

Installation Method for Head Stud Kits -

6.6L Duramax 2001-2016

SKU: DogBone-HS-0116D

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DOGBONE

Parts Included:

- (36) Head Studs
- (36) Head Stud Nuts
- (36) Head Stud Washers
- (8) Head Bolts
- (1) Assembly Lube

Tools Needed:

- Socket Set
- Torque Wrench
- Thread Chaser
 - M12 x 1.5
 - M8 x 1.25

1. Always verify the part number for your application with the part number on the side of the 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 **912-0007** (M12 X 1.5) and **912-0001** (M8 X 1.25).

4. Screw studs into the block "HAND TIGHT ONLY".

NOTE: LOCTITE MAY BE USED IF A PERMANENT MOUNTING OF THE STUDS IS PREFERRED. THE FASTENERS, HOWEVER, MUST BE TORQUED PRIOR TO THE LOCTITE SETTING UP.

5. Install the cylinder head(s) and check for binding or misalignment.

6. Lubricate the stud threads, nuts and washers with ARP ULTRA-TORQUE FASTENER ASSEMBLY LUBRICANT. Then install the washers and the nuts onto the studs and tighten them hand tight. DogBone 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. **(Continued on Back...)**

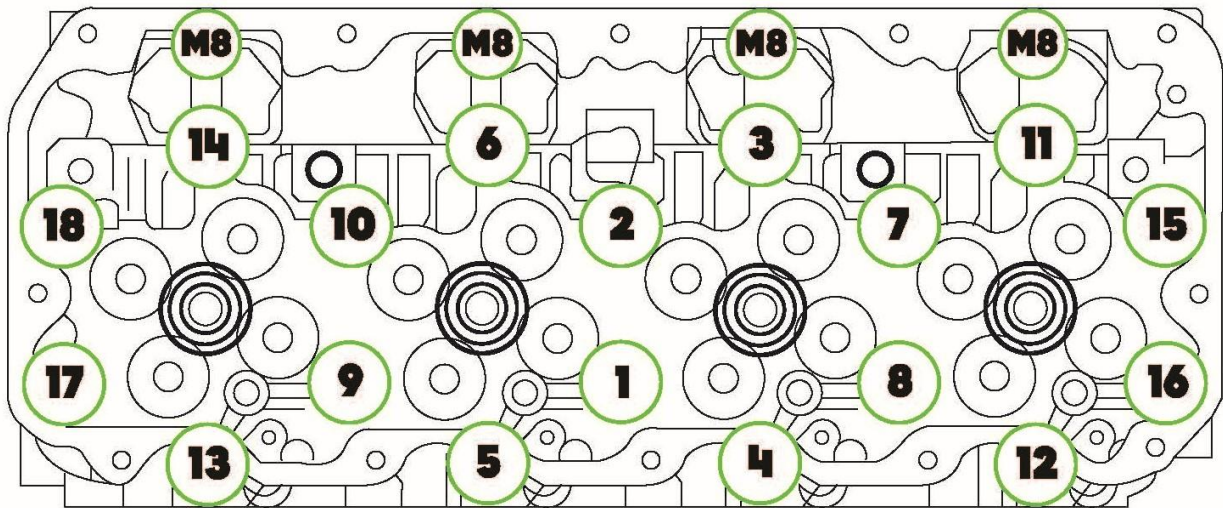
7. Follow the included 3 Step torque sequence to ensure proper clamping forces.

Step 1. The first round should be to 40 ft lbs. (positions 1-18)

Step 2. Then repeat the sequence for 80 ft lbs. (positions 1-18)

Step 3. Followed by 125 ft lbs. (positions 1-18)

****The amount of Head Stud threads showing above the Head Stud Nut should all be about the same. If one appears to have more thread, the stud is most likely not all the way in the head.****



8. Lubricate the mating face (bottom of head) and threads of the Upper Row 8mm Bolts with Assembly Lube and install them following the torque sequence below in a 2-step process going from inward-out.

Step 1. The first round should be to 10 ft lbs.

Step 2. Followed by 25 ft lbs.

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Seller disclaims any responsibility/ liability for improper, incorrect, or inexperienced installation of products by the purchaser or installer resulting in damage or loss. Buyer affirms by purchase of this product that it is fit for intended use and accepts all liability.

Buyer affirms products are used at buyers own risk and accepts full responsibility.