



941-621-8143

American Material | American Labor | American Pride

## INSTALLATION INSTRUCTIONS FOR ALUMINUM CONNECTING RODS

### 1. Correct Clearances

- A. Use plastigage or micrometers to obtain a minimum of .0025" bearing clearance.
- B. Side clearance for each pair of rods should be .020-.060" for rods sharing a journal.
- C. Side clearance for single rod per rod journal should be between .012"-.035"
- D. Minimum clearance for wrist pins should be .0007"

### 2. Lubricants and Torquing

- A. Clean and check rods well for debris. Apply 50W oil to bolts, then torque using the specifications below in three progressive steps. Do not use anti-seize or moly grease

### 3. Rotating Clearances

Note: Bolt Diameter is measured across threaded portion not socket size of bolt head

TYPE OF BOLT	RECOMMENDED STRETCH	TORQUE DO NOT EXCEED
1/4" BLACK OXIDE	N/A	150 INCH POUNDS
5/16 BLACK OXIDE	N/A	30 FOOT POUNDS
5/16" ARP 2000	.0057 – .0061"	33 FOOT POUNDS
5/16" CUSTOM AGE	.0062 – .0066"	42 FOOT POUNDS
5/16" L19	.0055 – .0060	32 FOOT POUNDS
3/8" ARP 2000	.0058 – .0064"	60 FOOT POUNDS
3/8" L19	.0065 – .0070"	65 FOOT POUNDS
7/16" 8740	.0050 – .0055"	75 FOOT POUNDS
7/16" ARP 2000	.0055 – .0060"	80 FOOT POUNDS
7/16" L19	.0060 – .0068"	90 FOOT POUNDS
7/16" CUSTOM AGE	.0066 – .0072"	90 FOOT POUNDS
12 mm L19	.0072 – .0077"	125 FOOT POUNDS
1/2" L19	.0082 – .0088"	130 FOOT POUNDS

A minimum of .060-.080" should be kept between all obstacles such as cam, pan rails, etc. (only cut on rods as a last resort — this is highly not recommended)

### 4. Maintenance

- A. Never re-torque rods when they are hot. Do not replace rod bolts in a used rod.
- B. Heavy chamfer side of rod always goes towards cheek side of the crankshaft.
- C. Chamfered I.D. of washers must go toward head of rod bolts.
- D. Check serrations for burns. If necessary, repair with small jewelers file.

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