

installation instructions

Important Installation Notes:

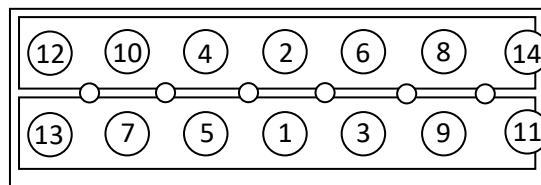
After unpacking the ProSeries stud bolts, inspect all hardware prior to installation. Look for obvious defects or shipping damage. Please call +49 34901/5970-16 with any questions or issues.

Before mounting, compare the supplied bolts with the stock screws, paying particular attention to the thread type end length of the bolts.

Check the existing threads inside the engine block for damage. To ensure proper thread engagement and accurate torque readings, make sure that all threads are free from remnant sealer, lubricant and debris. Check the flatness and surface finish of the engine block and cylinder head deck to avoid gasket failure.

1. Insert the stud bolts into the engine block and tighten them with a 5mm hexagon socket on the drive provided at the head of the stud bolt with a torque of 15Nm.
2. If the stud bolts are to remain permanently installed in the engine block, they can be used with screw locking. (not included)
3. **Attention!** Before final mounting of ProSeries nuts and washer all contact surfaces must be completely wetted with the supplied special ProSeries lubricant.
If this will be not considered the applied tightening torque is falsified and the resulting clamping force is reduced. Under certain circumstances, this can also inevitably lead to the bolts breaking/shearing off.
4. **Important**, tighten the nuts in three (3) equal steps in the factory sequence. For the last pass, the torque shown in the table below must be observed.
5. The ProSeries studs and nuts can always be reused. When re-tightening or reassembling, please always ensure that all contact surfaces are wetted with the special ProSeries lubricant. Please contact your ProSeries dealer if you have any further question.

Torque Procedure:



This Set	Thread Type	Torque
	M9x1.25	1. 25 Nm 2. 45 Nm 3. 65 Nm
	M10x1.25	1. 30 Nm 2. 60 Nm 3. 85 Nm
	M11x1.25	1. 40 Nm 2. 80 Nm 3. 115 Nm
	M12x1.25	1. 45 Nm 2. 90 Nm 3. 130 Nm