

Torque sequence.

1. Make sure all bolt holes threads are clean or chased and bolt holes are free of debris or coolant.
2. Apply a small amount fastener lube to the threads and screw the studs in with an allen wrench until they bottom out.
3. Apply a small amount of fastener lube to the bottom area of the flange nuts before installing.
4. Torque 25ft-lbs on all the M11 large studs in the sequence below.
5. Torque 50ft-lbs on all the M11 large studs in the sequence below.
6. Torque 70ft-lbs on all the M11 large studs in the sequence below.
7. Torque 25ft-lbs on all the small M8 studs on the last step after torquing all the M11 studs in the sequence below.

LS Head Bolt Tightening Sequence

