

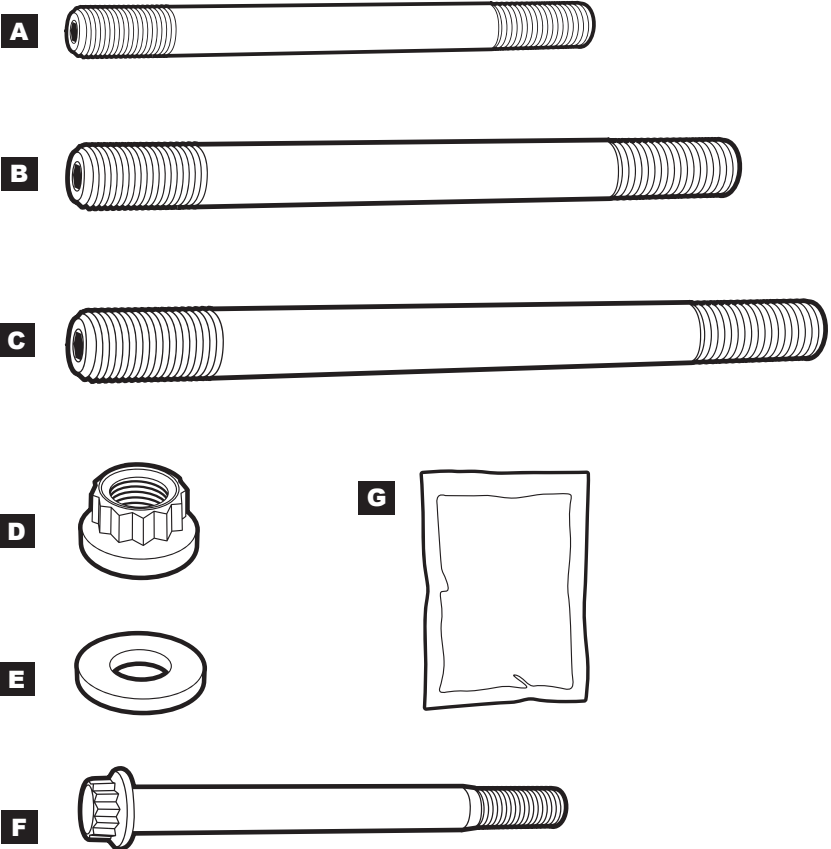
Dodge Cummins 5.9L 12V Head Stud Kit

(218034200)

Installation Guide

ATTENTION: We recommend the installation of this part be done by a trained professional 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.



CONTENTS

- A: 96mmL Head Stud (M12-1.25)(M12-1.75) - (6)
- B: 146mmL Head Stud (M12-1.25)(M12-1.75) - (14)
- C: 200mmL Head Stud (M12-1.25)(M12-1.75) - (6)
- D: M12-1.25 Flange Nut 21mmOD - requires 12pt 14mm socket - (26)
- E: M12 Flat Washer 22mmOD - (26)
- F: M8-1.25 x 75mmL Flange Bolt 15mmOD - requires 12pt 10mm socket - (6)
- G: Grease Pack - Assembly Lube - (1)

Inspect for damage or defects and clean all hardware prior to installation. Verify product part number matches your application.

Each rocker arm pedestal is required to be milled down to accommodate the washer and nut installation. Refer to instruction on **Fig.1** for machining details.

Clean all threads in the engine block and the rocker arm pedestal threads in the cylinder head. Use a bottoming thread chaser if necessary, to ensure thread engagement, and more accurate torque readings.

If the head studs protrude into a water jacket, use thread sealer to seal the block-end threads of the studs.

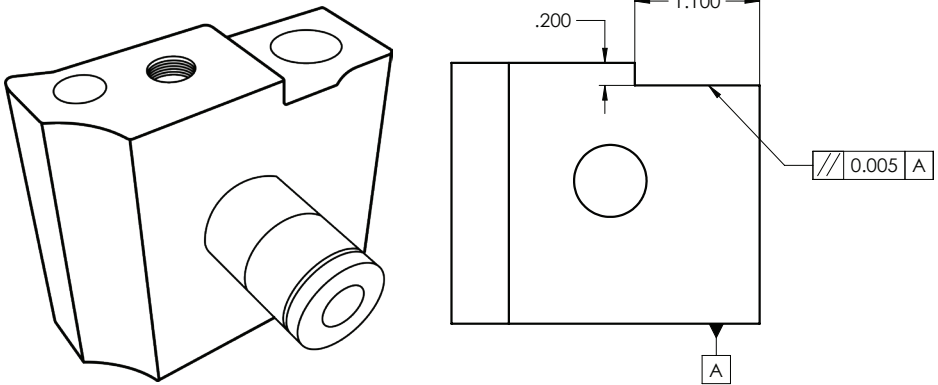


Fig.1

Mill down a 0.200"-deep, 1.100"-wide step on the top of each rocker arm pedestal as shown in the diagram. Make sure that the machined surface is parallel to the bottom surface of the pedestal.



*Install Studs into the block. Hand-tighten without tools (equivalent of 20-30 in. lbs.). The short M12 (A) studs in this kit are installed along the exhaust manifold side of the cylinder heads in the number 22, 14, 6, 3, 11 and 19 positions of the torque sequence. The long M12 (C) studs in this kit are installed along the intake manifold side of the cylinder heads in the number 21, 13, 5, 4, 12 and 20 positions of the torque sequence. **Fig.2***

Install cylinder head and check for proper alignment.

Verify consistent Stud height using a straight-edge ruler.

Install pushrods, make sure they are seated in the tappet

Thoroughly clean all six machined rocker arm pedestals. Install rocker arms to pedestals then onto the cylinder head per OEM instructions.

Install the M8 rocker arm pedestal bolts (F) into cylinder head, hand tighten for now.

Lubricate Stud (A, B, C) threads, Flange Nuts (D) and Flat Washers (E) with the fastener assembly lubricant (G) provided. Install the Flat Washers (E) and Flange Nuts (D) on to the Studs (A, B, C), hand tighten for now.

In three equal steps using the torque sequence, tighten M8 bolts (F) to a total spec of 25 ft lbs., and M12 nuts to 125 ft lbs.

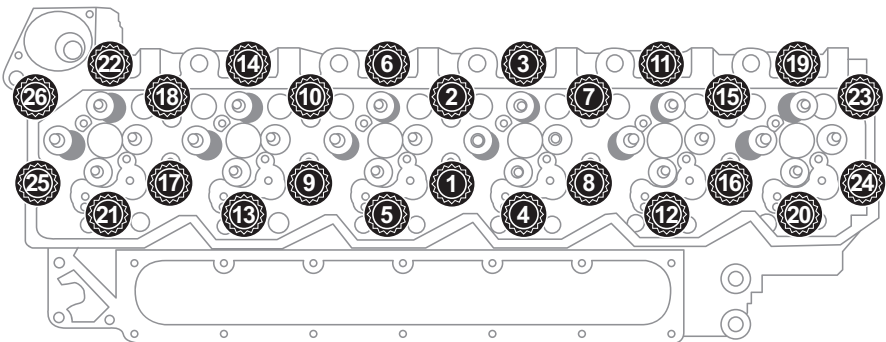


Fig.2

DISCLAIMER OF LIABILITY

Dodge 5.9L Head Stud Kit

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.

Note regarding emissions-related, non-E.O.-legal products: THESE PRODUCTS ARE LEGAL IN CALIFORNIA ONLY FOR RACING VEHICLES THAT MAY NEVER BE USED, OR REGISTERED OR LICENSED FOR HIGHWAY OR OFF-ROAD USE.

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