



## Gator Fasteners Competition Series Head Stud Kit

**Fits:** Dodge 1998.5-2018 5.9L & 6.7L Cummins Diesel • **Part Number:** HSK5967C-CS

### Parts Included:

- (26) Head Studs
- (26) Head Stud Nuts
- (26) Head Stud Washers
- (1) Assembly Lube

### Tools Needed:

- Socket Set
- Torque Wrench
- Thread Chaser
  - M12 x 1.75 (item # TCCM12x1.75)

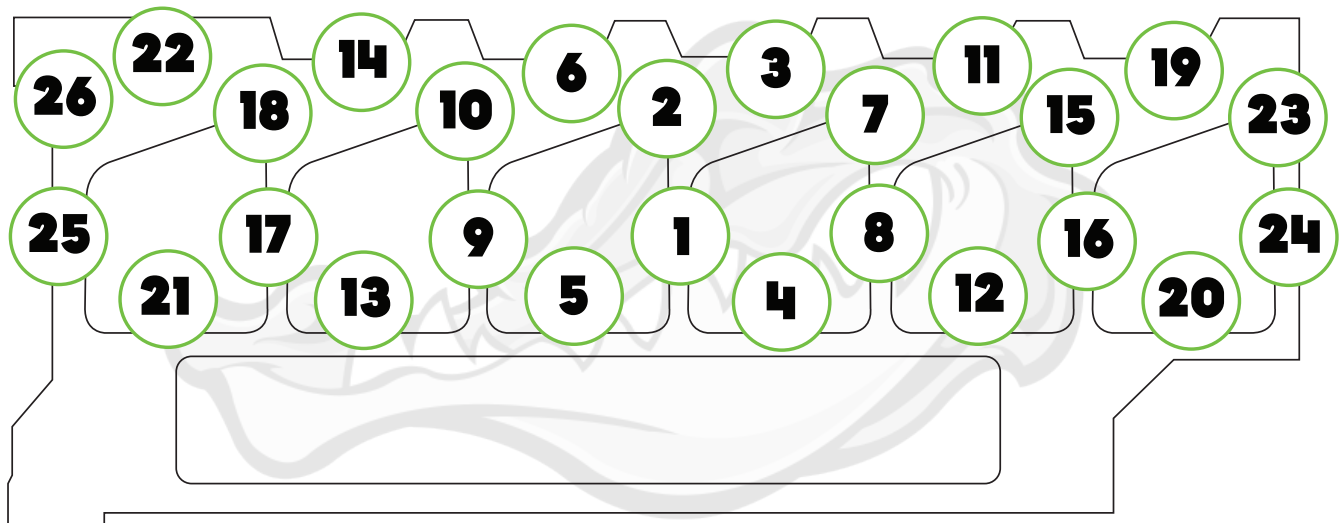
**Please Read Instructions before starting installation. If you don't feel confident that you can complete this task, do not start it and seek professional help!**

**Note: It will be necessary to machine the lower rocker arm cover at the No.24 bolt hole location in the torque sequence to facilitate installation of the lower rocker arm cover. (see Illustrations)**

- ☐ These instructions only cover the installation and torque sequence/technique of the Head Stud Kit.
- ☐ Clean and inspect the Studs, Washers, and Nuts to ensure they are free of shipping damage and obvious defects.
- ☐ Clean all threads in the block. It is recommended to use a Thread Chaser on the threads of the block so that they are completely clean to ensure proper thread engagement and accurate torque reading.
- ☐ Lubricate the threads of the Head Studs and install them into the block. Be sure to only screw them in **HAND TIGHT**. Note: The longer (6.625") studs in this kit install along the exhaust manifold side of the cylinder head in the #3, #6, #11, #14, #19 and #22 position of the factory torque sequence. Look across the tops of the head studs to see that they all appear to be the same length. If one is taller, remove the stud, clean the threads in the block and re-install.
- ☐ Install the head gaskets and cylinder heads; check for any misalignment.
- ☐ Place head stud washers onto the head studs. Then lubricate the top of head stud washers and head stud threads with assembly lube.
- ☐ Lubricate the mating face and threads of the Head Stud Nuts with Assembly Lube.

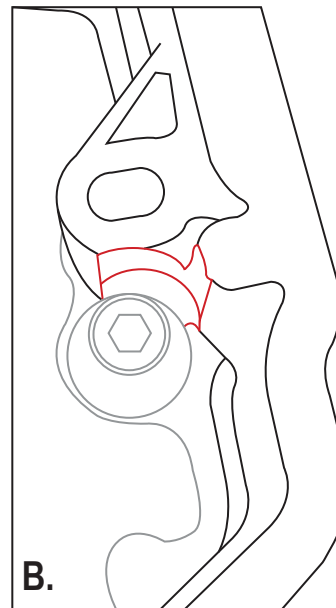
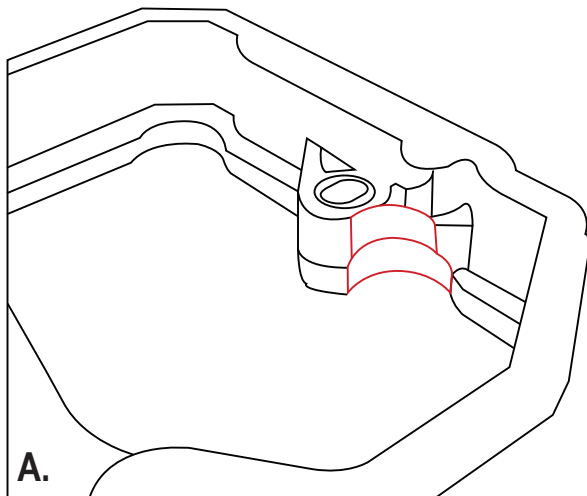
❑ Snug all Head Stud Nuts on Studs, then follow the torque sequence below in a 3-step process.

1. Tighten nuts 1 through 26 to 50 ft-lbs
2. Tighten nuts 1 through 26 to 100 ft-lbs
3. Tighten nuts 1 through 26 to 150 ft-lbs



- The amount of Head Stud threads showing above the Head Stud Nut should all be about the same. If one appears to have more thread, the stud is most likely not all the way in the head.

**A:** It will be necessary to machine the lower rocker arm cover at the #24 bolt hole location in the torque sequence to facilitate installation of the lower rocker arm cover.



**B.** Remove material as necessary to allow clearance for stud, nut and washer. Finish machine work should allow easy removal and installation of the head stud.

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