



Part Number: 204-3003

Application: VOLKSWAGEN "02M" RING GEAR

Press Fit – Ring Gear Bolt Installation

- [1] Please check the part-number(s) for your application against the part-number(s) listed on the instruction sheet.
- [2] It will be necessary to drill out the factory ring gear retaining rivets in order to install the ARP ring gear bolts.
- [3] Make sure that there is an adequate chamfer around the holes in the differential housing to clear the radius under the head of the new ring gear bolts.
- [4] Align the bolt holes on the ring gear with the bolt holes on the differential housing and install the ring gear. This is easily accomplished by pressing in two new ring gear bolts (180 degrees apart from one another) through the holes in the differential housing to help align the ring gear holes as the ring gear is pressed onto the differential housing.
- [5] Press the remaining ring gear bolts into the differential housing. **Note: The bolts must be pressed into the differential housing not the ring gear.**
- [6] Use **ARP Ultra-Torque Fastener Assembly Lubricant** to lubricate the threads of the bolt and the nut face. Then install the nuts onto the bolts and tighten them hand tight. **DO NOT USE ANY WASHERS** with ARP Ring Gear Bolts. They are designed to be used without them.
- [7] Using an alternating or criss cross pattern, torque the bolts to **40** ft lbs using **ARP Ultra-Torque Fastener Assembly Lubricant**.