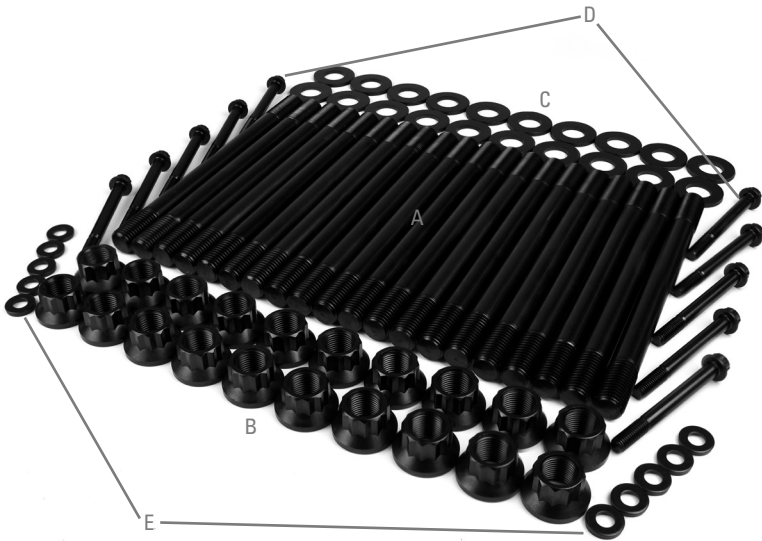




PART NO. XD3004HS

XDP X220 SERIES HEAD STUD KIT

INSTALLATION MANUAL



CODE	DESCRIPTION	QTY
A	Head Stud	20
B	Nut	20
C	16mm Washer	20
D	Inner Row Bolt	10
E	8mm Washer	10



BEFORE REMOVING ANY PARTS FROM YOUR TRUCK, PLEASE COMPARE THE ITEMS YOU HAVE RECEIVED WITH THE PACKING LIST PROVIDED TO VERIFY THAT YOU HAVE EVERYTHING NECESSARY TO INSTALL YOUR NEW XDP X220 SERIES HEAD STUD KIT.



BEFORE YOU BEGIN! Ensure that the vehicle has not been in use and that the engine is cool to the touch. Always wear eye protection when working on any vehicle.

- 1 Verify the part number on the box, and the instructions match the part number for your vehicle application.
- 2 Thoroughly inspect all hardware and ensure proper length and fitment.
- 3 Using a thread chaser (Such as XD40127TC & XD40128TC) chase all threads prior to installing your new head studs to ensure you get proper thread engagement and accurate torque readings.
- 4 Ensure that a thread sealer is used on any studs that protrude into a water jacket.
- 5 Using a 3/16" allen key, install the studs into the block **HAND TIGHT!**
- 6 Proceed to install the cylinder heads and be sure to check for any binding or misalignment.
- 7 Lubricate the threads of the studs, nuts, and washers with assembly lubricant.
- 8 Install the washers and nuts onto the studs tightening the nuts hand tight.

- 9 Following the torque sequence below in three steps, tighten the nuts to 90ft lbs, 180ft lbs, and then 275ft lbs, and the inner row bolts to 25ft lbs.
- Tech Tip:** We recommend going over in sequence and double checking torque at 275ft lbs on the 1-10 studs, and proper torque on the inner row bolts.

TORQUE SEQUENCE

1ST PASS 90FT LBS → 2ND PASS 180FT LBS → 3RD PASS 275FT LBS → FINAL PASS 275FT LBS

