



TITANIUM

ULTRA-TORQUE

Thank you for purchasing Arrow Connecting Rods. Great care has been taken to manufacture and deliver the ultimate Connecting Rod for each and every one of our clients.

All areas of the rod have been rumbled and peened to create a compressed hardened layer. Removal of this layer will cause a stress concentration, possibly leading to failure. We therefore recommend that you don't attempt to modify or polish rods.

Connecting Rod Bolt Installation Instructions

To achieve correct bolt pre-load and to ensure big end bore roundness after re-assembly.

- Ensure mating faces are wiped clean
- Remove any old grease from threads of bolts and rod.
- Apply ARP 'ultra-torque' assembly lubricant to seating face of bolt and threads of bolt and rod.
- Assemble cap to rod
- Torque to 15ft/lbs (20Nm).
- Tighten each bolt to recommended stretch value i.e. Loosen first bolt, zero stretch gauge, tighten until correct stretch is achieved. Loosen second bolt, zero stretch gauge, tighten until correct stretch is achieved.

| BOLT LETTER | PART No. | MATERIAL | THREAD | UHL | STRETCH |
|-------------|----------------|----------|------------|--------|-------------------|
| a | 3AG1.500-10U | ARP 625+ | 5/16" UNJF | 1.500" | 0.0055" - 0.0060" |
| b | 4AJ1.600-10SLU | ARP 625+ | 3/8" UNJF | 1.600" | 0.0065" - 0.0070" |
| c | 5AP1.750-10SLU | ARP 625+ | 7/16" UNJF | 1.750" | 0.0065" - 0.0070" |
| d | 3AG1.505-2U | ARP 2000 | 5/16" UNJF | 1.505" | 0.0050" - 0.0055" |
| e | 4AJ1.500-2SU | ARP 2000 | 3/8" UNJF | 1.500" | 0.0055" - 0.0060" |
| f | 4AJ1.750-2SU | ARP 2000 | 3/8" UNJF | 1.750" | 0.0065" - 0.0070" |
| g | 4AP1.550-2CL | ARP 2000 | 7/16" UNJF | 1.550" | 0.0050" - 0.0055" |
| h | AR502-2SLU | ARP 2000 | 7/16" UNJF | 1.725" | 0.0065" - 0.0070" |
| j | AR301-2W | ARP 2000 | 5/16" UNJF | 2.125" | 0.0070" - 0.0075" |
| k | 3AG1.500-7U | ARP 3.5 | 5/16" UNJF | 1.500" | 0.0055" - 0.0060" |
| m | 3AG1.260-10U | ARP 625+ | 5/16" UNJF | 1.260" | 0.0050" - 0.0055" |
| n | 4AJ1.600-2SU | ARP 2000 | 3/8" UNJF | 1.600" | 0.0055" - 0.0060" |
| t | 4AJ1.500-10SU | ARP 625+ | 3/8" UNJF | 1.500" | 0.0060" - 0.0065" |
| u | 4AJ1.600-7SLU | ARP 3.5 | 3/8" UNJF | 1.600" | 0.0055" - 0.0060" |
| v | 4AJ1.700-2U | ARP 2000 | 3/8" UNJF | 1.700" | 0.0065" - 0.0070" |
| w | 2AL1.400-7U | ARP 3.5 | 1/4" UNJF | 1.400" | 0.0045" - 0.0050" |
| x | M10AM1.575-7U | MP35N | MJ10 x 1.0 | 1.575" | 0.0055" - 0.0060" |
| y | M10AI1.950-10U | ARP 625+ | MJ9 x 1.0 | 1.950" | 0.0090" - 0.0095" |
| aa | M10AI1.440-2U | ARP 2000 | MJ9 x 0.75 | 1.440" | 0.0050" - 0.0055" |

