PROFESSIONAL QUALITY FASTENERS Tel: (805) 339-2200 Fax: (805) 650-0742 www.arp-bolts.com

## **INSTALLATION METHOD FOR PRO SERIES HEAD BOLT KITS**

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

- 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 912-0003 (M10x1.5)
- 3. Install the head gasket and cylinder head.
- 4. 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**

5. Following the manufacturers recommended torque sequence, shown below, torque the bolts per steps 1-3

1- Tighten bolts 1 through 10 to
2- Tighten bolts 1 through 10 to
30 ft-lbs
60 ft-lbs
3- Tighten bolts 1 through 10 to
80 ft-lbs

## **TORQUE SEQUENCE**

