

# ARP Head Stud Kit Installation Instructions

SAC – 7/25/2023

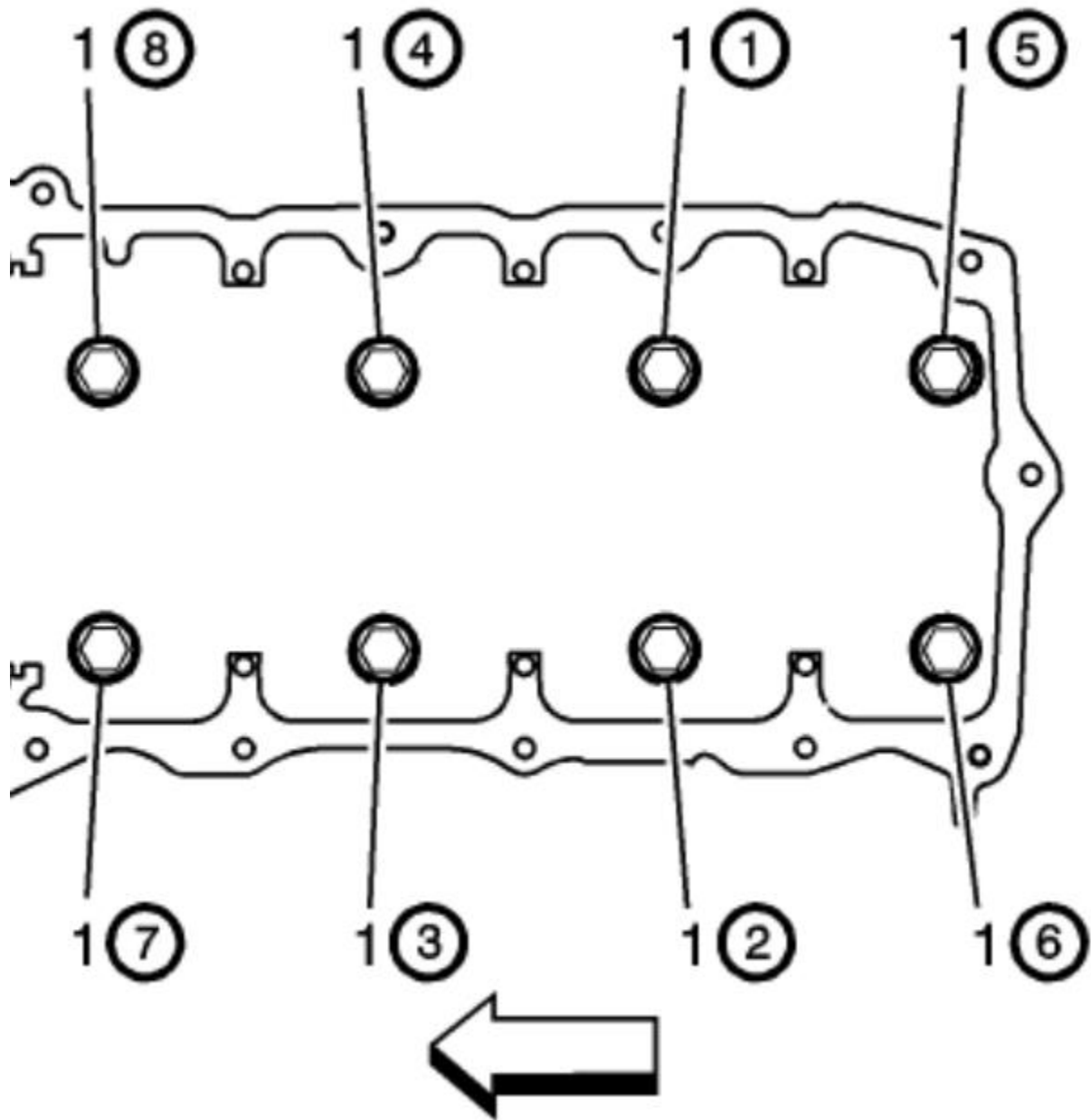
## Installation instructions with cylinder heads already installed:

1. Remove valve covers.
2. Remove one head bolt at a time, and replace with one head stud, in the order shown on the following pages.
3. Use brake cleaner to clean the spot faces where the washers will seat.
4. Screw the studs into the block hand tight. Note that the hex broach in the end of the stud is designed to assist with installing/removing studs from the block, not for applying torque. **Do not use torque.**
5. Use a clean, dry, lint free rag to remove all oil from both sides of each washer. **The cylinder head and washer mating surfaces must be free of oil/grease/lubricant. Failure to keep these surfaces dry may result in inconsistent clamp loads.**
6. Place the washers over the studs and on to the dry, clean spot faces of the cylinder head stamped side down. The stamped surface grips the cylinder head preventing the washer from spinning while the nut is being torqued. The result is accurate and consistent clamp load.
7. Lubricate the stud threads and bottom of the nuts with fastener assembly lubricant. Then install the nuts onto the studs and tighten hand tight.
8. ARP Pro Series head stud kit nuts should be tightened to 25, 50, then 80 foot-pounds, following the sequence shown on the following pages.
9. ARP Custom Age 625+ head stud kit nuts should be tightened to 35, 70 and 100 foot-pounds, following the sequence shown on the following pages.
10. Double check them all to verify they are properly torqued to 80 or 100 foot-pounds, depending on which head studs you're installing.

## Installation instructions with cylinder heads removed:

1. Install head gaskets and cylinder heads.
2. Use brake cleaner to clean the spot faces where the washers will seat.
3. Screw the studs into the block hand tight. Note that the hex broach in the end of the stud is designed to assist with installing/removing studs from the block, not for applying torque. **Do not use torque.**
4. Use a clean, dry, lint free rag to remove all oil from both sides of each washer. **The cylinder head and washer mating surfaces must be free of oil/grease/lubricant. Failure to keep these surfaces dry may result in inconsistent clamp loads.**
5. Place the washers over the studs and on to the dry, clean spot faces of the cylinder head stamped side down. The stamped surface grips the cylinder head preventing the washer from spinning while the nut is being torqued. The result is accurate and consistent clamp load.
11. ARP Pro Series head stud kit nuts should be tightened to 25, 50, then 80 foot-pounds, following the sequence shown on the following pages.
12. ARP Custom Age 625+ head stud kit nuts should be tightened to 35, 70 and 100 foot-pounds, following the sequence shown on the following pages.
13. Double check them all to verify they are properly torqued to 80 or 100 foot-pounds , depending on which head studs you're installing.

Left (driver) side torque sequence:



Right (passenger) side torque sequence:

