Automotive Racing Products
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PROFESSIONAL QUALITY FASTENERS

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INSTALLATION METHOD FOR HEAD STUD KITS

Part Number: 234-4349 Application: Dart LS Next, iron block ½", 15-bolt head

NOTE: The following torque recommendation is based on the stud capability only. Please refer the block manufacturer's recommendation before proceeding with final assembly.

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 911-0005 (1/2-13) and 912-0001 (M8 X 1.25).
3. Install the gasket(s) and cylinder head(s)
4. Install the studs into the block per locations listed below. 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.

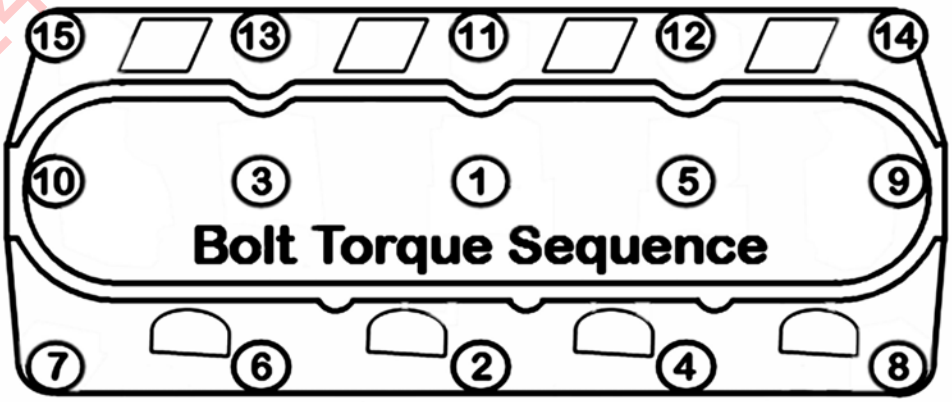
Location	Stud Dimensions
1-6	1/2 x 3.400" overall length
7-8	1/2 x 3.620" overall length
9-10	1/2 x 3.400" overall length
11-15	M8-5/16 x 2.550" overall length

5. 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.
6. Place the washers over the studs onto the dry, clean spot faces of the cylinder heads.
7. 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

8. Following the torque sequence shown below, torque the nuts per steps 1-4 below. **See note above.**

1-	Tighten nuts 1 through 10 (1/2) to	35 ft-lbs
2-	Tighten nuts 1 through 10 (1/2) to	70 ft-lbs
3-	Tighten nuts 1 through 10 (1/2) to	110 ft-lbs
4-	Tighten nuts 11 through 15 (M8-5/16) to	28 ft-lbs



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