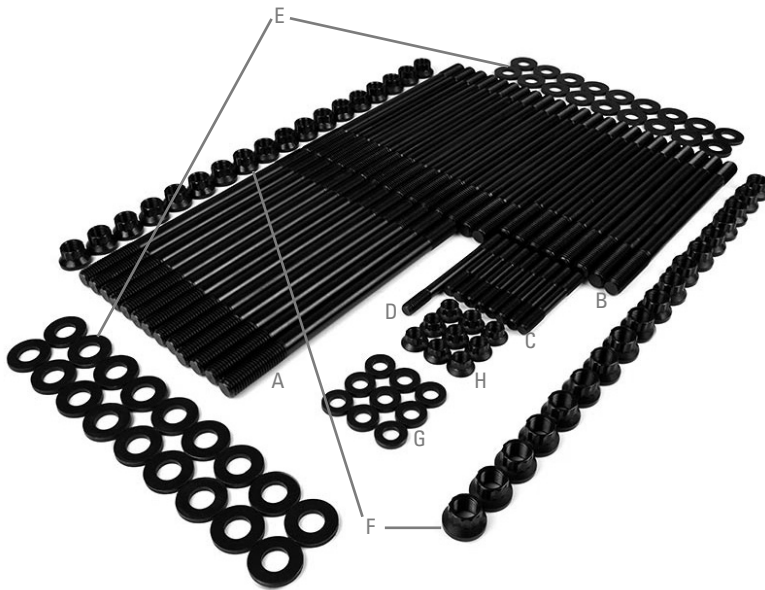




PART NO. XD3018HS

XDP X220 SERIES HEAD STUD KIT

INSTALLATION MANUAL



CODE	DESCRIPTION	QTY
A	Long Head Stud	28
B	Short Head Stud	8
C	M8 Stud	8
D	M8x1.25x3.7 (Driver side only)	1
E	12mm Washer	36
F	12mm Nut	36
G	8mm Washer	9
H	8mm Nut	9



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 XD40125TC & 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 5mm allen key install the M12 studs, and use a 3mm allen key to install the M8 studs into the block **HAND TIGHT!** NOTE: The shorter studs install along the exhaust manifold side of the cylinder head in positions 11, 13, 15, and 17.
- 6 Proceed to install the cylinder heads and be sure to check for any binding or misalignment. NOTE: Test fit valve covers to ensure proper clearance.
- 7 Lubricate the threads of the studs, nuts, and washers with assembly lubricant such as XD541 X-TRA Slick Engine & Fastener Assembly lubricant (Sold separately).

- 8 Following the torque sequence below torque the nuts in the following steps: Nuts 1-18 (M12) to 40ft lbs, Nuts 1-18 (M12) to 80ft lbs, Nuts 1-18 (M12) to 125ft lbs, and nuts 19-22/23 (M8) to 28ft lbs.

TORQUE SEQUENCE

1ST PASS 40FT LBS → 2ND PASS 80FT LBS → 3RD PASS 125FT LBS → FINAL PASS 125FT LBS

