

# TIGHTENING METHOD

## BLT-MK-STUD-DUR-2.0L

### Main stud kit.

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## METHOD

ARP lubricant must be used on all threads and underneath face of nut and washer.

**BEFORE CRADLE IS INSTALLED: -**

1. Ensure threads in block & on stud are completely clean
2. Apply lubricant to stud threads & screw stud into block finger tight only.

**Once crank and cradle is installed, fit nut & washer then: -**

**STAGE 1---25 LB/FT**

**STAGE 2---Back off ½ turn**

**STAGE 3---25 LB/FT**

**STAGE 4---60 LB/FT**

**STAGE 5---Back off ¼ turn**

**STAGE 6---60 LB/FT**

**DURATEC MAIN STUD**  
**TIGHTENING SEQUENCE**

<b>8</b>	<b>4</b>	<b>1</b>	<b>5</b>	<b>9</b>
<b>7</b>	<b>3</b>	<b>2</b>	<b>6</b>	<b>10</b>

**DURATEC MAIN STUD**  
**REMOVAL SEQUENCE**

<b>3</b>	<b>7</b>	<b>10</b>	<b>6</b>	<b>2</b>
<b>4</b>	<b>8</b>	<b>9</b>	<b>5</b>	<b>1</b>