

INSTALLATION METHOD FOR HEAD BOLT KITS

Part Number: 203-3801 Application: Toyota 1.3L 4EFE/FTE & 1.5L 5EFE/FHE

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 a thread chaser or tap class D4 or less.
3. **Clean the spot faces on the cylinder head where the washer seats, use of solvent or brake/carb cleaner is recommended.**
4. Install the head gasket and cylinder head.
5. **Then, using a clean, dry rag remove all oil from both sides of each washer. The cylinder head and washer mating surfaces must be free of oil/grease/lubricant. Failure to keep these surfaces dry may result in inconsistent preloads.**
6. Place the washers on to the dry, clean spot faces of the cylinder head. The ID chamfer side of the washer must face the bolt head.
7. 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

8. Following the manufacturers recommended torque sequence, shown below, torque the nuts per steps 1-3
 - 1- Tighten bolts 1 through 10 to 20 ft-lbs
 - 2- Tighten bolts 1 through 10 to 40 ft-lbs
 - 3- Tighten bolts 1 through 10 to 60 ft-lbs

Bolt Torque Sequence

