

## HOW TO: INSTALL CAP-STYLE ROD BOLTS

Replace your original connecting rod cap screws with these ARP products for enhanced durability and improved strength. Use whenever cap screw-style bolts are used for rod cap retention.

### TECH TIP

Be sure the torque spec used when re-sizing a rod **and** final engine assembly are the **same**. Communicate with your machinist! Use a stretch gauge for both functions, if possible.

**NOTE:** The only way to know if a bolt is ready to fail is if it has permanently yielded .001" or more. See page 27.



1. Clean and inspect all hardware for obvious damage. If necessary, chase or re-tap con rod threads to ensure proper thread engagement and accurate torque readings.

2. Position washer under bolt head to ensure it clears the under head radius. **NOTE:** Improper installation will cause premature bolt failure.



3. Assemble cap to rod, then lubricate with ARP Moly lube and install bolt & washer. Measure pre-torqued bolt length. You should keep a log of the original free standing length. A sample is on page 28.

4. Using a stretch gauge or micrometer to measure fastener stretch, torque rod bolt until recommended bolt stretch is achieved. A rod bolt stretch chart is on page 25.

5. Once properly preloaded, have the rods resized before assembling them to the pistons, then install in engine using the prescribed bolt-stretch method.

## HOW TO: INSTALL OEM-STYLE ROD BOLTS

Improved reliability and optimum strength are the main attributes of ARP's replacement rod bolts. These are the finest fasteners available today, and are recommended for all high performance applications.

### TECH TIP

Be sure the torque spec used when re-sizing a rod **and** final engine assembly are the **same**. Communicate with your machinist! Use a stretch gauge for both functions, if possible.



1. Inspect rods to ensure there is adequate chamfer to clear radius under heads, then install bolts after inspecting for damaged hardware.

2. Reinstall the rod cap, then measure bolt length using a micrometer (free standing length).



3. Lubricate rod nuts with ARP Moly lube, torque nuts to achieve recommended bolt stretch. A rod bolt stretch chart is located on page 25.

4. With proper preload applied, have rods resized. This procedure is recommended any time rod bolts are replaced.

5. Install rod and piston assemblies in engine using the prescribed bolt stretch method or by following recommended torque values.