

# INSTALLATION - SERVICE INSTRUCTIONS

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Bulletin #7

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## Replacement Main Caps

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### PART NUMBERS :

PART NUMBERS :	DESCRIPTION :
56200.....	Dana 60 steel main cap
58100.....	12 Bolt Chevrolet steel main cap
59300.....	8.8 Ford steel main cap
V-60050.....	Viper Dana 44 (Gen 2 & 3)

### DESCRIPTION :

### PART INCLUDED :

1 - 56200.....	1- Billet steel cap, 2 - 03004642.....	1/2"-13 X 2-1/2" Allen bolts (Dana 60).
1 -58100.....	1- Billet steel cap, 2 - 03004441.....	7/16"-14 X 2-1/4" Allen bolts (12 Bolt).
1 -59300.....	1- Billet steel cap, 2 - 03004640.....	1/2"-13 X 2" Allen bolts (8.8 Ford).
1 -V-60050.....	1- Billet steel cap, 2 - 03004642.....	1/2"-13 X 2 1/2" Allen bolts (Viper Dana 44).

### PRIMARY APPLICATIONS :

All applications for increased strength or replacement of broken or missing cap.

### INSTALLATION OVERVIEW :

- 1) Using a 1/2"-13 (Dana 60, 8.8 Ford & Viper) or 7/16"-14 (12 Bolt) tap, tap the two cap bolt holes in the housing as deep as possible.
- 2) Insert by hand the two furnished bolts until they bottom out. Measure the distance from the bottom of the bolt head to the cap mating surface on the case. This distance can not be any greater than 1-7/16" for Dana 60, 1-3/4" for 12 bolt Chevrolet, 1 1/8" for 8.8 Ford and 1 1/4" for Viper Dana 44(diagram A). If the distance is to great to obtain the proper dimension drill deeper and re-tap.
- 3) Remove the two bolts and install the cap with the chamfered edge towards the wheel side of the rear. Shift the cap on the housing until the cap and the housing bore match. Torque the bolts to the specs below.
- 4) Using an inside micrometer, measure the bore dimension as shown (diagram B).
- 5) Subtract the measured bore dimension from final bore dimension to determine how much material needs to be removed from the cap parting surfaces. The cap can be milled or ground in a rod cap grinder to remove the excess material. Reinstall the cap after machining, align cap and housing bore and re-torque bolts. Re-measure the final bore dimension. Bore should measure. 3.812 +/- .001 for Dana 60, 3.0625 +/- .001 for 12 bolt Chevrolet, 8.8 Ford and Viper Dana 44 (diagram B).
- 6) **Viper caps only**, The pad on top of the cap must be flycut to match the back face of the housing (+/- .001) after step 5 has been completed.

### TORQUE SPECS :

7/16"-14 X 2-1/4" 65-70 foot pounds  
1/2"-13 x 2" & 2-1/2" 85-90 foot pounds.

### MAINTENANCE REQUIREMENTS :

Periodic checks of cap bolt torque.

