

## INSTALLATION METHOD FOR PRO SERIES HEAD BOLT KITS

Part Number: 204-3901 & 204-3902 Application: VW/Audi 1.8L 20V Turbo (M10)

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 912-0003 (M10 X 1.5).
4. Lubricate the threads of the bolts and the under head of the bolts with **ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT**.
5. Install the cylinder head(s) and check for binding or misalignment.
6. 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 studs 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 80 ft lbs** with **ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT**.

## Bolt Torque Sequence

