

**PART NUMBER(s):** WKP-PMCA1ACR

**WE ARE NOT RESPONSIBLE FOR ANY DAMAGES. BE VERY CAREFUL TO NOT DAMAGE YOUR MACHINE OR PARTS DURING THIS PROCESS.**

#### STEP

##### 1) Correct clearances

- A. Use plastigage or micrometers to obtain a minimum of .0025" bearing clearance.
- B. Side clearance for each pair of rods should be .020" — .060" for rods sharing a journal.
- C. Side clearance for single rod per rod journal should be between .012" — .035"
- D. Minimum clearance for wrist pins should be .0007"

##### 2) Lubricants and Torquing

- A. Clean and check rods well for debris. Apply 50W oil to bolts, then torque using the specifications below in three progressive steps. **Do not use anti-seize or moly grease.**

##### 3) Rotating Clearances

TYPE OF BOLT	RECOMMENDED STRETCH	TORQUE (DO NOT EXCEED)
1/4" BLACK OXIDE	N/A	150 INCH POUNDS
5/16" ARP 2000	.0057" — .0061"	33 FOOT POUNDS
5/16" CUSTOM AGE	.0062" — .0066"	32 FOOT POUNDS
5/16" L19	.0055" — .0060"	32 FOOT POUNDS
3/8" ARP 2000	.0058" — .0064"	65 FOOT POUNDS
3/8" L19	.0065" — .0070"	75 FOOT POUNDS
7/16" 8740	.0050" — .0055"	75 FOOT POUNDS
7/16" ARP 2000	.0055" — .0060"	80 FOOT POUNDS
7/16" L19	.0060" — .0068"	90 FOOT POUNDS
7/16" CUSTOM AGE	.0066" — .0072"	90 FOOT POUNDS
12MM L19	.0072" — .0077"	125 FOOT POUNDS
1/2" L19	.0082" — .0088"	130 FOOT POUNDS

- A. A minimum of .060" — .080" should be kept between all obstacles such as cam, pan rails, etc. (**only cut on rods as a last resort — this is highly not recommended**)

##### 4) Maintenance

- A. Never re-torque rods when they are hot. Do not replace rod bolts in a used rod.
- B. Heavy chamfer side of rod always goes toward cheek side of of the crankshaft.
- C. Chamfered I.D. of washers must go toward head of rod bolts.
- D. Check serrations for burrs. If necessary, repair with small jewelers file.



## LIABILITY STATEMENT

Warranty Killer Performance's® products are designed to best fit user's ATV/UTV under stock conditions. Adding, modifying, or fabricating any factory or aftermarket parts will void any warranty provided by Warranty Killer Performance® and is not recommended. Warranty Killer Performance's® products could interfere with other aftermarket accessories. If user has aftermarket products on machine, contact Warranty Killer Performance® to verify that they will work together.

Although Warranty Killer Performance® has thousands of satisfied customers, user should be aware that installing lift kits, long travel, or suspension kits, tires, etc. will change the ride of machine and may increase maintenance and part wear. Operating any off-road machine while, or after, consuming alcohol and/or drugs increases risk of bodily harm or death. No warranty or representation is made as to this product's ability to protect user from severe injury or death. Warranty Killer Performance® urges operators and occupants to wear a helmet and appropriate riding gear at all times.

By purchasing and installing Warranty Killer Performance® products, user agrees that should damages occur, Warranty Killer Performance® will not be held responsible for loss of time, use, labor fees, replacement parts, or freight charges. Warranty Killer Performance®, nor any 3rd party, will not be held responsible for any direct, indirect, incidental, special, or consequential damages that result from any product purchased from Warranty Killer Performance®. The total liability of seller to user for all damages, losses, and causes of action, if any, shall not exceed the total purchase price paid for the product that gave rise to the claim.

Warranty Killer Performance® will warranty only parts provided by Warranty Killer Performance®. Any damage or problems with OEM housings, bearings, seals, or other manufacturers' products will not be covered by Warranty Killer Performance®. Warranty Killer Performance® parts and products are not warranted if item was not installed properly, misused, or modified. Installing, adding, modifying, or fabricating any factory or aftermarket product to your ATV/UTV may violate certain local, state, and federal laws. Be advised that laws vary depending on town, city, county, state, etc. Use of certain products on public streets, roads, or highways may be in violation law. The Buyer is solely and exclusively legally and personally responsible for any violation of the law by the installation or use of the product. You must abide by all local, state, and federal laws, including but not limited to vehicle safety, traffic laws, and ordinances. It is your responsibility to know the laws and how they apply to you.

The Buyer is responsible to fully understand the capability and limitations of his/her vehicle according to manufacturer specifications, warnings and instructions and agrees to hold Warranty Killer Performance® harmless from any damage resulting from failure to adhere to such specifications, warnings and/ or instructions. The Buyer is also responsible to obey all applicable federal, state, and local laws and ordinances when operating his/her vehicle while using this product, and the Buyer agrees to hold Warranty Killer Performance® harmless from any violation thereof.