

# CARRILLO™

*The Choice Connection*

The CARRILLO connecting rod is a precision, high strength, quality connecting rod, which when properly installed and maintained, will perform flawlessly in today's racing and high performance internal combustion engines. We would like to offer some suggestions and specifications that should be helpful in your installation.

## BOLTS

All bolts should be lubricated under the heads as well as on the threads. We recommend the bolt lube included, or as an alternative, molybdenum base paste mixed with engine oil.

The preferred method to torque the bolt is by using the stretch figure listed in the table below. In order to check bolt stretch, simply fixture one rod, leaving the cap portion free from clamping load. Measure both bolt lengths loose, then progressively tighten the bolt until the measured increase in length correlates with the figures below. Use the indicated torque reading to tighten all the connecting rods in final assembly.

THREAD SIZE	MATERIAL	STRETCH RECOMMENDED Inches	STRETCH RECOMMENDED Metric	TORQUE NOT TO EXCEED Pounds	TORQUE NOT TO EXCEED Metric
1/4	CARR	.004 to .006		275 Inch Pounds	
5/16	WMC5	.004 to .006		38 Foot pounds	
5/16	CARR	.005 to .007		45 Foot Pounds	
3/8	WMC6	.005 to .007		45 Foot Pounds	
3/8	CARR	.005 to .007		65 Foot Pounds	
7/16	CARR	.005 to .008		100 Foot Pounds	
7/16	WMC7	.005 to .007		75 Foot Pounds	
7/16	WMC7-1	.005 to .007		75 Foot Pounds	
M9	CARR	.0050 to .0066	0.127 to 0.168	60 Foot Pounds	82 Nm

## DO NOT MAGNAFLUX CARRILLO CONNECTING RODS WITH BOLTS INSTALLED

## CLEARANCES

Bearing clearances are dictated primarily by the bearing, not by the housing bore of the connecting rods. The connecting rod bore determines crush. Bearing clearances vary as to the application, diameter of the journal and bearing design. An approximate factor would be .001 per 1.000" diameter of crankshaft pin measured at the crown of the bearing surface.

Wrist pin to bushing clearance is variable per diameter as well. The following is a reference scale:

WRIST PIN DIAMETER	CLEARANCE	MAXIMUM CLEARANCE
.500 to 0.750"	.0010"	.0016"
.751 to 1.094"	.0012"	.0020"

Prior to disassembly of the connecting rod, number the connecting rod and matching cap. DO NOT use a metal stamp!

## GUARANTEE

We guarantee the quality of the steel, the forging, the heat treat process, and the dimensional sizes. We have no control over the assembly or customer modification of the connecting rod in the engine. There are no further guarantees either expressed or implied by CARRILLO INDUSTRIES or any of their agents or representatives.

CARRILLO INDUSTRIES reserves the right to alter the design or initiate product changes without incurring liability or obligation with respect to similar products previously manufactured by this concern.



Date: 07-Sep-07

Purchaser: Wiseco Piston, Inc.

Item: HO-752<-54570S-00

Lot Number: 39194-245-75

Center To Center: 4.570

Bolts: 5/16" CARR

WEIGHTS

P.E. Bore: 0.5916

Total: 320

B.E. Bore: 1.5360

Rotating: 245

P.E. Thks: 0.900

Reciprocating: 75

B.E. Thks: 0.893

**PLEASE RETAIN THIS CARD FOR REFERENCE**

Group: ND

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