

# BLT-H1-STUD-KIT

## 2.0L 16v Head stud kit.

### **IMPORTANT NOTE**

These Settings are only for use with SBD Cometic head gaskets part numbers: GSK-VX2-C88.00-03, GSK-VX2-C88.00-04 & GSK-VX2-C88.00-5.

Disregard the pre-packaged ARP torque settings

We do not use these head studs with standard gaskets and cannot supply torque settings for their use with standard gaskets or any other gasket.

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### METHOD

Supplied **ARP Ultra-Torque #100-9908** lubricant must be used on all threads and underneath face of nut and washer.

#### **BEFORE CYLINDER HEAD IS INSTALLED: -**

If engine is Post 93 you will need to make a 5mm thick alloy spacer to go under the ARP washer due to the thinner cylinder head (not required on Pre 93)

- 1. Ensure threads in block & on stud are completely clean**
- 2. Apply lubricant to stud threads & screw stud into block finger tight only.**

Once cylinder head is installed, fit nut & washer then:

	GSK-VX2-C88.00-03	GSK-VX2-C88.00-04	GSK-VX2-C88.00-05
STAGE 1	18 LB/FT (25NM)	18 LB/FT (25NM)	18 LB/FT (25NM)
STAGE 2	35 LB/FT (47NM)	35 LB/FT (47NM)	35 LB/FT (47NM)
STAGE 3	55 LB/FT (75NM)	60 LB/FT (81NM)	65 LB/FT (88NM)

## 2.0L 16V HEAD BOLT TIGHTENING SEQUENCE

<b>9</b>	<b>5</b>	<b>1</b>	<b>3</b>	<b>7</b>
<b>10</b>	<b>6</b>	<b>2</b>	<b>4</b>	<b>8</b>

## 2.0L 16V HEAD BOLT REMOVAL SEQUENCE

<b>1</b>	<b>3</b>	<b>9</b>	<b>5</b>	<b>7</b>
<b>2</b>	<b>4</b>	<b>10</b>	<b>6</b>	<b>8</b>

*Please be aware that Technical Support involving our Technicians is chargeable*

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