



ARP MAIN STUD KIT INSTALLATION INSTRUCTIONS

Part Numbers: T120334 & T120152

KIT CONTENTS

- 6 Standard ARP Main Studs
- 2 Modified ARP Main Studs
- 6 Standard ARP Nuts
- 2 Modified ARP Nuts
- 8 Washers
- ARP Ultra-Torque Assembly Lubricant

PREPARATION

1. Clean Threads

- Remove factory fasteners.
- Chase and clean all block threads to ensure proper stud engagement.
- Many blocks have head bolt and main bolt holes that are not fully threaded to the bottom of the bore. It is necessary to run a M11 x 1.25 tap through each hole, ensuring the threads are cut to the full depth of the bore.
- Blow out debris with compressed air.

2. Inspect Components

- Confirm that all 8 studs and 8 nuts are present.
- Identify the 2 modified studs and 2 modified nuts. These are required for the installation at the # 4 main cap location (rear).

INSTALLATION

1. Install Studs

- Apply ARP Ultra-Torque lubricant (or equivalent) to block-end threads.
- Hand-tighten all 8 studs into the block. Do not overtighten, tighten snugly.

2. Special Stud Placement

- Install the 2 modified studs at the #4 main cap.
- Install the 6 standard studs at remaining positions.

3. Main Cap Installation

- Position main caps on block.
- Install washers and nuts, apply lubricant to both sides of washers and to nut threads.
- Use modified nuts with the modified studs at #4 main cap (rear).
- On 3VZ 3.0L, DO NOT use the washers on the 2 rear studs

4. Torque Procedure

- Follow OEM torque sequence.
- Torque in 3 equal steps to **80 ft-lbs** using ARP Ultra-Torque lubricant.

NOTES

- Always follow proper torque sequence.
- Do not interchange standard and modified hardware: the modified studs/nuts **MUST** only be used at the #4 main cap (rear).

Installation Reference Photos



