

## **INSTALLATION METHOD FOR HEAD STUD KITS**

**Part Number: 250-4301 Application: Ford 6.7L PowerStroke Diesel**

1. Clean and 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. Install the shorter M12 studs in locations 11, 13, 15 and 17.

**NOTE: Before proceeding, test fit the valve covers to verify clearance between the studs and valve covers. If the stud interferes with the valve cover preventing it from seating please call 800-826-3045.**

5. Place the washers over the studs then lubricate the stud threads and bottom of the nuts with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the nuts onto the studs and tighten hand tight.

### **TORQUE PROCEDURE**

6. Following the manufacturers recommended torque sequence, shown below, torque the nuts per steps 1-4 below.
  - 1- Tighten nuts 1 through 18 (M12) to 40 ft-lbs
  - 2- Tighten nuts 1 through 18 (M12) to 80 ft-lbs
  - 3- Tighten nuts 1 through 18 (M12) to 125 ft-lbs
  - 4- Tighten nuts 19 through 22/23 (M8) to 28 ft-lbs

### **Bolt Torque Sequence**

