

INSTALLATION METHOD FOR MAIN BOLT KITS

Part Number: 201-5201 Application: BMW S1000RR Motorcycle

1. To ensure proper thread engagement and accurate torque readings, clean **ALL** threads in the engine case. Chase the threads if necessary with a Thread Chaser.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
3. Assemble the case halves according to OEM procedures and check for binding or misalignment.
4. Lubricate the underhead of the bolts and the bolt threads with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. **ARP recommends using the ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT that is provided with each kit as opposed to motor oil. This is due to higher friction on the bolts as well as inconsistencies in the clamping force of the fasteners when motor oil or other low quality lubricants are used.**
5. Install the factory sealing washers and the bolts as shown (see illustration).

PRELOAD (TORQUE) RECOMMENDATIONS

6. Following the manufacturers recommended torque sequence tighten the bolts in **equal steps** to the specifications listed below **with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT**.

For applications meeting
OEM load requirements

M9	50	ft lbs
M8	30	ft lbs
M6	11	ft lbs

For applications exceeding
OEM load requirements

M9	60	ft lbs
M8	40	ft lbs
M6	11	ft lbs

FOOTNOTE: When changing from factory fasteners to high strength fasteners, clamping force and tolerances will change, therefore it will be necessary to check the main bearing bores for proper size and out of round condition after installation of the bolts and align hone the engine case if necessary. The main bores should always be align honed using the same fasteners and lubricant which will be installed during final engine assembly at the recommended preload.

Bolt and Washer Locations

