



1863 Eastman Ave.
Ventura, Ca. 93003
www.arp-bolts.com

Part Number: 200-6209 & 200-6219

Application: GEN-REPL. FOR STEEL RODS 1.600 U.H.L.

Cap Screw with Washer - Rod Bolt Installation

- [1] Please check the part-number(s) for your application against the part-number(s) listed on the instruction sheet.
- [2] Use **ARP Ultra-Torque Fastener Assembly Lubricant** to lubricate the threads of the bolt and the under head of the bolt.
- [3] Position the chamfered side of the washer on the bolt so it faces the bolt head. This is done to clear the radius on the under head of the bolt. **Note:** Improper installation of the washer will cause premature bolt failure.
- [4] Install the bolts in the rod and tighten them hand tight.
- [5] ARP recommends using the **STRETCH METHOD** when tightening the bolts. Following the instructions for using a stretch gauge, **Stretch the bolts to .0055 - .0060 .**
- [6] If you do not have a stretch gauge, torque the bolts to **55 ft-lbs** using **ARP Ultra-Torque Fastener Assembly Lubricant**.
- [7] The connecting rods should always be re-sized after new rod bolts are installed.
- [8] A log should be kept on the original non-torqued length of each bolt. Bolts that have any permanent deformation or have increased in non-torqued length by more than .001 in. should be replaced.

If you have any questions or need additional information please contact us at **(805) 339-2200** or by **FAX (805) 650-0742**