

MILODON
2250 Agate Court
Simi Valley, Ca 93065
(805) 577-5950

**TWO BOLT MAIN CAP
INSTALLATION INSTRUCTIONS**

The tensile strength of the ductile iron that Milodon uses in these main caps is 85,000 PSI. This is considerably stronger than other mild steel "Billet Caps". Also the expansion rate of ductile iron is equal to that of the cylinder block, eliminating engine bearing failure due to irregular bearing bore expansion when the engine reaches operating temperature.

Milodon supplies complete bolt kits with all main cap sets. However, if maximum strength and durability are required, studs should be used. Studs are available for all applications, refer to the Milodon catalog for specific part numbers.

STEP 1 Clean all main bolt holes with a tap. A bottoming tap is recommended on all blocks. Bolts should be checked on each hole to be sure the bolts do not bottom out in the holes or an incorrect torque reading will result. For maximum strength main studs should be used.

STEP 2 Clean block and caps thoroughly removing all burrs. Install the main caps on the block.

STEP 3 Torque all bolts, using oil.
7/16" bolts torque to 65 ft lbs.
1 / 2" bolts torque to 110 ft lbs

STEP 4 The block is now ready to be align bored. Align bore block initially with a rough cut to .010 under finished size. On the second pass, align bore exactly to finish size. Align honing should not necessary if bore can be done close enough. If not, rough align bore then hone for the final finish. Debur and clean as necessary.