

INSTALLATION METHOD FOR HEAD STUD KITS

Part Number: 238-4201

Application: Caterpillar C15 HSK

Tools Needed:
1/4 Allen wrench
15/16 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.
3. Install the spacer plate, 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 long studs install in the No. 11, 12, 13, 14, 16, 18, 20, 22, 24 and 26 positions of the torque sequence.
5. Lubricate 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 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 **15/16** socket to torque the nuts per steps 1-3
 - 1- Tighten nuts 1 through 26 to 150 ft-lbs
 - 2- Tighten nuts 1 through 26 to 300 ft-lbs
 - 3- Tighten nuts 1 through 26 to 440 ft-lbs

TORQUE SEQUENCE

