

PROFESSIONAL QUALITY FASTENERS

INSTALLATION METHOD FOR PRO SERIES HEAD BOLT KITS

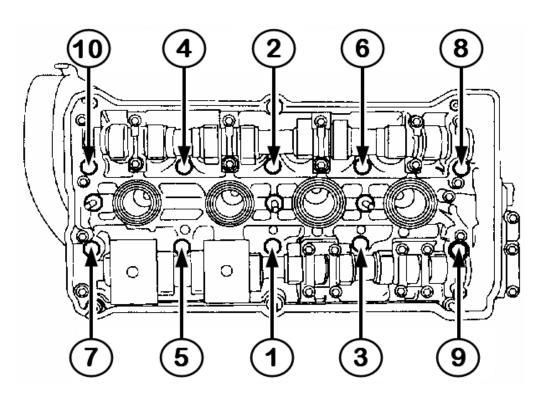
Part Number: 204-3901 & 204-3902 Application: VW/Audi 1.8L 20V Turbo (M10)

- 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>912-0003 (M10x1.5)</u>
- 3. Install the head gasket and cylinder head.
- 4. Lubricate the bolt threads and bottom of the heads of each bolt with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the bolts and tighten hand tight.

TORQUE PROCEDURE

- 5. Following the manufacturers recommended torque sequence, shown below, torque the bolts per steps 1-3
 - 1- Tighten bolts 1 through 10 to 30 ft-lbs
 - 2- Tighten bolts 1 through 10 to 60 ft-lbs
 - 3- Tighten bolts 1 through 10 to 80 ft-lbs

TORQUE SEQUENCE



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