

Automotive Racing Product
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INSTALLATION METHOD FOR HEAD BOLT KITS HIGH PERFORMANCE SERIES

170,000 Psi

7/16-inch Diameter

- [1] To ensure proper thread engagement and accurate torque readings, clean and re-tap, if necessary ALL threads in the block.
- [2] Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
- [3] a. **IF** cylinder head bolts protrude into the water jacket, lubricate the threads of the bolts with **ARP Thread Sealer**.
b. If cylinder head bolts protrude into blind hole, lubricate the threads with **ARP MOLY ASSEMBLY LUBRICANT** or 30wt motor oil.
- [4] Install cylinder heads and check for binding or misalignment.
- [5] ARP recommends using the ARP MOLY LUBRICANT or at the very least, a good quality Moly Lubricant as opposed to motor oil. This is due to higher friction on the bolts as well as inconsistencies in the clamping force of the fasteners when motor oil (or low quality lubricant) is used.

PRELOAD (TORQUE) RECOMMENDATIONS:

- [A] Torque values are based on 75% of the fasteners yield strength. Use the manufacturers torque sequence but do not use the engine manufacturers torque specs. Torque the bolts to 65 ft lbs for **ARP MOLY ASSEMBLY LUBRICANT (or ARP THREAD SEALER)** or torque to 85 ft lbs with 30wt motor oil.
- [B] Due to the heat expansion rate of ALUMINUM, it is recommended that the torque should be 60 ft lbs with **ARP MOLY ASSEMBLY LUBRICANT (or ARP THREAD SEALER)**.

Note: Do not use any other Moly Lubricant. Use only ARP Moly Lube or head gasket failure can result.