

Head Stud Kit

Subaru Impreza WRX STi EJ20 EJ25

(718032200)

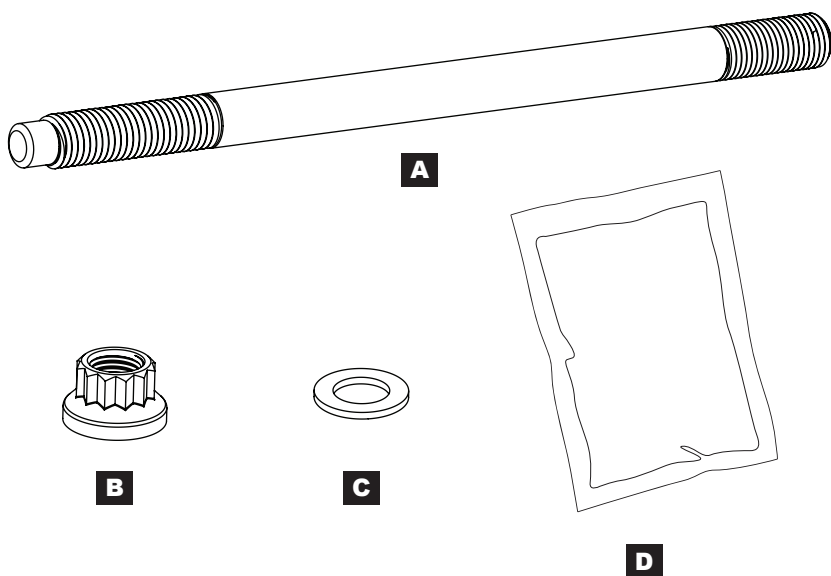
Installation Guide



ATTENTION: We recommend the installation of this part be done by a trained professional Subaru technician. PPE will not accept liability for damage resulting from incorrect assembly.

These instructions are not intended as a service or overhaul manual. These instructions are intended to facilitate the modification of non-factory parts installation by a trained professional.

NOTE: Tolerances will change when changing from factory to high-strength fasteners. It will be necessary to check main bearing bores for proper size and out-of-round condition after installation of the studs. Hone the cylinder block if necessary. Main bores should always be align-honed using the same fasteners and lubricant which will be installed, at the recommended preload, during the final engine assembly.



CONTENTS

- A. (12) M11 x 195mmL Studs
- B. (12) M11 Flange Nuts
- C. (12) M11 Washers
- D. (1) Fastener Assembly Lubricant

Prior to installation, please inspect for any damage or defects and clean all hardware. Verify product part number matches your application. Make sure kit is complete with no missing parts.

NOTE: Loctite may be used for permanent mounting. Torque sequences must be complete prior to Loctite hardening.

Clean all threads in the engine block. Use a bottoming thread chaser if necessary (M11 x 1.25). This would ensure thread engagement and more accurate torque readings.

Install the head gasket followed by the cylinder head. Check for proper alignment.

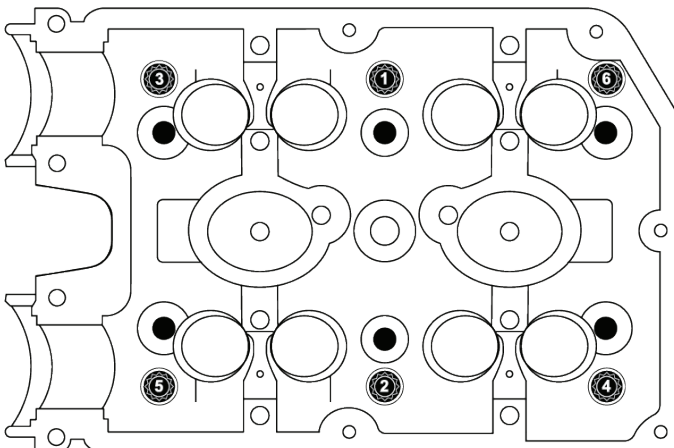
Ensure the washer and mating surfaces are clean and free of all debris.

Install Stud **(A)** into the block. Hand-tighten without tools (equivalent of 20-30 in. lbs.)

Place the washers over the studs.

Lubricate Stud **(A)** threads, and Flange Nuts **(B)** with the fastener assembly lubricant **(D)** provided. Install the Flange Nuts **(B)** on to Studs **(A)**.

Tighten Flange Nuts **(B)** in three equal steps 35/70/100 using the torque sequence to a total spec of 100 ft-lbs.



DISCLAIMER OF LIABILITY

Performance products can increase horsepower above and beyond factory specifications. Additional horsepower creates more stress on the drive-train components, which could result in drive-train failure.

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