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INSTALLATION METHOD FOR HEAD STUD KITS

Part Number: 247-4202 Application: Dodge/Cummins 5.9L/6.7L 24V HSK, Long exhaust row studs.

Tools Needed:
5mm Allen wrench
14mm socket

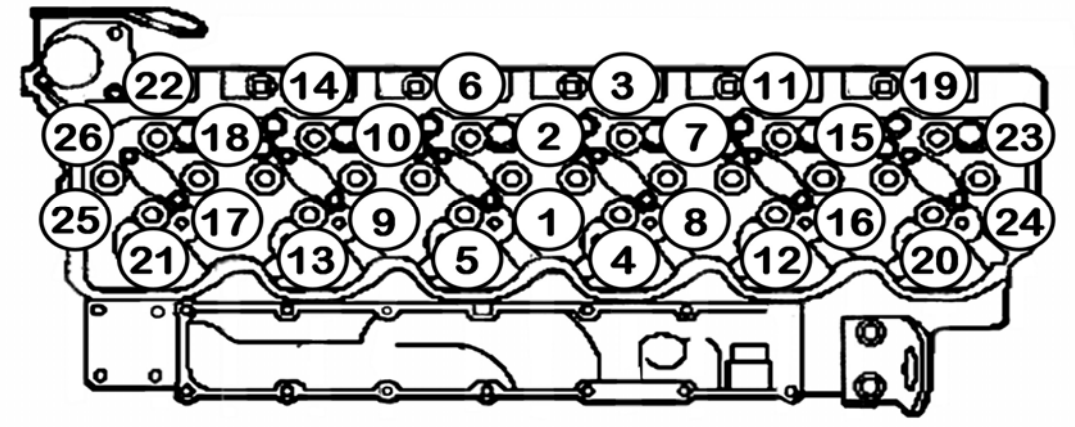
1. Inspect all hardware prior to installation. Look for obvious defects or shipping damages. Please call 800-826-3045 with any questions or issues.
2. To ensure proper thread engagement and accurate torque readings, clean all threads in the block. Chase if necessary with ARP Thread Chaser, part number 912-0008 (M12 X 1.75)
3. Install the head gasket and cylinder head.
4. Screw the studs into the block, do not apply torque. The hex broach in the end of the stud is designed to assist with installing/removing the studs from the block, not for applying torque.
   NOTE: The 6.625″ long studs install along the exhaust manifold side of the cylinder head in the No. 3, 6, 11, 14, 19 and 22 positions of the torque sequence.
5. Lubricate the both sides of the washers with ARP Ultra-Torque Fastener Assembly Lubricant then place them over the studs onto the cylinder head spot faces.
6. Lubricate the stud threads and bottom of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and thread by hand down until the nut contacts the washer.

TORQUE PROCEDURE

7. Following the manufacturers recommended torque sequence, shown below, use a **14mm** socket to torque the nuts per steps 1-3

   1- Tighten nuts 1 through 26 to 40 ft-lbs
   2- Tighten nuts 1 through 26 to 80 ft-lbs
   3- Tighten nuts 1 through 26 to 125 ft-lbs

TORQUE SEQUENCE



Note: It will be necessary to machine the lower rocker arm cover at the No. 24 bolt hole location in the torque sequence to facilitate installation of the lower rocker arm cover (see illustrations).

Remove material as necessary to allow clearance for the stud, nut and washer.

Finished machine work should allow easy removal and installation of the head stud.