



## Installation Instructions for KPMI Part No: **30-33750** HONDA® • TRX 400X/EX 1999-2014 & XR400R 1996-2004 Black Diamond™ Cylinder Studs

### A) 30-33750 Kit Includes

| Quantity | Size Info  | Size Info      | Description | Remarks             |
|----------|------------|----------------|-------------|---------------------|
| 1-Pc     | 5.000"     | Overall Length | Stud        | Intake Side         |
| 1-Pc     | 4.000"     | Overall Length | Stud        | Exhaust Side        |
| 2-Pcs    | 3.400"     | Overall Length | Stud        | Left and Right Side |
| 4-Pcs    | M10 x 1.25 | 12-Point       | Nut         | 12mm socket         |

### B) Instructions

1. It is imperative that the threads this stud kit will be installed into, are intact, free of burrs and are properly formed. Preferably use a M10 x 1.25 Roll Tap and re-tap each internal thread. By using a Roll Tap you are reforming the thread vs cutting material away, which produces a stronger thread. In most cases you will not need to clean up the threads if all threads are properly formed, intact and a stud can screw in by hand uninterrupted. In the event threads are worn or badly deformed or missing, proper repair will be necessary beyond re-tapping, before installing this stud kit.
2. Identify the studs listed above and their intended locations listed in the Remarks Section. If the stud has different length threads on each end, apply motor oil to the **long** threads of each stud (if the threads are equal length, apply oil to either end). Thread the lubricated end by hand into the location indicated as per above. Screw the stud all the way in by hand and leave loose. Repeat this procedure for each stud.
3. Once all studs are installed into the case and the cylinder head is in place as per the OEM instructions, Install the OEM washers and apply motor oil to the exposed stud threads. Thread the nuts on by hand till tight.
4. Using a crisscross torque-sequence for all steps, initially torque to 20-ft/lbs. Set the final torque at 35-ft/lbs. Note, this a wet torque recommendation. Do not exceed 35-ft/lbs. for any reason. This is a 10mm stud being threaded into aluminum and the clamping force being achieved with these Heavy Duty KPMI® Black Diamond™ Studs will be an increase of over 1600 lbs. from stock.

Packaged By: \_\_\_\_\_

Date: \_\_\_\_\_