

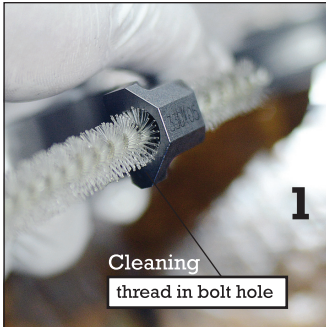
IMPORTANT !



ARP highly recommend using a stretch gauge when installing rod bolts and other fasteners, where it is possible to measure the length of the fastener. It is the most accurate way of measuring preload of any bolt. When using a stretch gauge it's best to measure the fastener prior to starting and monitor overall length during installation. When the bolt has stretched a specified amount, the correct preload or clamping force has been applied. ARP recommend that you maintain a chart of all rod bolts and make a note of the fastener length prior to installation and after any disassembly. If there is a **permanent increase of .001" or more in length**, there is a deformation and the bolt should be replaced.

For more information, please refer to ARP website: www.arp-bolts.com

ARP ROD BOLT INSTALLATION PROCEDURES



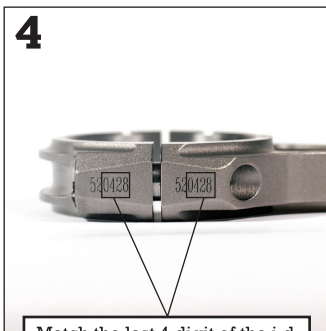
1
Cleaning
thread in bolt hole



2
Cleaning
the mating surfaces



3
Cleaning
bolt head loading surface on cap



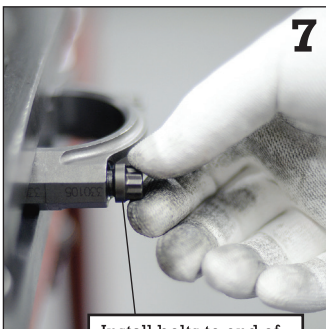
4
Match the last 4 digit of the i.d. numbers on cap and beam



5
Using stretch gauge to check the original bolt length



6
Lubricate bolt thread and under-head radius



7
Install bolts to end of thread by hand



8
Tighten bolts by torque wrench in 2 times, refer to the recommended torque



9
Using the stretch gauge to check the length of bolt again, make sure the stretch is correct. If not, tight or loose the bolt to correct the stretch

ARP ROD BOLT STRETCH & RECOMMENDED TORQUE

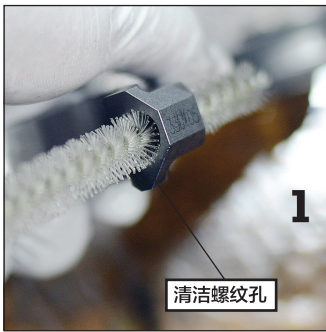
SPECIFICATION	MATERIAL	TENSILE STRENGTH	STRETCH	RECOMMENDED TORQUE		
				FT.LBS.	N-M	ARP SET EQUIV.
7/16"-20 X 1.601"	ARP 2000	220,000 PSI	0.0040"- 0.0045"	50/65	70/90	-
7/16"-20 X 1.801"	ARP 2000	220,000 PSI	0.0045"- 0.0050"	50/70	70/95	200-6204(16PCS)
3/8"-24 X 1.600"	ARP 2000	220,000 PSI	0.0050"- 0.0055"	35/55	50/75	200-6209(8PCS)
3/8"-24 X 1.600"	ARP CUSTOM AGE 625+	260,000 PSI	0.0060"- 0.0065"	45/60	60/85	300-6703(8PCS)
3/8"-24 X 1.500"	ARP 2000	220,000 PSI	0.0050"- 0.0055"	35/55	50/75	200-6207(8PCS)
5/16"-24 X 1.505"	ARP 2000	220,000 PSI	0.0045"- 0.0050"	15/30	20/40	200-6210(8PCS)
5/16"-24 X 1.500"	ARP CUSTOM AGE 625+	260,000 PSI	0.0050"- 0.0055"	15/35	20/50	300-6708(8PCS)

Notice: Torque information are based on using ARP Ultra-Torque fastener assembly lubricant(#100-9908), when using other lubricant, torque might be different

ARP强烈建议在安装连杆螺栓时使用拉伸计，因为这是测量螺栓预紧力最准确的方法。如果有条件测量螺栓安装前后的长度变化，也建议在安装其他螺栓时使用。当使用拉伸计时，最好在安装前测量螺栓初始长度，并在安装过程中监测整体长度变化。当螺栓拉伸至目标值时，表明施加了正确的张紧力或夹紧力。ARP建议在安装前和拆卸后，测量并记录螺栓的长度。如果**螺栓长度增加了0.001英寸或更多**，则说明螺栓发生了塑性变形，应及时更换。

更多信息敬请访问ARP官网：www.arp-bolts.com

ARP连杆螺栓安装步骤



1 清洁螺纹孔



2 清洁杆与盖的结合面



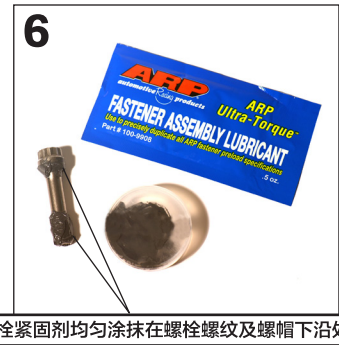
3 清洁连杆盖的螺栓台



4 将连杆杆、盖按序号后四位配对



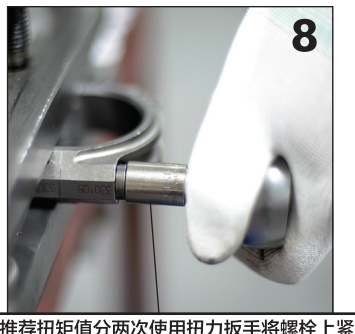
5 使用拉伸计测量螺栓初始长度



6 将BW螺栓紧固剂均匀涂抹在螺栓螺纹及螺帽下沿处



7 用手上紧连杆螺栓



8 按推荐扭矩值分两次使用扭力扳手将螺栓上紧



9 使用拉伸计测量螺栓的拉伸量，确保拉伸量正确。如果拉伸量不正确，则需要通过拧紧或松开螺栓来调整至正确的拉伸量

ARP连杆螺栓拉伸量及推荐扭矩值对照表

规格	材质	拉伸强度	拉伸量	推荐扭矩值 首次/完成(牛·米)
7/16"-20X1.600"	ARP 2000	220,000PSI	0.0040"-0.0045"	70/90
7/16"-20X1.800"	ARP 2000	220,000PSI	0.0045"-0.0050"	70/95
3/8"-24X1.600"	ARP 2000	220,000PSI	0.0050"-0.0055"	50/75
3/8"-24X1.600"	ARP CUSTOM AGE 625	260,000PSI	0.0060"-0.0065"	60/85
3/8"-24X1.500"	ARP 2000	220,000PSI	0.0050"-0.0055"	50/75
5/16"-24X1.500"	ARP 2000	220,000PSI	0.0045"-0.0050"	20/40
5/16"-24X1.500"	ARP CUSTOM AGE 625	260,000PSI	0.0050"-0.0055"	20/50

备注：推荐扭矩值仅适用于使用BW螺栓紧固剂时有效，使用其他润滑剂/紧固剂时可能会使扭矩值有偏差