

## TITANIUM

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 head

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 **Arrow ABL-04** 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 (RECOMMENDED)
a	M9AG1.500-7U	ARP 3.5	5/16" UNJF	1.500"	0.0055" – 0.0060"
b	M10AJ1.595-10U	ARP 625+	3/8" UNJF	1.595"	0.0065" – 0.0070"
d	M9AG1.500-2U	ARP 2000	5/16" UNJF	1.500"	0.0050" – 0.0055"
e	M10AJ1.500-2U	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	AR4AP1.550-2U	ARP 2000	7/16" UNJF	1.550"	0.0050" – 0.0055"
h	AR4AP1.725-2U	ARP 2000	7/16" UNJF	1.725"	0.0065" – 0.0070"
i	M10AJ1.495-6U	ARP L19	3/8" UNJF	1.495"	0.0060" – 0.0065"
j	AR301-2W	ARP 2000	5/16" UNJF	2.125"	0.0070" – 0.0075"
m	3AG1.260-10U	ARP 625+	5/16" UNJF	1.260"	0.0045" – 0.0050"
n	M10AJ1.600-2U	ARP 2000	3/8" UNJF	1.600"	0.0055" – 0.0060"
r	3AI1.600-2CU	ARP 2000	MJ9 x 1.0	1.600"	0.0065" – 0.0070"
t	M10AJ1.495-10U	ARP 625+	3/8" UNJF	1.495"	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"
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"
ab	CRB002.9.1.39.BH10.01	MP35N	MJ9 x 1.0	1.535"	0.0055" – 0.0060"
ac	M10AF1.650-2U	ARP 2000	MJ8 x 1.0	1.650"	0.0065" – 0.0070"
ad	M10AJ1.595-6U	ARP L19	3/8" UNJF	1.595"	0.0065" – 0.0070"

