



Jge Long block studs and coopers rings fitting guide.

Jge have their own type of Cosworth Yb long block studs that are manufactured by ARP. They are slightly longer than other types to allow deeper thread cutting in the base of the engine block. Our racing engines all use a 3 layer mls gasket with Coopers rings.

Fitting procedure: Ensure all threads are clean and free of oil.

Use a medium strength Loctite on the lower thread and torque into the block 40ft/lbs.

Fit the blue stud seals into the block using a small amount of silicon sealer under the seal to help seal the water jacket.

Coat the upper threads with ARP lube and fit the Head gasket and coopers rings. The rings are fitted with the fold on the lower side.

Fit the cylinder head.

Place the washers over the studs adding an extra washer to both of the rear studs. Coat the mating faces of the 12 point nuts with ARP lube and tighten hand tight only working from the centre studs outwards in spiral sequence. As illustrated below.

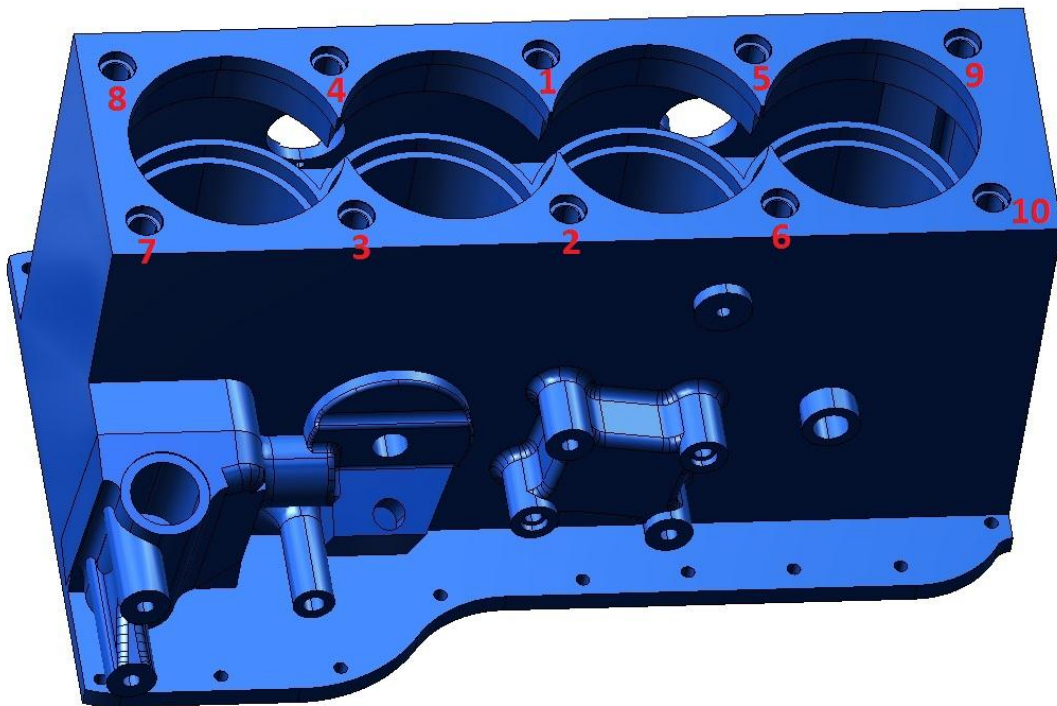
Tighten the head down in 3 stages @ 30ft/lbs-60ft/lbs-90ft/lbs

Leave the engine overnight to settle.

Slacken each nut in sequence 90 degrees and retorque 90 ft/lbs .

Your engine is now ready for action.

Note. Some engine builders like to repeat this after the engine has been run up to normal operating temperature. Although this is not totally necessary it is a wise precaution.



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