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INSTALLATION FOR SMALL BLOCK CHEVROLET ENGINE AND ACCESSORY FASTENER KITS

Pad No.: 534-9501, 534-9601, 534-9701, 534-9801

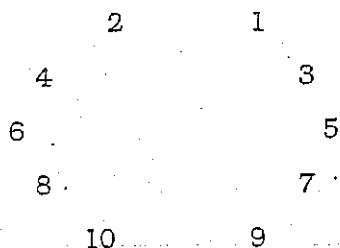
[1] Front Cover:

10 pieces 1/4-20 .515 bolts

10 pieces 1/4" washers

Preparation: Make sure that block surface is clean and dry where gasket is to be placed and that bolt threads are clean and free of debris. Use a 1/4-20 tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block, then carefully place the gasket in position. Lubricate the bolt threads, under the head and the washer with either a 30wt motor oil or ARP Moly Assembly Lubricant. Position cover so that dowels in block enter holes in cover without binding. Do not force cover over dowels so that cover flange or holes are distorted. While holding cover, install and snug tight bolts in an alternating manner. Torque bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) in sequence shown below:



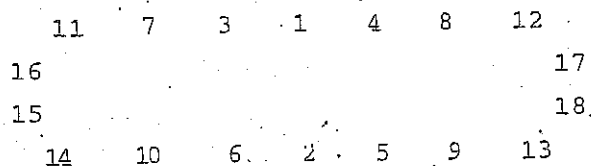
[2] Oil Pan:

14 pieces 1/4-20 x .515 bolts w/ washers

4 pieces 5/16-18 x .560 bolts w/ washers

Preparation: Make sure that block is clean and dry where the gasket is to be placed and that bolt holes are clean and free of debris. Use a tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block and carefully position the gasket. Position the front and rear oil pan seals and place a blot of silicone approximately 5/16" diameter where the seals meet the gasket. Carefully place the oil pan in position. Lubricate the bolt threads under the head and the washer with a 30wt. motor oil or ARP Moly Lube. Torque the 1/4" bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) and the 5/16" bolts to 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube) using the torque sequence below. NOTE: bolts 15-16-17-18 are 5/16".



[3] Fuel Pump:

2 pieces 1/4-20 x .515 bolts w/ washers

2 pieces 3/8-16 x 1.250 bolts w/ washers

Preparation: Make sure fuel pump and cylinder block are clean and dry where the gasket is to be placed and that holes are clean and free of debris. Use a tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block and carefully place the gasket in position. Lubricate the bolt threads, under the head and washers with a 30wt motor oil or ARP Moly Assembly Lubricant. Insert the fuel pump push rod and locate the fuel pump in proper position. While holding the fuel pump, insert the 3/8" bolts and snug tighten bolts in an alternating and even manner till pump is almost flush with block. Insert 1/4" bolts and snug. Snug 3/8" bolts. Torque 1/4" bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) and 3/8" bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[4] Motor Mounts:

6 pieces 3/8-16 x .750 bolt w/ washers

Preparation: Make sure bolt holes are clean and free of debris. Use a tap if necessary.

Installation: Lubricate the bolt threads, under the head and the washers with a 30wt motor oil or ARP Moly Assembly Lubricant. Position the motor mount. Insert the bolts and snug. Torque bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[5] Intake Manifold:

12 pieces 3/8-16 x 1.000 bolts w/ washers

Preparation: Make sure cylinder head surface is clean and dry where the gasket is to be placed and that bolt holes are clean and free of debris. Use a 3/8-16 tap if necessary. Clean block surface where rubber manifold seals are to be placed.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover manifold gasket surface of the cylinder heads and carefully place the gaskets. If rubber manifold end seals are preferred, put them in place or run a bead of silicone along the block approx. 1/4" diameter (the rubber end seals have a tendency to push out). Carefully place the manifold in position. Lubricate the bolt threads, under the head and the washers with a 30wt. motor oil or ARP Moly Assembly Lubricant. Run the bolts in an alternating manner. Torque all the bolts to 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube) using the sequence shown below. Then torque the bolts to the final torque of 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube) using the same sequence.

12	11	4	1	5	6
10	9	3	2	7	8

[6] Water Pump.

4 pieces 3/8-16 x 2.000 bolts w/ washers
1 piece 3/8-16 x 2.500 bolts w/ washer

Preparation: Make sure cylinder block surface and water pump are clean and dry where gasket is to be placed and that bolt holes are clean and free of debris. Use a tap if necessary.

Installation: If you have a short neck water pump you will only need the 4 short bolts. If you have a long neck water pump, you will need 1 long bolt and 3 short bolts. Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the cylinder block and carefully place the gaskets in position. Lubricate the bolt threads, under the head and the washers. Hold the water pump in position and tighten the bolts till snug. Torque the bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[7] Thermostat Housing:

2 pieces 3/8-16 x 1.000 bolt w/ washers
1 piece 3/8-16 x 2.000 bolt w/ washer

Preparation: Make sure intake manifold and thermostat housing surfaces are clean and dry where gasket is to be placed and that bolt holes are clean and free of debris. Use a tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the intake manifold and carefully place the gasket in position. If you have a standard thermostat housing you will only use the 2 short bolts. If you have an offset thermostat housing, you will need 1 long bolt and 1 short bolt. Lubricate the bolt threads, under the head and the washers. Hold the thermostat housing in position and tighten the bolts till snug. Torque the bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[8] Coil Bracket:

2 pieces 5/16-18 x .560 bolt w/ washers

Preparation: Ensure that bolt holes are clean and free of debris. Using a tap is not recommended unless absolutely necessary.

Installation: Lubricate the bolt threads, under the head and the washers using a 30wt motor oil or ARP Moly Assembly Lubricant. Locate coil and coil bracket into position and tighten bolts till snug. Torque bolts to 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube).

[9] Distributor Bracket

1 piece of each 3/8" stud, nut & washer

Preparation: Ensure that bolt holes are clean and free of debris. Using a tap is not recommended unless absolutely necessary.

Installation: The stud should be capable of installing into the manifold by hand. If not, it will be necessary to double nut the stud to install it. Use a thread locking compound to prevent the stud from backing out of the manifold. Screw the stud into the manifold. Lubricate the inside of the nut and washer. After locating distributor and distributor bracket, place the washer and nut on the stud and lighten with a long end wrench to approx. 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[10] Valve Covers:

8 pieces 1/4-20 x .515 bolt w/ washers

Preparation: Make sure that cylinder head and valve cover surfaces are clean and dry where gasket is to be placed and that bolt threads are clean and free of debris. Use a 1/4-20 tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket area of the valve covers and carefully place the gaskets in position. Lubricate the bolt threads, under the head and the washers. Place the valve covers on the cylinder heads and tighten the bolts till snug. Torque the bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) using the sequence below: (Note: These bolts are for stamped steel valve covers. If you are using cast aluminum covers, ARP has a separate valve cover bolt kit that has a longer bolt. We also make studs for both applications.)

1	2
3	4

[11] Alternator Bracket:

1 piece 5/16-18 x .750 bolt with washer
2 pieces 3/8-16 x .750 bolt with washers

Preparation: Make sure that bolt holes are clean and free of debris. Use a tap if necessary.

Installation: Lubricate the bolt threads, under the head and the washers. Place bracket in position and install 3/8" bolts. Tighten till snug. Torque 3/8" bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube). Insert 5/16" bolt into alternator and adjust so proper tension is on belt. Tighten 5/16" bolt to approx. 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube).

[12] Exhaust Headers:

12 pieces 3/8-16 x .750 bolts w/ washers

Preparation: Make sure that cylinder head and exhaust headers are clean and dry where gasket is to be placed and that bolt holes are clean and free of debris. Use a tap if necessary.

Installation: Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket header and carefully place gasket into position. Lubricate the bolt threads under the head and the washers. Position the exhaust header and insert 2 bolts at opposite ends. Insert remaining bolts and tighten till snug. Torque bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).