



Mazda MZR Head Stud Kit (Custom Age 625 Plus) Installation Manual

Please read all instructions thoroughly before starting installation.

1. Remove existing head bolts, head, and install new head gasket.
2. We recommend that you use a bottoming tap to prepare the threads in the block and be sure to get all oil, fuel, dirt, ect. out of the hole with compressed air and brake clean (don't forget eye protection)
3. Install the head stud into the locations by hand (put a small dab of engine oil onto the portion of the stud that will thread into the engine block itself). Only tighten the studs finger-tight. Lower the head down over the studs and onto the gasket.
4. Apply the international compound #2 assembly lubricant onto the upper threads of the stud and on the nut side of the provided washer and bearing surface of the nut. Torque the nuts on the studs in sequence as recommended in your owners manual to **35 ft-lbs**. After all have been torqued, loosen them, repeat the torque sequence to **35 ft-lbs**, loosen them, repeat the torque sequence to **35 ft-lbs**, loosen them, then torque in a three step sequence to a final torque value of **70 ft-lbs** as follows. The sequence is as follows, **25 ft-lbs, 45 ft-lbs**, then to the final step of **70 ft-lbs**.

Note: It is a lot of work to torque, loosen, torque, loosen, torque, loosen and torque again, but it is WELL WORTH IT in the long run. Doing this helps seat the threads and will give you the VERY BEST RESULTS. Take the time to do it right the first time so you never have to do it again!

Call us with any questions.

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