

## INSTALLATION METHOD FOR HEAD STUD KITS

**Part Number: 203-4101 Application: Toyota 1.5L (1NZFE) DOHC 4-cyl**

**NOTE: CHECK CLEARANCE BETWEEN HEAD STUD / NUT TO CAMSHAFTS AND VVT-I SOLENOID PRIOR TO ASSEMBLY. IF STUD/NUT INTERFERES WITH CAMSHAFT OR SOLENOID PLEASE CALL 800-826-3045**

1. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
2. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. Chase if necessary with a Thread Chaser.
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".  
NOTE: LOCTITE MAY BE USED IF A PERMANENT MOUNTING OF THE STUDS IS PREFERRED.
5. Install the cylinder head(s) and check for binding or misalignment.
6. Lubricate the stud threads, nuts and washers with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the washers and the nuts onto the studs and tighten them hand tight.

### TORQUE PROCEDURE

7. Following the manufacturers recommended torque sequence, shown below, torque per steps below:
  - 1- Tighten nuts 1 through 10 to 20 ft-lbs
  - 2- Tighten nuts 1 through 10 to 35 ft-lbs
  - 3- Tighten nuts 1 through 10 to 55 ft-lbs

### TORQUE SEQUENCE

