



Golden Eagle Mfg. “HD” Head Stud Install

Thank you for your purchase of Golden Eagle Mfg. products for your high performance needs. You now own one of the best products on the market, all 100% made in the *USA!* We are very confident you will be more than pleased with your purchase. If you ever experience any problems, have any concerns or just want to give some advice, we would love to hear from you.

(909) 592 – 4311 ext. 102 or e-mail sales@goldeneaglemfg.com

DO NOT SMOKE OR HAVE OPEN FLAME

When doing the head stud!! Perform this install in a well ventilated area!

! WARNING ! We strongly suggest having a trained technician perform the head stud install. Do not attempt to perform this installation procedure if you are not very familiar with how the engine system works. Incorrect disassembly or re-assembly of the engine system could lead to extensive engine damage, fire or personal injury! Always have a shop manual on hand for reference when performing the head stud install.

The “HD” head studs are manufactured from the highest quality 4340 material heat treated to a 180 KSI min. These studs have a glass bead finish that allows for a more accurate torque when compared to studs that are black oxide coated. These studs were designed to handle the abuse of turbo, all-motor, nitrous street and full race applications. Follow the directions below. **OVERTIGHTENING THE STUDS WILL CAUSE THEM TO LOOSE THEIR INTEGRITY AND WILL NOT PROVIDE THE PROPER CLAMPING LOAD REQUIRED. FOLLOW THE DIRECTION FOR TIGHTNING AS DIRECTED BELOW. IMPROPER INSTALLATION CAN CAUSE PREMATURE HEAD GASKET FAILURE.**

Kit includes ten studs, ten precision ground hardened washers, ten 12pt. nuts and a red lube packet. A properly calibrated torque wrench should be used.

Make sure the threads in the block are clean and free from debris. Running a cleaning tap through the threads is always a good idea.

Remove the studs from the package. Place them with the dog point going into the block. Tighten the studs to 10 ft. lbs. into the block. Replace the head gasket and head. Cover the washers, nuts and studs using the red lube supplied in the kit. Make sure that everything has lube on it. Place the washers over the studs and then the 12pt. nuts. Follow the factory torque sequence using the torque values below:

1st step, torque the nuts to **25 ft. lbs.**

2nd step, torque the nuts to **50 ft. lbs.**

While still going in the factory torque sequence, loosen each nut *one at a time* ½ turn then torque back to **50 ft. lbs.** Repeat this step three (3) times. This will mate the threads and give more accurate torque reading upon final torque.

Last step, torque to **72 ft. lbs.**

Now you are ready to hold some power. If you have any questions or concerns, please let us know anytime at (909) 592 – 4311 or sales@goldeneaglemfg.com

Disclaimer – Golden Eagle Mfg. will not be responsible for blown head gaskets while using these head studs. Golden Eagle Mfg. will not be responsible for any damages related, directly or indirectly, to the installation and use of these studs. Since this is a high performance product, there is NO expressed warranty and buyer is to be responsible for the proper installation and use of this product. Product cannot be returned once the studs have been installed. Any return must be sent through an authorized Golden Eagle Mfg. distributor or an RMA (Returned Merchandise Authorization) must be obtained in writing from Golden Eagle Mfg. directly BEFORE any return will be accepted.

Again, we thank you for your purchase and we are always here for your input.

Golden Eagle Mfg.

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