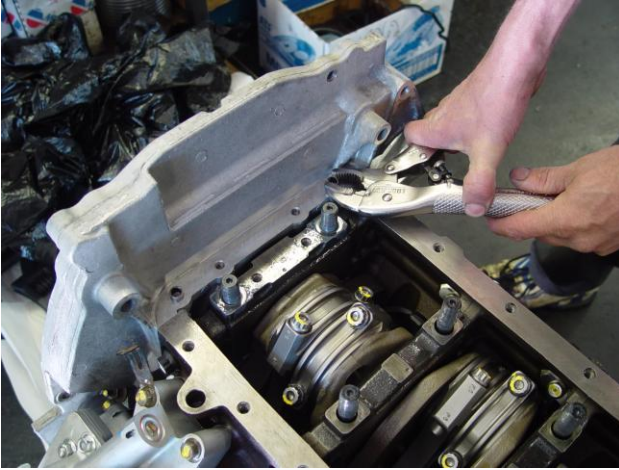
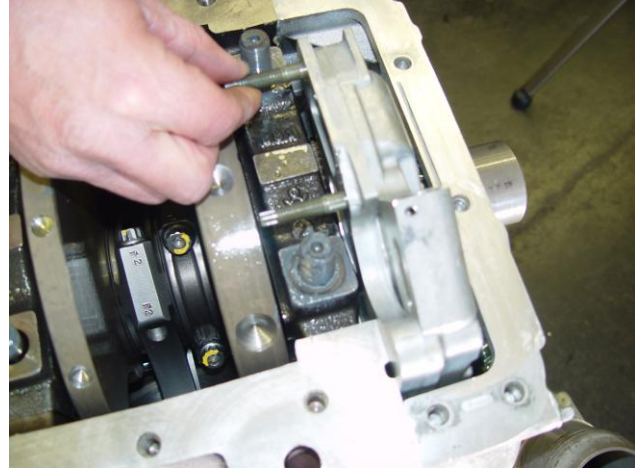


Duramax Main Bearing Girdle Installation

PLEASE READ ALL INSTRUCTIONS FIRST



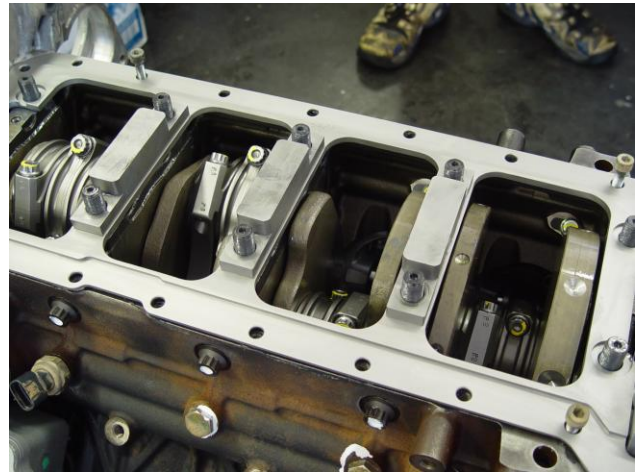
(1) REMOVE REAR ALIGNMENT DOWELS.



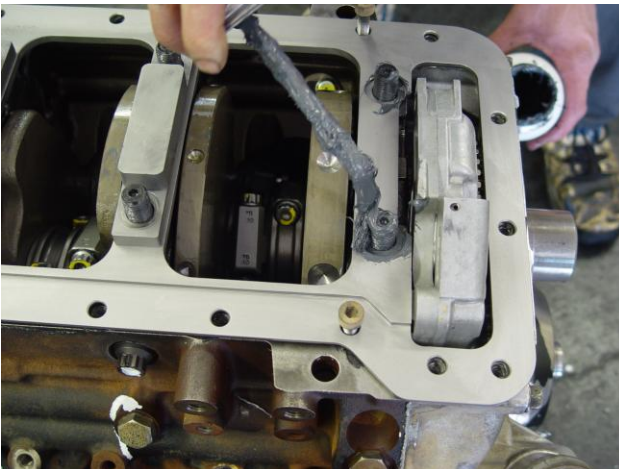
(2) REMOVE OIL PUMP PICKUP TUBE STUDS.



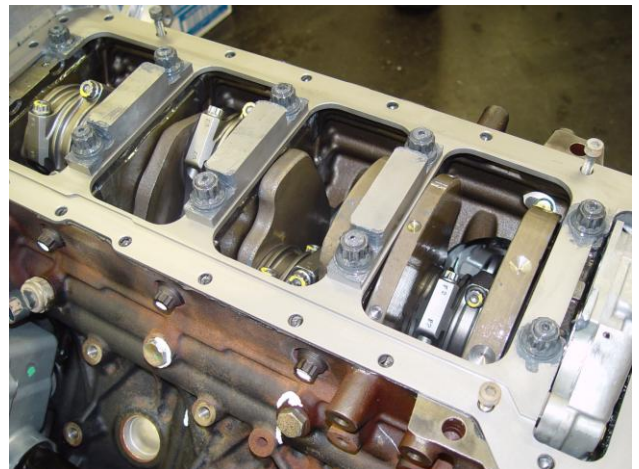
(3) APPLY A 1/16 INCH BEAD OF SILICONE (PERMATEX THE RIGHT STUFF) AND INSTALL GIRDL.



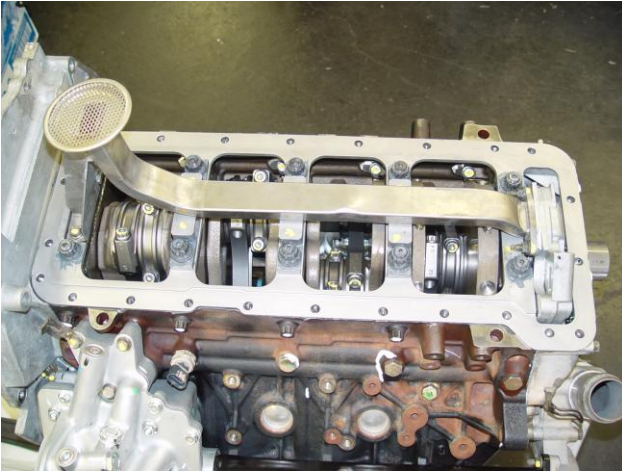
(4) INSTALL 4 OIL PAN BOLTS TO ALIGN THE GIRDL. INSTALL 3 CENTER MAIN CAP REINFORCEMENT BARS.



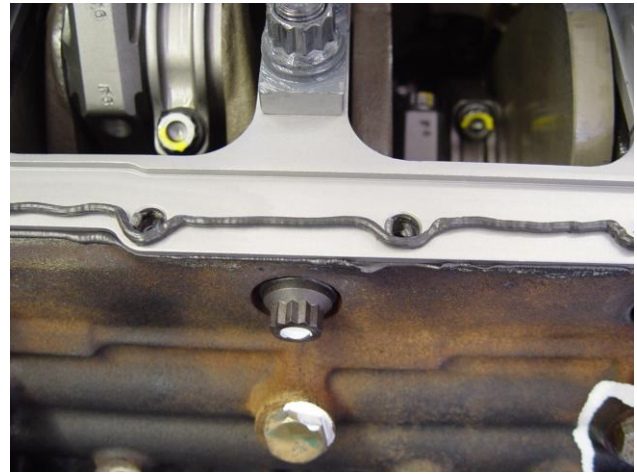
(5) APPLY A.R.P. MOLLEY LUBE TO STUDS & WASHERS.



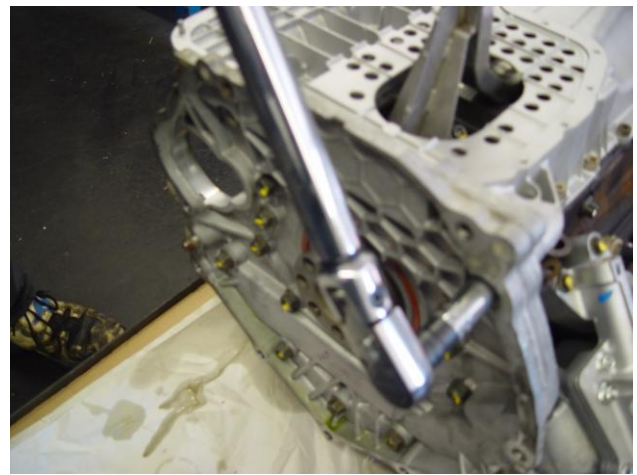
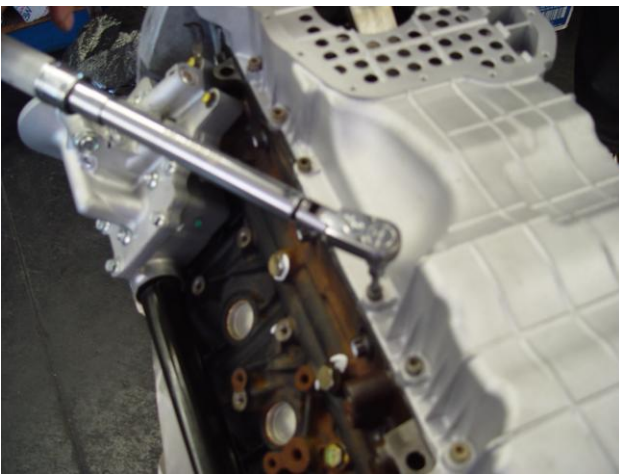
(6) INSTALL MAIN WASHERS & NUTS (TORQUE IN 3 STEPS TO 200 FT LBS.)



(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 INSTRUCTIONS APPLY AFTER MAIN STUDS HAVE BEEN INSTALLED AND TORQUED AND LOOSENED (CYCLED) 3 TIMES.

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 200 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.randysengine.com or www.performancedieselmachine.com

SIDE BOLTS (CROSS BOLTS) 86 FT. LBS.

TRANS. ADAPTER BOLTS 67 FT. LBS.

OIL PAN BOLTS 15 FT. LBS.

FOR INSTALLATION VIDEO GO TO www.randysengine.com OR www.performancedieselmachine.com