



1863 Eastman Ave.
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Part Number: 203-6302

Application: TOYOTA 2.0L (4U-GSE) DOHC 4-CYL

Cap Screw without 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] Make sure there is an adequate chamfer around the bolt hole on the connecting rod cap to clear the radius under the head of the bolt.
- [3] Use **ARP Ultra-Torque Fastener Assembly Lubricant** to lubricate the threads of the bolt and the under head of the bolt. Then install the bolts and tighten them hand tight.
- [4] ARP recommends using the **STRETCH METHOD** to tighten the rod bolts whenever possible. When applicable, **stretch the bolts to .0065 - .0070**.
Please Note: The OEM connecting rods on this application have blind holes and the stretch method cannot be used. **See step 5.**
- [5] Torque the bolts to 60 ft-lbs using **ARP Ultra-Torque Fastener Assembly Lubricant**.
- [6] The connecting rods should always be re-sized after new rod bolts are installed.
- [7] 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**