

## INSTALLATION METHOD FOR HEAD STUD KITS

**Part Number: 154-4103 Application: Ford Flathead (1938-48) w/ Offenhauser heads**

1. **Always verify the part number for your application with the part number on the side of box and the part number on the instruction sheet. This will help ensure you have the correct installation procedure for your specific application before installing any components.**
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
3. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. Chase if necessary with ARP Thread Chaser, part number 911-0004 (7/16-14).
4. Lubricate the block threads of the studs with ARP THREAD SEALER.
5. Screw studs into the block "HAND TIGHT ONLY".
6. Install the cylinder head(s) and check for binding or misalignment.
7. 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. **ARP recommends using the ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT that is provided with each kit as opposed to motor oil. This is due to higher friction on the studs as well as inconsistencies in the clamping force of the fasteners when motor oil or other low quality lubricants are used.**

### PRELOAD (TORQUE) RECOMMENDATIONS

8. Following the manufacturers recommended torque sequence tighten the nuts to the following specifications with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT.

**Step 1. Tighten studs to 20 ft-lbs.**

**Step 2. Tighten studs to 40 ft-lbs.**

**Step 3. Final tighten studs to 55 ft-lbs.**

**Note:** It will be necessary to re-torque the cylinder heads after the initial warm up and a complete cool down cycle. Then re-torque the cylinder heads a second time after a month of steady use or 4 to 5 hot/cold cycles of the engine.

## **Bolt Torque Sequence**

