

TIGHTENING METHOD

BLT-STUD-DUR-2.0L

Head stud kit.

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NOTE -USE A STANDARD HEAD GASKET WITH THIS KIT

METHOD

ARP lubricant must be used on all threads and underneath face of nut and washer.

BEFORE CYLINDER HEAD IS INSTALLED: -

- 1. Ensure threads in block & on stud are completely clean**
- 2. Apply lubricant to stud threads & screw stud into block finger tight only.**

Once cylinder head is installed, fit nut & washer then: -

STAGE 1---25 LB/FT

STAGE 2---Back off ½ turn

STAGE 3---25 LB/FT

STAGE 4---60 LB/FT

STAGE 5---Back off ¼ turn

STAGE 6---60 LB/FT

DURATEC HEAD STUD TIGHTENING SEQUENCE

8	4	1	5	9
7	3	2	6	10

DURATEC HEAD STUD REMOVAL SEQUENCE

3	7	10	6	2
4	8	9	5	1



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