



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

Part Number: 235-6401 & 235-6421

Application: CHEVY 454-502 CID V8 (7/16 dia)

Press Fit - Rod Bolt Installation

- [1] Please check the part-number(s) for your application against the part-number(s) listed on the instruction sheet.
- [2] Due to inconsistencies with the spot face on the factory rod cap, the nuts may interfere with the radius on the cap. ARP recommends resurfacing the spot face on the factory rod cap so the nuts will sit flat on the cap surface.
- [3] Make sure there is an adequate chamfer around the top of the connecting rod bolt hole to clear the radius under the head of the bolt. Then press the bolts into the connecting rods and install the rod caps.
- [4] Use **ARP Ultra-Torque Fastener Assembly Lubricant** to lubricate the threads of the bolt and the nut face. Then install the nuts onto the bolts 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 .0070 - .0075 .**
- [6] If you do not have a stretch gauge, torque the bolts to 85 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**