



## Installation Instructions - Ultimate Duty H11 Head Stud Kit

Applications: Subaru WRX / STi EJ20  
Subaru WRX / STi EJ25

### General Installation & Maintenance

- Ensure that the studs, nuts are coated with oil at all times. Motor, machining, or almost any oil can be used. Do not wash studs with an aqueous solution. Only a solvent based cleaner must be used for washing.
- Make sure threads in the block are clean and re-tap **ONLY** if necessary. Use cutting oil when chasing threads.
- Coat the studs that will be threaded into the block with a thin coat of engine oil. Thread the studs into the block **hand tight only**. You can use an Allen key to “snug” the studs.
- Install the cylinder heads and check to ensure all studs are properly aligned. Always use the factory dowels.
- Once the head is properly aligned, generously apply included assembly lubricant on top of washers, threads of the stud, threads of the nut, and bottom of the nut. If you have washers with a chamfer in them, the chamfer side faces down. If you have flat washers, the square edge on the perimeter faces down. Hand tighten the nuts first.
- Use the diagram below and follow the torque sequence of the head bolts. Torque the nuts to 100 ft/lbs. in three steps (i.e. 30, 60, then 100 ft/lbs. following torque sequence).

