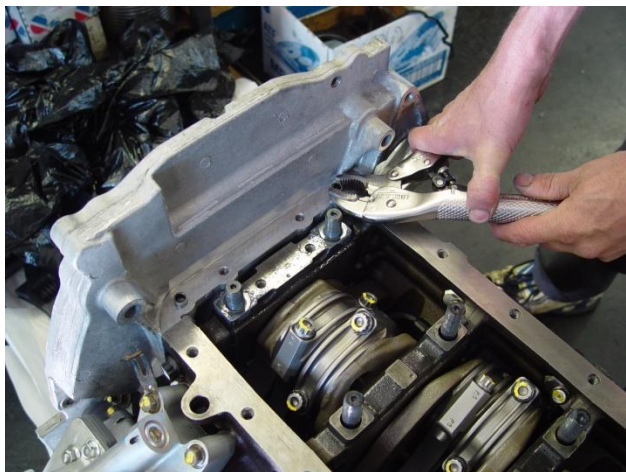
SEE PICTURE.

FOR INSTALLATION VIDEO GO TO www.performancedieselmachine.com

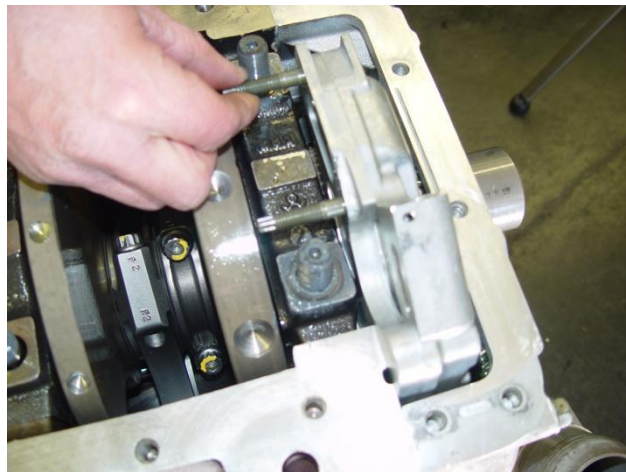


Duramax Main Bearing Girdle

WE RECOMMEND THAT YOU DO A TRIAL FIT OF THE GIRDLE AND LOWER CRANK CASE BEFORE FINAL ASSEMBLY.



(1) REMOVE REAR ALIGNMENT DOWELS.



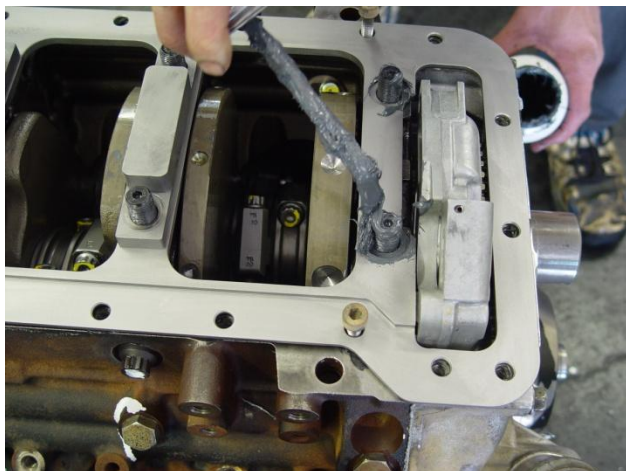
(2) REMOVE OIL PUMP PICKUP TUBE STUDS.



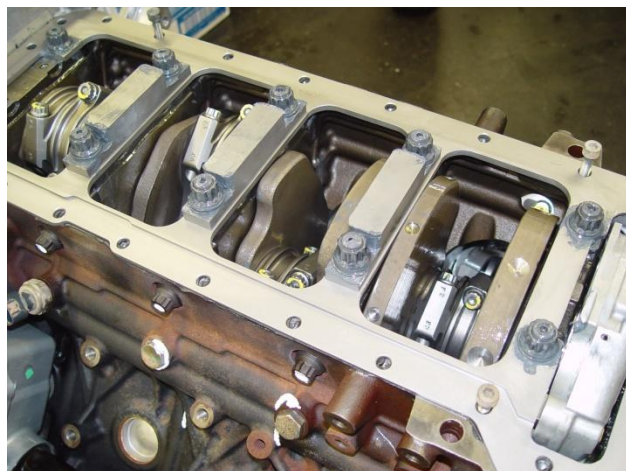
(3) APPLY A 1/16 INCH BEAD OF SILICONE (PERMATEX THE RIGHT STUFF) AND INSTALL GIRDLE.



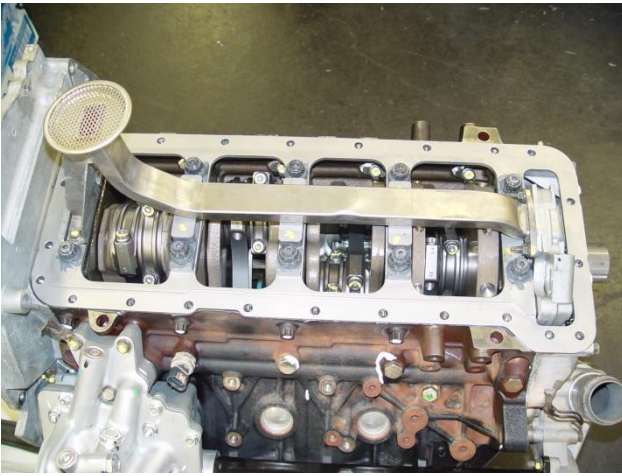
(4) INSTALL 4 OIL PAN BOLTS TO ALIGN THE GIRDLE. INSTALL 3 CENTER MAIN CAP REINFORCEMENT BARS.



(5) APPLY A.R.P. MOLLEY LUBE TO STUDS & WASHERS.



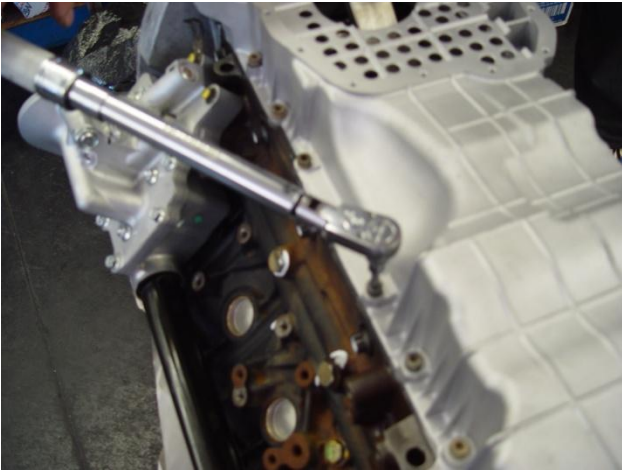
(6) INSTALL MAIN WASHERS & NUTS (TORQUE IN 3 STEPS TO 175 FT LBS.)



(7) INSTALL THE OIL PUMP PICKUP TUBE.



(8) APPLY A 1/16 INCH BEAD OF SILICONE TO THE PAN RAIL. (PERMATEX THE RIGHT STUFF)



NOW INSTALL THE LOWER CRANK CASE (UPPER OIL PAN) AND INSTALL ALL THE OIL PAN BOLTS (HAND TIGHT ONLY). NOW INSTALL THE 2 TRANS ADAPTER BOLTS (HAND TIGHT ONLY). NOW CAREFULLY TIGHTEN CRANK CASE BOLTS AND TRANS ADAPTER BOLTS. THE LOWER CRANK CASE MUST BE PULLED DOWN AND BACK AT THE SAME TIME, THEN TORQUE THE TRANS ADAPTER BOLTS TO 67 FT. LBS. AND THE LOWER CRANK CASE BOLTS TO 18 FT. LBS.

(NOTE) THESE SPECIFICATIONS AND INSTRUCTIONS SUPERSEDE THE VIDEO.

TRIAL FIT THE GIRDLE BEFORE STARTING FINAL ASSEMBLY, CHECK ALIGNMENT OF ALL BOLT HOLES, THE GIRDLE MUST FIT FLAT ON THE BLOCK.

CLEAN ALL SURFACES WITH CARB CLEANER BEFORE SILICONE IS APPLIED.

DO NOT USE AN ANAEROBIC SILICONE, THIS PROCEDURE TAKES A LITTLE TIME AND IT MAY SET UP TO FAST.

TORQUE THE OIL PICK UP TUBE (STUDS ON THE PUMP FIRST, REAR BOLTS LAST) TO 18 FT. LBS.

MAIN STUD TORQUE 175 FT LBS (MAIN STUDS SHOULD BE CYCLED 3 TIMES BEFORE FINAL TORQUE.

WE RECOMMEND LINE HONING BLOCK AFTER MAIN STUDS ARE INSTALLED. (SEE VIDEO ON CYLINDER DISTORTION AND DECKPLATE HONING) @ www.performancedieselmachine.com

SIDE BOLTS (CROSS BOLTS) 90 FT. LBS.

TRANS. ADAPTER BOLTS 67 FT. LBS.

OIL PAN BOLTS 15 FT. LBS.

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