

INSTALLATION METHOD FOR HEAD STUD KITS

Part Number: 234-4341 Application: Dart LS Next, iron block, 23 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 911-0003 (3/8-16), 911-0004 (7/16-14) and 912-0001 (M8 X 1.25).
3. Install the studs into the block and cylinder head 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	7/16 x 3.450" overall length
7-8	7/16 x 3.650" overall length
9-10	7/16 x 3.450" overall length
11-15	M8-5/16" x 2.550" overall length
16-19	3/8 x 2.250" overall length
20-23	M8-5/16" x 2.725 overall length. These studs install into the bottom of the cylinder head.
4. Install the head gasket(s)
5. Install the cylinder head(s) and check for binding or misalignment.
6. Place the washers over the studs then 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

7. Following the torque sequence shown below, torque the nuts per steps 1-6 below. **See note above.**
 - 1- Tighten nuts 1 through 10 (7/16) to 30 ft-lbs
 - 2- Tighten nuts 1 through 10 (7/16) to 60 ft-lbs
 - 3- Tighten nuts 1 through 10 (7/16) to 90 ft-lbs
 - 4- Tighten nuts 11 through 15 (M8-5/16) to 28 ft-lbs
 - 5- Tighten nuts 16 through 19 (3/8) to 55 ft-lbs
 - 6- Tighten nuts 20 through 23 (M8-5/16) to 28 ft-lbs

