



Installation Instructions for KPMI Part No: 30-34030 HONDA® • CRF™ 450R/RX/WE • 2017-2025 Black Diamond™ Cylinder Studs

A) 30-34030 Kit Includes

Quantity	Size Info	Size Info	Description	Remarks
4-Pcs	6.5"	Overall Length	Stud	-
4-Pcs	0.745" OD	0.405" ID	Washer	-
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 and 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 each stud location. 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 KPMI 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 25-ft/lbs. Set the final torque at 40-ft/lbs. Note, this a wet torque recommendation. Do not exceed 40-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 2500 lbs. from stock.

Packaged By: _____

Date: _____