

INSTALLATION METHOD FOR PRO SERIES HEAD BOLT KITS

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

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 912-0003 (M10x1.5)
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
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|----------------------------------|-----------|
| 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

