



## **SPECIALTY PRODUCTS, INC.**

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### **“ESP” Forged Steel H-Beam Connecting Rod Installation Instructions**

Thank you for selecting Eagle Specialty Products Connecting Rods! We strive to maintain the highest quality products and services. To ensure optimum service, please read the following instructions thoroughly. If you need any further assistance or have any questions, please contact our technical department at (662)796-7373.

**General:** Always disassemble and thoroughly clean all rod bolt surfaces. Do not use metal stamps to number rods, felt tip markers or tool makers dye are excellent alternatives.

**Fasteners:** Rod bolt threads and underside of head of the bolt should be lubricated with ARP Moly Assembly Lube. Do not use oil or Loctite. Cap should be seated on rod by aligning cap by hand and lightly tapping into place. Alternatively tighten bolts to avoid cocking cap.

**Warning:** If any other lubricant is used on bolt, bolt stretch method must be used due to different viscosity lubricants. Improper bolt torque will cause premature bolt failure.

#### **Torque Specs:**

Bolt	Identification	Torque	Bolt Stretch
7/16" ARP 8740	7/16" bolt head	63 ft. lbs.	.0059"-.0063"
7/16" ARP 2000	7/16" bolt head	75 ft. lbs.	.0064"-.0068"
7/16" ARP L-19	1/2" bolt head	79 ft. lbs.	.0073"-.0077"
3/8" ARP 2000	7/16" bolt head	43 ft. lbs.	.0055"-.0059"
5/16" ARP 2000	3/8" bolt head	28 ft. lbs.	.0048"-.0052"
5/16" ARP Custom Age 625	3/8" bolt head	32 ft. lbs.	.0062"-.0066"

To accurately determine the life of a bolt, it is recommended that a log of the bolts original free-standing (Untorqued) length should be kept and recorded upon subsequent teardowns for inspection. The free-standing length should be checked against it's original length. If there is an increase of .001" or more, or if there is any permanent deformation or galling, the bolt should be replaced.

**Caution:** Rod bolts are manufactured from high grade steel and are vulnerable to corrosion. Caution should be taken when handling fasteners to prevent exposing to moisture. Bolts should always be handled by the bolt head. Rod bolts should always be lubricated prior to handling or storage.

**Clearances:** Clearances listed are general guides and may vary according to the application.

- Rod Bearings - .002" - .003"
- Piston Pin - .0009" - .0015"
- Side Clearance - .015" - .025"
- Block / Cam - Minimum .050"

**Warranty:** Eagle Specialty Products warrants that all of its products are free from defects in material and workmanship. This warranty is void on all products that show evidence of misapplication, improper installation, abuse, lack of proper maintenance or alteration from its original design. Warranty is limited to the cost of replacement of Eagle Specialty Products only, excluding labor and other related incurred cost. Eagle Specialty Products will not be responsible for incidental or consequential damages, property damage and personal injury damages to the extent permitted by law.

### Connecting Rod Bolt Log

Rod #1	In	Out	Rod #2	In	Out	Rod #3	In	Out	Rod #4	In	Out
Rod #5	_____	_____	Rod #6	_____	_____	Rod #7	_____	_____	Rod #8	_____	_____

Rod #1	In	Out	Rod #2	In	Out	Rod #3	In	Out	Rod #4	In	Out
Rod #5	_____	_____	Rod #6	_____	_____	Rod #7	_____	_____	Rod #8	_____	_____

Rod #1	In	Out	Rod #2	In	Out	Rod #3	In	Out	Rod #4	In	Out
Rod #5	_____	_____	Rod #6	_____	_____	Rod #7	_____	_____	Rod #8	_____	_____

Rod #1	In	Out	Rod #2	In	Out	Rod #3	In	Out	Rod #4	In	Out
Rod #5	_____	_____	Rod #6	_____	_____	Rod #7	_____	_____	Rod #8	_____	_____

Rod #1	In	Out	Rod #2	In	Out	Rod #3	In	Out	Rod #4	In	Out
Rod #5	_____	_____	Rod #6	_____	_____	Rod #7	_____	_____	Rod #8	_____	_____