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For tech help, contact:

PRW

Toll Free (888) 377-9779

PRW Billet Steel Main Girdle Installation Instructions

Each Box Contains:

- 1 Main Girdle
- 10 Studs
- 10 Nuts
- 10 Washers

Installation

Step 1

Remove all factory main bolts. Do not remove the main caps.

Step 2

Clean and chase all of the threads in the main bolt holes. This will help provide accurate torque readings.

Step 3

Coat the bottom threads with Loctite (or similar thread locker) and hand-tighten into the block. Use oil or moly lube to coat the upper threads of the studs and torque to OEM specifications.

Step 4

Install the main girdle onto the main caps. Be sure to have 0.020" minimum clearance between the girdle cross bar and the center of the main caps. Add washers if needed.

Step 5

Hand-tighten the nuts.

Step 6

Hand-turn the crankshaft and check for both crank counterweight and rod clearance. If there are clearance issues, you will have to modify the girdle. Mark the spot or spots on the girdle where the crank or rods are hitting.

Step 7

Install the oil pump by hand-tightening it into place. If there are clearance issues with the pump and/or the girdle, mark the girdle where the clearance issue occurs.

Step 8

Remove oil pump and girdle if modifications need to be made. Mill the girdle where contact occurred.

Step 9

Reinstall the girdle and oil pump, recheck the clearances.

Step 10

Once you have the clearances, you can torque the girdle and oil pump into place. Torque to factory specs.

Step 11

Install the windage tray, if using.

Step 12

Install the oil dipstick. Be sure it fits all the way in and does not hit the girdle.

Step 13

Check the positioning of the oil pump with the bottom of the oil pan. The pick-up should be parallel to the bottom of the pan, and between a 1/4" and 3/8" from the bottom.

Step 14

Install oil pan.

If you need technical information, or additional information regarding the installation of this product,

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Or

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