



M-6009-C392 Short Block Assembly INSTRUCTION SHEET

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!!! PLEASE READ ALL OF THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION. AT ANY TIME YOU DO NOT UNDERSTAND THE INSTRUCTIONS, PLEASE CALL THE FORD RACING TECHLINE AT 1-800-367-3788 !!!

OVERVIEW:

The M-6009-C392 engine short block assembly is used to build the C392 engine. This engine is intended for drag race or street rod vehicles (not subject to emission restrictions). The pistons are notched to suit GT-40 and Z304 aluminum cylinder heads with cams up to .600" lift.

Short block components include:

- Sportsman 351W two bolt block.
- Forged aluminum 4.030" pistons with a 15cc dish and full floating pins & pin locks.
- M-6200-D351 Sportsman high strength SAE 4130 forged steel connecting rods with 3/8" ARP 190,000 psi rod bolts. Rods are bushed for floating pins.
- M-6303-B385 3.85" stroke forged 4340 steel crank.
- Clevite CB-831P or Federal Mogul 7155CH rod bearings.
- Clevite MS-1432H or Federal Mogul 130M main bearings.
- Sealed Power 9902+.030" piston rings.

Notes:

1. VALVE TO PISTON CLEARANCE MUST BE CHECKED with any high lift camshaft. Recommended minimum clearance is .100" intake, .125" exhaust.
2. Rod shoulder to cam lobe clearance must also be checked. If required, machine the rod shoulders to obtain .050" minimum clearance.
3. Check and/or RETORQUE THE MAIN AND ROD BOLTS! Mains should be 105 ft./lbs., rods are 50 ft./lbs. with ARP moly lube.
4. The crank has been externally balanced using standard 351W 28.2 oz./in. imbalance in the damper and flywheel. The M-6316-C351 damper and M-6375-A302 157 tooth flywheel are commonly used with this assembly for manual transmission applications. Other dampers and flywheels for various manual and automatic transmission applications are available from Ford Racing.
5. A performance oil pan to suit the intended vehicle application and usage should be carefully chosen.

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356



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Bore x Stroke - 4.030" x 3.850"

Piston specs - 1.615" compression height, dish + notch volume = 15 +/- .5 cc

.912" floating pin w/ four lock rings (two per side)

1/16", 1/16", 3/16" Speed Pro R9902 +.030 ring pack

Nominal compression ratio – 9.7:1 (range is +/- .5) with 64 cc combustion chamber heads

Deck height - 9.50"

Piston to deck - .000" min.

Note: all dimensions are nominal

Torque Specs - with 30 weight oil

Main bearing bolts - 105 ft./lbs.

Con. Rod bolts - 50ft./lbs. with ARP moly lube

Cylinder head bolt - 3 steps, 45 / 75 / 105 ft./lbs.

Recommended Clearances:

Piston to bore .0038 - .0042"

Ring end gap Top .020", 2nd .016"

Piston pin .0008 - .0012" (snug but can be turned by hand)

Crank end play .004 - .008"

Main bearing .0025 - .0035"

Rod bearing .002 - .003"

Rod side clear .010 - .015"

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