



**Part Number: 251-6202**

**Application: FORD 1.8L DURATECH 4-CYL**

### **Cap Screw without Washer - Rod Bolt Installation**

- [1] Please check the part-number(s) for your application against the part-number(s) listed on the instruction sheet.
- [2] Make sure there is an adequate chamfer around the bolt hole on the connecting rod cap to clear the radius under the head of the bolt.
- [3] Use **ARP Ultra-Torque Fastener Assembly Lubricant** to lubricate the threads of the bolt and the under head of the bolt. Then install the bolts and tighten them hand tight.
- [4] ARP recommends using the **STRETCH METHOD** when tightening rod bolts. Following the instructions for using a stretch gauge, **Stretch the bolts to .0065 - .0070**.
- [5] If you do not have a stretch gauge, torque the bolts to **45** ft-lbs using **ARP Ultra-Torque Fastener Assembly Lubricant**.
- [6] The connecting rods should always be re-sized after new rod bolts are installed.
- [7] A log should be kept on the original non-torqued length of each bolt. Bolts that have any permanent deformation or have increased in non-torqued length by more than .001 in. should be replaced.