



X3 Custom Age 625 Head Stud Kit 9mm-10mm

SKU(s): 800FC0010

INCLUDED PARTS

| |
|----------------------------------|
| (1) Custom Age 625 Head Stud Kit |
| -(8) 9-10mm Head Studs |
| -(8) 10mm Washers |
| -(8) 10mm Nuts |
| -Assembly Lube |

REQUIRED TOOLS

Torque Wrench

INSTALLATION STEPS:

Remove (1) factory head bolt and replace with (1) ARP 625 Head Stud 9-10mm. Apply supplied assembly lube to the top of the stud threads and both sides of the washer and nut. Install washer first, then thread nut onto the top of the stud - torque nut to **45 ft lbs**. Be very careful not to drop anything into the engine! **NOTE:** Do this process one at a time for all remaining head bolts. **Never loosen more than (1) head bolt without replacing and torquing with a stud.** This will ensure the cylinder head gasket does not lose its seal. Once all factory bolts have been replaced with studs, torque the head according to the "REPLACEMENT" pattern and torque steps below. When all studs have been torqued to the final value, re-torque to the final value (3) more times.

























NEW GASKET INSTALLATION:

NOTE: If the engine is disassembled and a new head gasket is being installed, see the "**NEW GASKET**" torque pattern and torque below.

Please refer to the shop manual for removal and installation and timing the camshafts.

- To ensure proper thread engagement and accurate torque, be sure all components are clean and free of debris.
- Use the supplied assembly lubricant on the top side of the stud and between the washer and nut.
- Hand tightens the stud until it lightly seats into the block.
- Install the washer and nut then torque as listed below.



| | | | | | | | | | | | | | | | | | |
|--|---|---|---|---|---|--|---|---|---|---|---|---|---|--|---|---|---|
| <p><u>REPLACEMENT Torque Procedure</u></p> <ol style="list-style-type: none">1. Initial 45 ft lb2. Final 65 ft lb confirm. 3 TIMES <p><u>NEW GASKET Torque procedure</u></p> <ol style="list-style-type: none">1. Initial 28 ft lb2. Intermediate 45 ft lb3. Final 65 ft lb confirm 3-TIMES | <p><u>Exhaust Side</u></p> <table><tr><td>8</td><td>1</td><td>4</td><td>5</td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td>7</td><td>2</td><td>3</td><td>6</td></tr><tr><td></td><td></td><td></td><td></td></tr></table> | 8 | 1 | 4 | 5 |  |  |  |  | 7 | 2 | 3 | 6 |  |  |  |  |
| 8 | 1 | 4 | 5 | | | | | | | | | | | | | | |
|  |  |  |  | | | | | | | | | | | | | | |
| 7 | 2 | 3 | 6 | | | | | | | | | | | | | | |
|  |  |  |  | | | | | | | | | | | | | | |

Thank you for choosing Evolution Powersports products. If you require further assistance, please call our Tech Support @ (715) 247-3862

Note: This product is exempt from the emission standards and related requirements of 40 C.F.R. § 1051 as provided by 40 C.F.R. § 1051.620, and California law [e.g., vehicle code §§ 27156 and 38391]. This product is sold only for use in connection with EPA certified, purpose-built, nonroad vehicles used solely for closed course, nonroad competition/racing and not used for any recreational purpose or on public highways or right of ways maintained by and open to the public. This product is sold only in connection with machines that do not fall under state and/or federal noise or emission standards/regulations. Purchasers who/that purchase this product represent and warrant that the product is purchased only in connection with EPA -certified, emission-regulations-exempt and noise-regulations-exempt competition/racing vehicles as interpreted under applicable state and/or federal law. Questions: Call Evolution Powersports at (715) 247-3862.