



## NASCAR SPEC ENGINE

### Spec Engine Assembly Notes and Torques

August 27, 2008

<b>Bolt / Bearing</b>	<b>Lube / Loctite</b>	<b>Torque</b>	<b>Special Instructions</b>
Center Main Cap Bolts	Oil	55 Ft Lbs	
Outer Main Cap bolts	Oil	55 Ft Lbs	
Side Main Cap Bolts	Oil	22 Ft Lbs	
Main Bearing Insert	Assembly lube		
Rod Bolts	Lunati Extreme	65 Ft Lbs	
Rod Bearing Insert	Assembly lube		Mix Std. Insert and .001 Under Per Rod
Camshaft	Oil		Oil Thrustplate Front and Rear
Timing Chain	Oil		Pre-Soak In Oil And Line Up Marks
Distributor Drive	Oil	26 Ft Lbs	
Lifters			Pre soak In Oil
Rear Oil Pressure Diverter	Assembly lube		O-Ring to Rear
Gaskets			All Gaskets in Kit are deigned to be assembled without glue, silicone



			sealers or adhesives
Rear Cover		22 Ft Lbs	
Rear Seal	No lube or glue		Seal Designed to run dry- do not lube
Front Cover		22 Ft Lbs	Counter sunk allen head at top
Front Seal	No lube or glue		seal designed to run dry- do not lube
Big Head Bolts	GM Are Pre Lubed/ARP Uses supplied Lube	65 Ft Lbs	
Small Head Bolts	GM Are Pre Lubed/ARP Uses supplied lube	22 Ft Lbs	
Head bolt tightening Sequence			9 5 1 3 7 10 6 2 4 8
Lifter Holders			Shoulder Bolts must be centered inside lifter holder mounting holes
Rocker Arms	Assembly Lube	22 Ft Lbs	Pre soak Rockers in oil. Bolts fit tight through rocker arms and alignment plates.
Timing Mark			Rotate Crank to Piston Stop Slowly On #1 Cylinder to find TDC, record degree reading on dampner, rotate crank in opposite direction slowly until piston stops record dampner reading, split difference for TDC(0)
Dampner	Loctite	100 Ft Lbs	
Front Drive	Oil	60 Ft Lbs	

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Oil Pan			At corners where front and rear covers meet block, apply a thin coat of silicone before placing gaskets on pan rails
Left Head Plate			10mmX35mm Allen bolts with AN Washers
Right Head Plate			1-10X30mm and 3-10X70mm through alt.plate
Intake Manifold		90 INCH Lbs	
Flywheel Bolts	Loctite	60 Ft Lbs	
Clutch Plates	Loctite	25 Ft Lbs	
Water Pump	Anti Seize		
Fuel Pump			Assembly Lube on Arm
Spark Plugs			Tapered Seat Only Recommend Autolite 473
Firing Order			<b>18726543</b>
Timing			Set to 29 degrees @ 4000 Rpm
Fuel			Leaded or Unleaded Racing (Valves are Coated)
Carburetor			86 to 93 jets, all four corners. Float Level set at .200. Road racing will require trimmed floats or separate road racing Carb.
Oil			Mobile One 5W-30

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