

Weistec M1 13/M1 13K ENGINE

Head Stud Installation Guide



- 2003-2006 E55 AMG
- 2006 CLS55 AMG
- 2003-2008 SL55 AMG
- 2002-2006 S55 AMG
- 2002-2004 CL55 AMG
- 2004-2009 G55 AMG

WEISTEC M113/M113K Head Studs

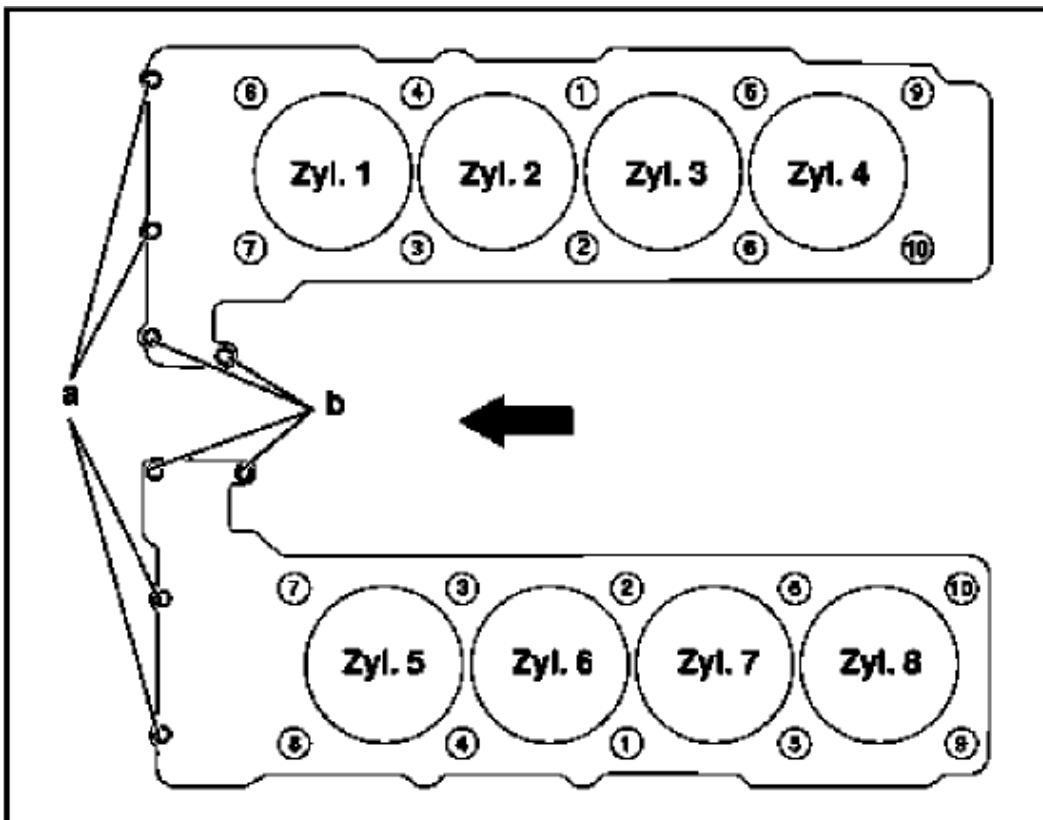
Thank you for your purchase of the Weistec M113/M113K Head Studs for the Mercedes AMG 55 with the 5.5L motor. Please follow all directions, and keep a clean work space when commencing installation.

Tools Required

- Moly Lube Lubricant
- High Temp Black RTV Silicone
- 3/16" Hex Key
- 3/8" Drive Ratchet
- 3/8" Drive, 1/2", 12 point socket
- 3/8" Torque Wrench
- 3/8" Drive Ratchet

I. Head Stud Install

1. Prepare for installation by removing cylinder head and preparing block deck surface as if you were changing a head gasket.
2. Apply Moly Lube thread lubricant to ends of the studs
3. Install Studs into block:
 - a. By hand, start threading all studs into the engine block.
 - b. Using a 3/16" hex key, tighten all studs until they bottom out in the block. **DO NOT OVERTIGHTEN THE STUDS AT THIS POINT. HAND TIGHT ONLY!**
4. Slide head gaskets over studs and dowel sleeves.
5. Slide engine head over studs being careful to not damage stud threads
6. With a 1/2", 12 point socket, hand thread each nut onto its stud, being careful not to drop the nut into the head or strip the stud.
7. Lightly hand tighten each nut down onto the washers, to not torque at this step.
8. In steps 9 through 11, torque down all the nuts in the "in to out" pattern shown below



9. Stage 1: Using a torque wrench, torque all nuts to 50 ft-lbs
10. Stage 2: Using a torque wrench, torque all nuts to 75 ft-lbs
11. Stage 3: Using a torque wrench, torque all nuts to 90 ft-lbs

NOTES: