

**ASSEMBLY & INSTALLATION NOTES**

**JUBU HD steel rods 2GE-FE (JU00088PRD)**

for 2GR-FE

Please follow the instructions in this manual for a proper assembly & installation of the JUBU HD steel rods for 2GR-FE.

Please find in this document:

1. PART LIST
2. ASSEMBLY & INSTALLATION NOTES

**1. PART LIST for product JU00088PRD**

#	ITEM	ART-NO.	UNITS
1	HD steel rods 2GR-FE	JPP620001	6
2	Fastener assembly lubricant	JU01213ART	1



Fig 1: Scope of delivery

## 2. ASSEMBLY & INSTALLATION NOTES

Level of difficulty: **Complex**

Required time: **1h - 2h** (depends on engine built status, experience, available tools & skills)

1. Please check the clearance of the conrod bearings. (0.045mm to 0.056 mm)
2. Before tightening the conrod bolts, clean the threads and apply the ARP moly lubricant (2) on the threads and under bolt heads.
3. There are 2 options to tighten the rod bolts correctly (we prefer the stretch method)

### Stretch method

- Tighten the conrod bearing bolts progressively (in 3 steps) to reach 0.11mm to 0.15mm stretch.

 **NOTE:** Do not go over 75Nm or 55 ft-lb.

### Torque method (tighten the conrod bolts in 3 steps)

1. 45Nm or 33 ft-lb and open the bolts but loose them not completely
2. 65Nm or 48 ft-lb and open the bolts but loose them not completely
3. 75Nm or 55 lf-lb (final step)

 **NOTE:** Only 2 full tightening procedures are allowed. After 2 cycles you have to renew the con rod bolts!

\*\*\*\*\*

If you have any questions or need additional information, please contact us by email:

[info@jubu-performance.com](mailto:info@jubu-performance.com)

**JUBU Performance GmbH**

Saxenegg 3a, 4323 Münzbach, AUSTRIA