



M-6014-G500 Cylinder Head Stud Kit INSTRUCTION SHEET

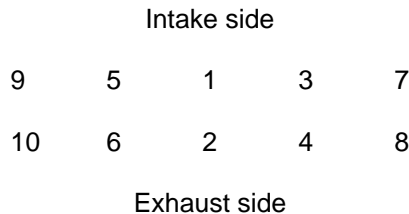
NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD RACING PERFORMANCE PARTS

Please contact the Tech "Hot Line" for the most current instruction information (586) 468-1356

!!! PLEASE READ THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION !!!

INSTALLATION INSTRUCTIONS:

- Step 1:** Clean and re-tap all cylinder head bolt threads in block.
- Step 2:** Clean and inspect all kit components prior to installation. Look for any defects, shipping damage, proper fit, length, etc.
- Step 3:** Apply thread sealer to the coarse threads of the 9/16" studs. Install the studs in the block, **HAND TIGHT ONLY**. Loctite may be used if permanent mounting is preferred (see #6 below).
- Step 4:** Coat nuts, washers and fine threads on studs with 30 wt. oil.
- Step 5:** Install cylinder heads, nuts and washers and torque to 135 ft./lbs. in three steps: 1) 75 ft./lbs.; 2) 105 ft./lbs.; 3) 135 ft./lbs., using the sequence shown below.
- Step 6:** To permanent mount the studs: Use Loctite 262 on the coarse threads. Screw the studs into the block hand tight. Install the cylinder heads. Apply 30 wt. oil to the stud fine threads, nuts and washers. Install the nuts and washers and tighten to preload the stud. Maintain the preload until the Loctite has set up.
- Step 7:** Torque sequence:



Tech "Hot Line" (586) 468-1356

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356