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Yamaha Girdle Kit Instructions

Kit Includes:

6 - stainless studs
6 - 10mm flat washers
6 - 10mm acorn nuts

- 1) Clean studs and nuts with a solvent, brake cleaner, or contact cleaner.
- 2) Apply anti-seize (preferred) or grease to the threads on both ends of the studs.
- 3) Check the threads on the studs by installing a nut onto each one of them. Make sure that they go on easily and then back off. Remove nuts from studs.
- 4) Install studs with the long ends of the threads into cases, make sure the studs go all of the way in. The studs should all be approximately the same height when sticking out of the cases. It may be necessary to clean the lock-tite from the case holes applied by the factory. Do not bottom the 10mm acorn nut to install the studs! It is best to use a stud tool. The studs do not need to be torqued into the cases, they should just be tightened until they stop.
- 5) The head can now be installed, hand tightening all head bolts and girdle nuts.
- 6) First torque the head bolts to 15ft/lbs, then torque the girdle nuts to 15ft/lbs. Then torque the head bolts to 18ft/lbs and the girdle nuts to 18ft/lbs. Torque the girdle nuts to 23ft/lbs.
- 7) Now, re-torque all head bolts to 18ft/lbs and the girdle nuts to 23ft/lbs. Periodically re-torque after initial use.

**ALWAYS TORQUE BOLTS WORKING FROM THE MIDDLE OUT
AND IN A CRISS-CROSS PATTERN**