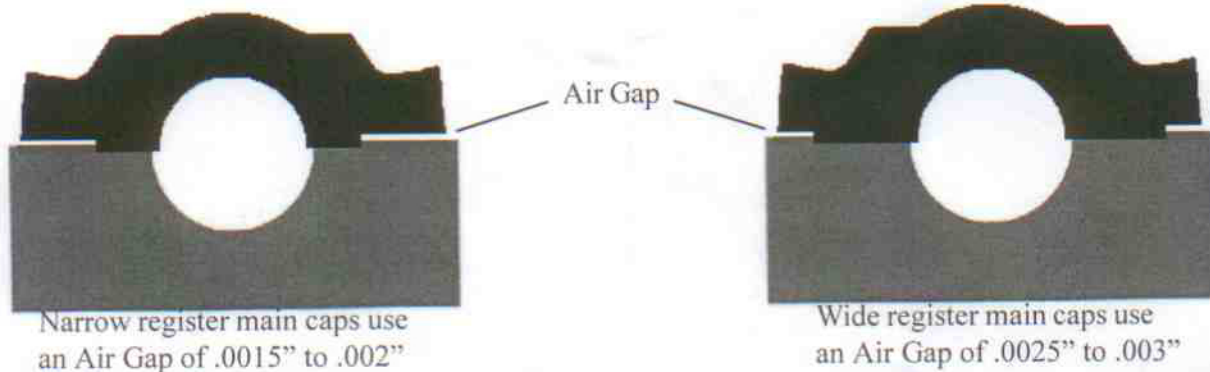




## INSTALLATION TIPS FOR: Main Bearing Caps with Splayed Outer Bolts

### Installation Tips:

- 1.) Debur the block at the registers and the main web area the replacement cap will cover.
- 2.) Install the cap and torque the two center main bolts to the specs recommended for the fastener that you are using.  
\*NOTE\* Wait to drill and tap the angled bolt holes till after the "Air Gap" is set.
- 3.) While installed, mark the cap to assign it's position in the block.
- 4.) Use a feeler gauge to measure the distance between the cap and block. This determines the "Air Gap".
- 5.) Use a cap grinder to remove material from the mating surface of the cap so that the Air Gap is set. (See below chart.)
- 6.) Reinstall and torque the main caps to the positions previously assigned.
- 7.) Drill and tap the angled bolt holes using the cap, bolted in place, as a guide.
- 8.) Proceed with normal align boring and honing operations as per equipment manufacturers instructions.



Narrow register main caps use an Air Gap of .0015" to .002"

Wide register main caps use an Air Gap of .0025" to .003"

| AMC            | Buick          | Chevy           | Chrysler     | Ford          |
|----------------|----------------|-----------------|--------------|---------------|
| AMC401CSA - 10 | B4.1V6CSA - 15 | SB283CSA - 10   | M340C4A - 18 | F351CSVO - 18 |
|                |                | SB283C22 - 22   | M360C4A - 18 | F351CWSA - 18 |
|                |                | SB350C12 - 12.5 |              | F460CSA - 18  |
|                |                | SB350C22 - 22   |              |               |
|                |                | SB350CSA2 - 10  |              |               |
|                |                | SB350CSA4 - 10  |              |               |
|                |                | SB400CSA - 10   |              |               |
|                |                | SB90V6CSA2 - 10 |              |               |

\*\*Above chart indicates part number and angle of outer bolt.\*\*