

INSTALLATION METHOD FOR HEAD BOLT KITS

Part Number: 230-3601 & 230-3701 **Application:** Chevy LS9 ARP2000

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 with ARP Thread Chaser, part number 912-0008 (M12x1.75) and 912-0001 (M8x1.25)
3. Clean the spot faces on the cylinder head where the washer seats, use of solvent or brake/carb cleaner is recommended.
4. Install the head gasket and cylinder head.
5. Then, using a clean, dry rag 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 preloads.
6. Place the washers on to the dry, clean spot faces of the cylinder head. Place the stamped side of the washer, see figure to the right, down against the cylinder head. This stamped surface grips the cylinder head preventing the washer from spinning while the bolt is being torqued. The result is accurate and consistent preload. The ID chamfer side of the washer must face the bolt head.
7. Lubricate the bolt threads and bottom of the heads of each bolt with ARP Ultra-Torque Fastener Assembly Lubricant. Then install the bolts and tighten hand tight.



TORQUE PROCEDURE

8. Following the manufacturers recommended torque sequence, shown below, torque the bolts per steps 1-4
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| 1- Tighten bolts 1 through 10 (12mm) to | 40 ft-lbs |
| 2- Tighten bolts 1 through 10 (12mm) to | 80 ft-lbs |
| 3- Tighten bolts 1 through 10 (12mm) to | 130 ft-lbs |
| 4- Tighten bolts 11 through 15 (8mm) to | 25 ft-lbs |

TORQUE SEQUENCE

