



Installation Instructions for KPMI Part No: **30-33950**

HONDA® • CRF450R • 2002-2008 / HONDA® • CRF450X • 2005-2017

HONDA® • TRX450R/ER • 2006-2014

Black Diamond™ Cylinder Studs

A) 30-33950 Kit Includes

Quantity	Size Info	Size Info	Description	Remarks
4-Pcs	6.915"	Overall Length	Stud	-
4-Pcs	M10 x 1.25	12-Point	Nut	12mm socket
4-Pcs	0.745" OD	0.405" ID	Washer	-

B) Instructions

1. It is imperative that the threads this stud kit will be installed into, are intact, free of burrs and are properly formed. Preferably use a M12 x 1.25 Roll Tap and re-tap each internal thread. By using a Roll Tap you are reforming the thread vs cutting material away, which produces a stronger thread. In most cases you will not need to clean up the threads if all threads are properly formed, intact and a stud can screw in by hand uninterrupted. In the event threads are worn or badly deformed or missing, proper repair will be necessary beyond re-tapping, before installing this stud kit.
2. The case end of the stud is the larger M12 diameter, the smaller M10 diameter is the nut end. Apply motor oil to the **M12** each stud and thread the lubricated end by hand into the case. Screw the stud all the way in by hand and leave loose. Repeat this procedure for each stud.
3. Once all studs are installed into the case and the cylinder head is in place as per the OEM instructions, Install the 4 washers and apply motor oil to the exposed stud threads. Thread the nuts on by hand till tight.
4. Using a crisscross torque-sequence for all steps, initially torque to 25-ft/lbs. Set the final torque at 40-ft/lbs. Note, this a wet torque recommendation. Do not exceed 40-ft/lbs. for any reason. This is a 10-12mm stud being threaded into aluminum and the clamping force being achieved with these Heavy Duty KPMI® Black Diamond™ Studs will be a significant.

Packaged By: _____

999-102725

3/3/2021

Date: _____

Rev 1