

Supplemental Information & Instructions for 320-899 Bolt & Lock Washer Set, Wrist Pin Clamp MG T-Series Engines

Contents of Kit

Qty	Item#	Description
4	320-891	Bolt, wrist pin clamp, 8 MM X 1.0 x 30 MM
4	324-030	Lock Washer, Square Cross-Section
1	322-815	ARP Ultra-Torque Assembly Lube
1	980-277	Supplemental Information Sheet (this document)

A Little History

The original bolt fitted to the small end of the connecting rod was one of the "Nuffield Mad Metric" fasteners found on T-Series engines. The head is BSF, and measures 0.525" across the flats (AF). The threads are 8 MM with a 1.0 thread pitch, or 25.5 threads per inch. For years, these bolts were made in the Moss Machine shop from lengths of high tensile strength BSF hex stock, which we purchased in England. As you can imagine, the proper BSF hex material became hard to find, and finally disappeared. When that happened, Moss offered replacement pinch bolts made from both 0.500" hex stock and 13mm (0.511") EN16T steel hex stock. You may already have replacement pinch bolts that are not 0.525" AF. **Important! If you attempt to remove (or install) a bolt with a 1/2" (0.500") or 13mm head using a BSF socket, you will round off the corners on the head. This makes it nearly impossible to tighten or remove the bolt. Test fit your socket on the bolt before you apply significant force.**

New Bolts from Moss

To offer a permanent solution and eliminate the confusion of hex-head bolts in 4 different sizes, we have chosen socket cap bolts made from DFARs (Defense Acquisition Regulations System) military-spec steel alloy, (Class 12.9). Because the new bolts differ in weight from the original bolts and the replacement bolts currently in use, we only supply these in sets of four with lock washers so as not to disturb the balance of the four piston/connecting rod assemblies. The kit includes a packet of ARP Ultra-Torque Assembly Lube for use on these bolts. It allows you to reach within 5% of the required pre-load on the first torque and stays consistent if you re-torque the bolts

Torque Procedure:

1. Lube bolt threads with ARP Ultra-Torque Assemble Lube.
2. Hand thread bolt into assembled piston/wristpin/rod assy.
3. Torque pinch bolt to **15 ft-lbs.**
4. Torque pinch bolt to **28 ft-lbs.**
5. Back bolt off, and re-torque to **28 ft-lbs.**



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