



INSTALLATION INSTRUCTIONS

Part No: 234-3602 & 234-3725

Application: Chevy Gen III LS Series (2004 & later) ARP2000

NOTES

Inspect all hardware prior to installation. Look for obvious defects or shipping damages. Please call 800-826-3045 with any questions or issues

The engine block and cylinder head decks must be flat and have the proper surface finish for the head gasket used or gasket failure may result

To ensure proper thread engagement and accurate torque readings, clean all threads in

the block to remove remnant sealer, lubricant and debris. Chase if necessary with ARP Thread Chaser, part numbers 912-0011 (M11x2.0) 912-0001 (M8x1.25)

Before final assembly, a mockup of the engine and or components to check the fit and clearance near and around the fasteners is recommend.

SOCKETS NEEDED

13MM, 10MM

FINAL ASSEMBLY

1. **Clean the spot faces on the cylinder head.**

Brake cleaner is recommended to clean the spot faces where the washer seats.

2. **Use a clean, dry rag to remove all oil from both sides of each washer.**

The cylinder head and washer mating surfaces must be free of oil/grease/lubricant. Failure to keep these surfaces dry may result in inconsistent clamp loads.

3. **Place the washers on to the dry, clean spot faces of the cylinder head.**

The stamped side of the washer goes down against the cylinder head. This stamped surface grips the cylinder head preventing the washer from spinning while the bolt is being torqued. The result is accurate and consistent clamp load.

The ID chamfer side of the washer must face the bolt head.

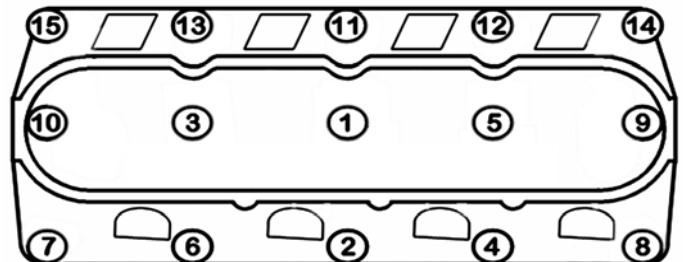
4. **Apply ARP Ultra-Torque**

Lubricate the bolt threads and bottom of the head of each bolt with ARP Ultra-Torque Fastener Assembly Lubricant. Install the bolts and tighten hand tight.

TORQUE PROCEDURE

5. Following the manufacturers recommended torque sequence, torque the bolts per steps 1-4

- 1- Tighten bolts 1 through 10 (11mm) to 30 ft-lbs
- 2- Tighten bolts 1 through 10 (11mm) to 60 ft-lbs
- 3- Tighten bolts 1 through 10 (11mm) to 90 ft-lbs
- 4- Tighten bolts 11 through 15 (8mm) to 25 ft-lbs



Automotive Racing Products (ARP), Inc
1863 Eastman Ave, Ventura Ca 93003
Tech Support 805-339-2200 Email info@arpfasteners.com