Automotive Racing Products 1863 Eastman Avenue Ventura, Ca 93003



PROFESSIONAL QUALITY FASTENERS Tel: (805) 339-2200 Fax: (805) 650-0742 www.arp-bolts.com

## INSTALLATION METHOD FOR HEAD STUD KITS Part Number: <u>260-4704</u> Application: <u>Subaru 2.0L-2.5L DOHC EJ Series CA625+</u>

- 1. Inspect all hardware prior to installation. Look for obvious defects or shipping damages. Please call 800-826-3045 with any questions or issues.
- 2. To ensure proper thread engagement and accurate torque readings, clean all threads in the block. Chase if necessary with ARP Thread Chaser, part number <u>912-0004 (M11 X 1.25)</u>
- 3. Clean the spot faces on the cylinder head where the washer seats, use of solvent or brake/carb cleaner is recommended.
- 4. Install the head gasket and cylinder head.
- 5. Screw the studs into the block hand tight, do not apply torque. The hex broach in the end of the stud is designed to assist with installing/removing the studs from the block, not for applying torque.
- 6. Then, using a clean, dry rag 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 preloads.
- 7. Place the washers over the studs and on to the dry, clean spot faces of the cylinder head.
- 8. Lubricate the stud threads and bottom of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and tighten hand tight.

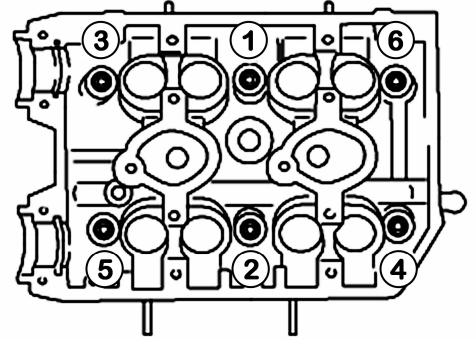
## **TORQUE PROCEDURE**

9. Following the manufacturers recommended torque sequence, shown below, torque the nuts per steps 1-3

100 ft-lbs

- 1- Tighten nuts 1 through 6 to 35 ft-lbs
- 2- Tighten nuts 1 through 6 to 70 ft-lbs
- 3- Tighten nuts 1 through 6 to

## **BOLT TORQUE SEQUENCE**



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