1863 Eastman Ave.
Ventura, Ca. 93003
www.arp-bolts.com

Part Number: 203-6001
Application: TOYOTA 1.6L (4AGE/4ALC) 4-CYL (M9)

Press Fit - 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 top of the connecting rod bolt hole to clear the radius under the head of the bolt.

[3] Press the bolts into the connecting rods and install the rod caps.

[4] 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.

[5] ARP recommends using the **STRETCH METHOD** when tightening the bolts. Following the instructions for using a stretch gauge, **Stretch the bolts to . 0050 - . 0055 .**

[6] If you do not have a stretch gauge, torque the bolts to **40** ft-lbs using **ARP Ultra-Torque Fastener Assembly Lubricant**.

[7] The connecting rods should always be re-sized after new rod bolts are installed.

[8] 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.

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If you have any questions or need additional information please contact us at **(805) 339-2200 or by FAX (805) 650-0742**