

INSTALLATION METHOD FOR HIGH PERFORMANCE SERIES HEAD BOLT KITS

Part Number: 190-3609 Application: Pontiac 400-455 w/ Edelbrock D-Port heads

1. Always verify the part number for your application with the part number on the side of box and the part number on the instruction sheet. This will help ensure you have the correct installation procedure for your specific application before installing any components.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages, plus proper fit, length and dimension.
3. To ensure proper thread engagement and accurate torque readings, clean ALL threads in the block. Chase if necessary with ARP Thread Chaser, part number 911-0005 (1/2-13).
4. Position the chamfered side of the washer on the bolt so it faces the bolt head. This is done to clear the radius on the under head of the bolt. **Note:** Improper installation of the washer will cause premature bolt failure.
5. Install the cylinder head(s) and check for binding or misalignment.
6. Lubricate the underhead of each bolt, the bottom side of the washers and the threads with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the bolts into the cylinder head and tighten them hand tight. ARP recommends using the ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT that is provided with each kit as opposed to motor oil. This is due to higher friction on the bolts as well as inconsistencies in the clamping force of the fasteners when motor oil or other low quality lubricants are used.

PRELOAD (TORQUE) RECOMMENDATIONS

7. Following the manufacturers recommended torque sequence tighten the nuts in three equal steps to 100 ft lbs with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT.

Note: ARP Ultra-Torque Fastener Assembly Lubricant has been specifically designed to reduce tension preload scatter and eliminate the need to cycle high performance engine fasteners before final installation. ARP Ultra-Torque far surpasses all requirements offered by previous ARP lubricants in terms of fastener preload repeatability and performance lubricating properties.

Bolt Location and Torque Sequence

(Bolts are measured by underhead length in inches)

