

# Verify Clearances

Before installing your CTS connecting rods it is recommended you measured all the critical clearances. Make sure to record the measurements for each rod and number match them to the bearing set, crankshaft journal, and wrist pins.

**\*\* You must use a quality bore gauge and micrometer, record the following measurements:\*\***

- Wrist pin diameter
- Wrist pin bushing bore
- Wrist pin clearance (Bore minus diameter)
- Rod journal (w/bearings)
- Crankshaft journal diameter
- Journal clearance

# Torque Specifications

## STEP 1 -PRE-TORQUE:

Before you final stretch the rod bolts, it's important the bolt and rod threads are fully seated.

- Install rod bearings
- Align matching printed numbers on rod and cap
- Assemble cap to rod
- Apply ARP assembly lube to bolt threads
- Hand tighten bolts
- Using a quality calibrated torque wrench, torque bolts to 50 ft/lbs
- Break bolts loose, and again torque to 50 ft/lbs
- Break bolts loose, then torque to 50 ft/lbs one final time

## STEP 2 -FINAL TORQUE:

The final torque spec is .006" (stretch gauge) or 50 ft/lbs (torque wrench) with ARP assembly lube. The preferred method of measuring bolt load is with a stretch bolt gauge.

### Stretch Gauge

- Loosen bolt and zero stretch gauge
- Tighten bolt to .006" stretch
- Loosen second bolt and zero stretch gauge
- Tighten second bolt to .006" stretch

### Torque Wrench

- Loosen bolt
- Tighten bolt to 50 ft/lbs
- Loosen second bolt
- Tighten second bolt to 50 ft/lbs

### Important notes

- Do not exceed rod bolt stretch/torque. If bolt stretch is exceeded, replace rod bolts with new ones.
- Torque wrench settings are given as a guide only, to ensure proper bolt installation a stretch gauge is required.
- Do not install bolts dry or with any other lubricant than the supplied ARP assembly lube.

