



Instructions for

Trick Flow Main Girdle for the SBF 289/302

TFS-51500700

Thank you for choosing the Trick Flow Main Cap Girdle for your 289/302 Ford. It is designed to fit all two bolt main 289 and 302 blocks using strokes up to 3.500" with front sump or pre 8/27/90 stock rear sump oil pans. Use with other rear sump oil pans may require modifications not listed below. This girdle will give extra support to your lower end by connecting the main caps which greatly limits the amount of deflection possible in any particular main cap/saddle assembly.

Parts list:

- (1) Trick Flow Main Girdle
- (10) Main Bolts
- (1) 1/4"-20 bolt (for securing the oil pump pick-up tube if needed)
- (1) 1/4" lock washer

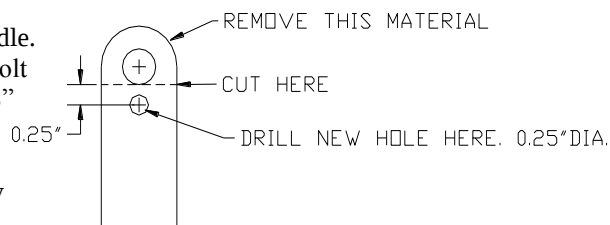
Note: We recommend the following pick-up tube part numbers for 1981 to 8/26/90 stock rear sump oil pans.

Ford	E7PE-6622AA
Melling	68-S4
Speed Pro	224-1411

Installation

Note: In-vehicle installation is not recommended. Some steps will not be required when using front sump oil pans.

1. Remove the oil pump, oil pump pick up, dipstick and tube, and all main bolts.
2. Place the girdle on the main caps.
3. Lubricate the threads of the new main bolts with either moly lube or 30 wt. engine oil then tighten the bolts just enough to properly seat the main caps. Next, torque the main bolts using a torque pattern that starts from the center of the block and works outward to the following specs:
 - **Moly lube: 25 ft-lbs, 45 ft-lbs, 65 ft-lbs.**
 - **Engine oil: 35 ft-lbs, 60 ft-lbs, 85 ft-lbs.**
4. Repeat the final torque step to assure all the bolts are torqued correctly.
5. Reinstall the oil pump, but do not fully tighten the bolts.
6. Reinstall the dipstick and tube assembly. The dipstick tube may need to be bent slightly to align it with the hole in the girdle.
7. Reinstall the oil pump pick-up and note the position of the hold down tab. If needed, cut, deburr and drill the mounting tab as shown below.
8. Bend the modified tab so that the hole aligns with the tapped hole in the girdle.
9. Next, test fit the position of the pick up screen by tightening down the 1/4" bolt and lock washer. The pick up screen should be centered in the pan with 3/8" clearance to the bottom. Be sure to use a pan gasket when checking this clearance.
10. Rotate the crank and rod assembly to check for any interference and modify as needed.
11. When everything is correct, torque the oil pump bolts (lubricated with oil) to 35 ft-lbs. Use a small amount of thread locking compound on the 1/4" mounting tab bolt before tightening.



Ultimate Bolt-On Performance® Lifetime Warranty

Trick Flow Specialties cylinder head castings are backed by a lifetime warranty. If a cylinder head casting fails to provide the original purchaser with complete satisfaction, Trick Flow Specialties will repair or replace it free of charge — guaranteed!

Moreover, the valves, valve guides, valve seats, valve job, valve springs, valve spring retainers, valve locks, rocker arm studs, guideplates, and valve stem seals included on assembled Trick Flow Specialties cylinder heads are warranted to the original purchaser to be free from defects in materials and workmanship for a period of two years from the date of purchase. All other Trick Flow Specialties products are warranted to be free from defects in materials and workmanship for a period of 90 days. There are no mileage limitations.

Extent of Warranty

Customers who believe they have a defective product should return it to the dealer from which they purchased or ship it freight prepaid to Trick Flow Specialties along with proof of purchase and a complete description of the problem. If a thorough inspection indicates defects in materials or workmanship, our sole obligation is to repair or replace the product.

This warranty is only if the product is properly installed, subjected to normal use and service, did not fail due to owner negligence or misuse, and has not been altered or modified.

Trick Flow Specialties warranties do not cover any installation or removal costs.

Trick Flow Specialties is not liable for consequential damages for breach of contract of any warranty in excess of the purchase price of the product sold.

PROPOSITION 65 WARNING

This product may contain one or more substances or chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

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