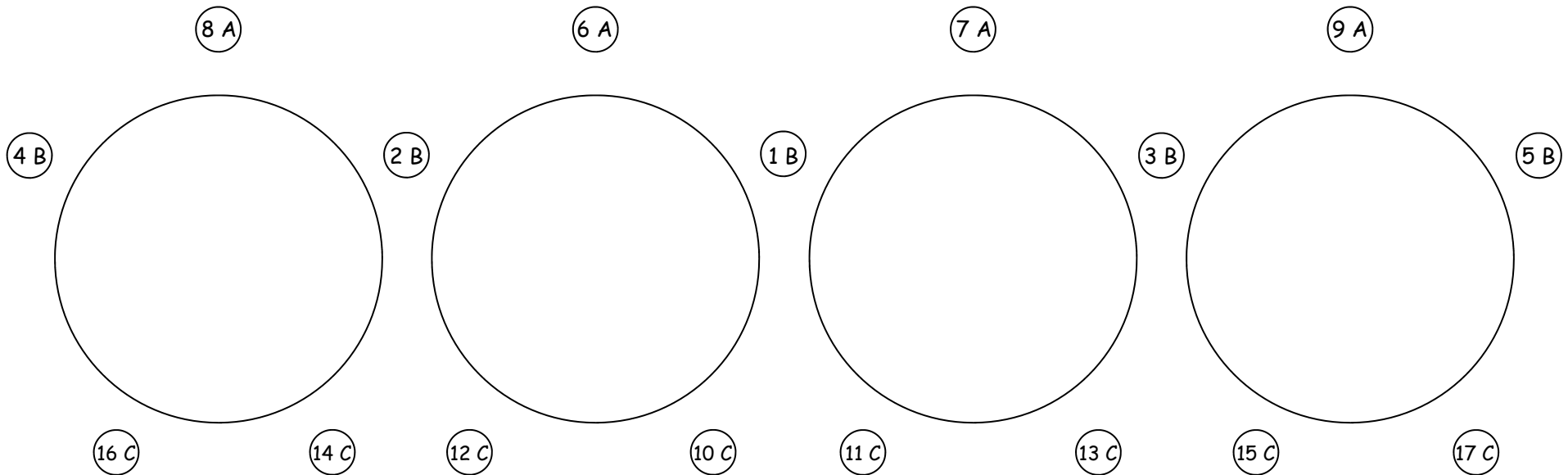


AJPE 426 HEMI Torque Pattern: 9/16 Std Steel Studs

09/18/07



Final Torques:

<u>A Row</u> (Inner Head Studs)	7/16" Std Steel	<u>60 lbs.</u>
<u>B Row</u>	9/16" Std Steel	<u>140 lbs.</u>
<u>C Row</u> (Bottom Row)	9/16" Std Steel	<u>110 lbs.</u>

Torque Order:

- (1) Work from Inside Out.
- (2) Torque "B" row first, "A" row second, "C" row third.

Torque Method:

- (1) "B" row: Impact wrench first, then torque to 140 lbs.
- (2) "A" row: Torque to 60 lbs.
- (3) "C" row: Impact gun first, then torque to 110 lbs.

Lube:

Peanut Butter *aka* Detroit Diesel International Compound #2.
If unavailable, ARP moly lube may be used instead.