

## INSTALLATION INSTRUCTIONS FOR ARC-6270 BILLET ROD

To install your ARC rod you will need:

- a 12 point 1/4" socket
- a QUALITY inch pound torque wrench
- an outside micrometer
- dial bore gauge or plastigauge
- oil

Measure the crank pin diameter with the outside micrometer. It should measure 1.180" +/- .0005". Measure it in several spots to insure roundness. If the diameter is out of round more than .0005", it should likely be replaced. The crank pin finish should be smooth to the touch.

When disassembling the rod, notice the side of the rod where the part number is located. There are two dots next to the separation point of the beam and cap. These dots help to re-orientate the cap and beam when assembled. The side of the rod with the part number engraved will always face the side cover.

Make sure the bearing and rod serrations are clean, then install the bearings. Lubricate the rod bolt threads, and hand tighten the bolts. Using the torque wrench, tighten the bolts to 60" lbs. Alternate each side to increase the torque by 20" lbs until you reach 150"lbs. Loosen the bolts and repeat the torque process. This helps seat the rod bearing, especially on a new rod. Measure the bore with your dial bore gauge opposite the parting lines. If using a plastigauge, you will have to install the rod on the crank and use according to the plastigauge instructions.

The rod bore should measure 1.183 +/- .0005". With plastigauge, you are looking for about .003" clearance. A clearance of .0025-.0035" is acceptable. Anything outside this range should prompt a call to our office: (910) 655-9035 M-T 8:30AM-5:30PM, F 8:30AM-3PM.

Once clearance is set, apply oil to rod, crank, and wrist pin and torque to 170"lbs.

***Improperly torquing rod bolts is one of the most common causes of rod failure.***