



Make sure all block threads are completely clean right into the bottom.

Fit studs to block 10 lbs/ft max using a stud driver

Lube all the threads and oil the washers

For the top 10 bolts

- torque head nuts to 30 lbs/ft,
- then 50 lbs/ft
- then 70 lbs/ft and repeat the sequence with 70lbs/ft 2 or 3 times

For lower 4 bolts

- torque head nuts to 20 lbs/ft,
- then 45 lbs/ft
- Repeat 2x

144 W Britannia St, Building 25, Taunton MA 02780

1 - 5 0 8 - 8 8 0 - 5 4 4 8 - contact@thewedgeshop.com

<https://www.thewedgeshop.com> & <https://www.twsmotors.com>