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**PROFESSIONAL
QUALITY
FASTENERS**

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Installation Method For Head Stud Kits

This guide describes how to install ARP Head Studs into your engine block.

PI152-4201

200,000 PSI

12mm Diameter (Metric for SOHC & Intech Blocks)

Note: When installing head studs, do not torque them into the block! They should be finger tight. If you have height issues due to drill depths in the block, the engine builders' trick is to drop a [ball bearing](#) down the hole. It is recommended to purchase a pack when buying head studs.

1. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. Chase if necessary with a thread chaser.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
3. If the cylinder head studs protrude into a water jacket, lubricate the block threads of the studs with ARP THREAD SEALER.
4. Screw studs into the block "HAND TIGHT ONLY". If you have height issues due to different drill depths in the block, the engine builders' trick is to drop a 6mm ball bearing down the thread.
NOTE: LOCTITE MAY BE USED IF A PERMANENT MOUNTING OF THE STUDS IS PREFERRED. THE FASTENERS, HOWEVER, MUST BE TORQUED PRIOR TO THE LOCTITE SETTING UP.
5. Install the cylinder head(s) and check for binding or misalignment.
6. Lubricate the stud threads, nuts and washers with supplied ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the washers and the nuts onto the studs and tighten them hand tight. ARP recommends using the ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT that is provided with each kit as opposed to motor oil. This is due to higher friction on the studs as well as inconsistencies in the clamping force of the fasteners when motor oil or other low quality lubricants are used.
7. PRELOAD (TORQUE) RECOMMENDATIONS
Following the manufacturers recommended torque sequence, tighten the nuts in three equal steps to [110 ft lbs](#) with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT.

Note: ARP Ultra-Torque Fastener Assembly Lubricant has been specifically designed to reduce tension preload scatter and eliminate the need to cycle high performance engine fasteners before final installation. ARP Ultra-Torque far surpasses all requirements offered by previous ARP lubricants in terms of fastener preload repeatability and performance lubricating properties. To purchase ARP Ultra-Torque contact T.I. Performance.

Please [contact us](#) if you have any trouble with installation.