

## PLAZMAMAN BARRA 4.0L HEAD STUD KIT

1. Look for obvious defects or shipping damages, plus proper fit, length and dimension. This step will make sure you will have zero issues moving forward.
2. Please ensure all threads are cleaned and supplied anti-seize compound is used on all threads, nuts and washers . (very important to use compound under washers and nut to get torque correct)
3. Insert each stud finger tight using the allen key head until they bottom out. (DO NOT TIGHTEN – Just Touching) Make sure an OEM block Dowels are reinserted as required.
4. Once studs are inserted Carefully TEST fit head over the studs, At this stage **DO NOT FIT THE HEAD GASKET** – just test fit the head goes over all studs easily, with out any Binding issues.
5. If all fits well, at this stage you can fit the head gasket and go ahead and bolt head on.
6. Once again **MAKE SURE YOU LUBE ALL UPPER THREADS, WASHERS ANS NUTS**
7. Tighten each nut from the middle of engine outwards (as per factory sequence) in 3 steps .
  7. Step 1 - 38 ft/lbs
  - Step 2 - 75 ft/lbs
  - Step 3 – 100-102 ft/lbs
8. Normally with head studs, once you have done everything correct, re checking Head torque is not required. However if you feel the need to check again, you must follow factory sequence to retorque.