



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:

Identify the bolt type by measuring the under-head length, thread pitch and checking the material type stamped on the bolt head

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

- Wipe mating faces clean and remove any old grease from threads of bolts and rod.
- Apply **Arrow ABL-01** lubricant to seating face of bolt and threads of bolt and rod.
- Assemble cap to rod and torque each bolt to 15ft/lbs (20Nm).
- Loosen first bolt, zero stretch gauge, tighten until correct stretch is achieved.
- Loosen second bolt, zero stretch gauge, tighten until correct stretch is achieved.

PLEASE NOTE:

To optimise accuracy and to achieve correct bolt pre-load, each bolt should be tightened using a stretch gauge. Torque values are given as a guide ONLY.

If a torque wrench is used to install new bolts, the bolts should be cycled at least three times to settle their friction values.

| BOLT LETTER | PART No. | MATERIAL | THREAD | UHL | STRETCH (RECOMMENDED) | TORQUE (NOT RECOMMENDED) |
|-------------|-----------------------|----------|------------|--------|-----------------------|--------------------------|
| a | M9AG1.500-7U | ARP 3.5 | 5/16" UNJF | 1.500" | 0.0055" – 0.0060" | 30 ft/lbs (41Nm) |
| b | M10AJ1.595-10U | ARP 625+ | 3/8" UNJF | 1.595" | 0.0065" – 0.0070" | 46 ft/lbs (62Nm) |
| d | M9AG1.500-2U | ARP 2000 | 5/16" UNJF | 1.500" | 0.0050" – 0.0055" | 30 ft/lbs (41Nm) |
| e | M10AJ1.500-2U | ARP 2000 | 3/8" UNJF | 1.500" | 0.0055" – 0.0060" | 44 ft/lbs (60Nm) |
| f | 4AJ1.750-2SU | ARP 2000 | 3/8" UNJF | 1.750" | 0.0065" – 0.0070" | 42 ft/lbs (57Nm) |
| g | AR4AP1.550-2U | ARP 2000 | 7/16" UNJF | 1.550" | 0.0050" – 0.0055" | 66 ft/lbs (90Nm) |
| h | AR4AP1.725-2U | ARP 2000 | 7/16" UNJF | 1.725" | 0.0065" – 0.0070" | 65 ft/lbs (88Nm) |
| i | M10AJ1.495-6U | ARP L19 | 3/8" UNJF | 1.495" | 0.0060" – 0.0065" | TBC |
| j | AR301-2W | ARP 2000 | 5/16" UNJF | 2.125" | 0.0070" – 0.0075" | 28 ft/lbs (38Nm) |
| m | 3AG1.260-10U | ARP 625+ | 5/16" UNJF | 1.260" | 0.0045" – 0.0050" | TBC |
| n | M10AJ1.600-2U | ARP 2000 | 3/8" UNJF | 1.600" | 0.0055" – 0.0060" | 48 ft/lbs (65Nm) |
| r | 3AI1.600-2CU | ARP 2000 | MJ9 x 1.0 | 1.600" | 0.0065" – 0.0070" | 42 ft/lbs (57Nm) |
| t | M10AJ1.495-10U | ARP 625+ | 3/8" UNJF | 1.495" | 0.0060" – 0.0065" | 42 ft/lbs (57Nm) |
| u | 4AJ1.600-7SLU | ARP 3.5 | 3/8" UNJF | 1.600" | 0.0055" – 0.0060" | TBC |
| v | 4AJ1.700-2U | ARP 2000 | 3/8" UNJF | 1.700" | 0.0065" – 0.0070" | 45 ft/lbs (61Nm) |
| x | M10AM1.575-7U | MP35N | MJ10 x 1.0 | 1.575" | 0.0055" – 0.0060" | TBC |
| y | M10AI1.950-10U | ARP 625+ | MJ9 x 1.0 | 1.950" | 0.0080" – 0.0085" | TBC |
| aa | M10AI1.440-2U | ARP 2000 | MJ9 x 0.75 | 1.440" | 0.0050" – 0.0055" | 45 ft/lbs (61Nm) |
| ab | CRB002.9.1.39.BH10.01 | MP35N | MJ9 x 1.0 | 1.535" | 0.0055" – 0.0060" | TBC |
| ac | M10AF1.650-2U | ARP 2000 | MJ8 x 1.0 | 1.650" | 0.0065" – 0.0070" | TBC |
| ad | M10AJ1.595-6U | ARP L19 | 3/8" UNJF | 1.595" | 0.0065" – 0.0070" | TBC |

