



INSTALLATION INSTRUCTIONS

P/N 38000, 38010 and 38020 CYLINDER HEAD STUD KITS

Please examine the contents of the box before attempting installation. You should have the following pieces:

PART #38000		PART #38010		PART #38020	
16	7/16" SHORT STUDS	20	7/16" LONG STUDS	16	7/16" SHORT STUDS
4	7/16" MEDIUM STUDS	4	7/16" MEDIUM STUDS	4	7/16" MEDIUM STUDS
14	7/16" LONG STUDS	8	7/16" SHORT STUDS	14	7/16" LONG STUDS
34	7/16"-20 NUTS	32	7/16"-20 NUTS	34	7/16"-20 NUTS
34	7/16" WASHERS	32	7/16" WASHERS	34	7/16" WASHERS

Run a 7/16"-14 tap through all of the head bolt holes. Clean the coarse threaded ends of all of your head studs. Use a shop rag with some kind of solvent on it that will leave the thread oil free. Use some type of thread sealer, such as Loctite #271. It is important that you use Loctite #271 and use it correctly, because the head bolt holes go into the water jacket, and, not being careful now could cause you a troublesome leak later. Because these sealers dry quickly, we recommend that you install the studs one at a time. Install the short studs in the correct holes first. Do not use a vise grip or pliers to thread the studs into the block. Use 2 spare 7/16"-20 nuts locked against each other to turn the studs in until they bottom out. Using these nuts, torque the stud to 7-10 ft./lbs. so as not to distort the upper cylinder wall. Remove the nuts and follow the same procedure for the rest of the studs. Make sure on all 32 studs that they are Loctited, and that they are torqued. When you have installed the last stud, wait about 15 minutes to allow the sealer to fully dry.

The gasket and the head may be installed now. Place the washer over the studs with the chamfered edge facing up. Put a few drops of oil on the studs and washers before threading on the nuts. Torque all of the nuts to 70 ft./lbs. using a Chevrolet service manual for the correct sequence. If you use a click type torque wrench, it is a good idea to have the calibration checked every year or so.

We here at Moroso Performance Products feel that you have purchased the finest product available with respect to materials and workmanship. In the unlikely event that you should encounter a problem in installation or use, please contact us, using the quality control number packed with this part in all correspondence with us.

**For Technical Assistance, Call Moroso's Tech Line at
(203) 458-0542, 8:30am – 5:00pm Eastern Time**

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