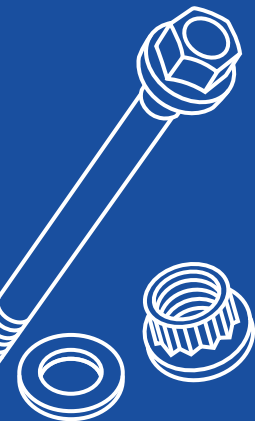


**XOTIC<sup>®</sup>**  
PERFORMANCE



#### KIT INCLUDES



**12 X** ROD BOLTS



**1 X** FASTENER ASSEMBLY LUBRICANT



**1X** SOCKET

# INSTRUCTION MANUAL

## DODGE CUMMINS 5.9L 24V & 12V CONNECTING ROD BOLT KIT

PART NUMBER CP114 | 1989-2002

**STEP 1:** Clean all bolts, threads, and mating surfaces thoroughly to remove dirt, debris, or oil. Inspect connecting rods, caps, and bearings for cracks, wear, or damage. Replace any questionable parts before assembly.

**STEP 2:** Use only the supplied fastener lubricant. Apply evenly to the threads and under the bolt head for consistent clamping force.

**STEP 3:** Install bearings and pistons according to manufacturer guidelines. Seat the connecting rods onto the crankshaft. Refit the rod caps, ensuring they are aligned in the same orientation as removed.

**STEP 4:** Hand-thread each bolt until snug. Verify the caps and rods are correctly aligned and fully seated.

**STEP 5:** Tighten bolts in a progressive sequence:

1. Snug each bolt to 10 ft-lbs.
2. Final tighten to **95 ft-lbs**

**STEP 6:** Re-check all fasteners for uniform torque or stretch. Document the original free length of each bolt for future comparison.

**STEP 7:** At teardown, measure each bolt against its original length. If a bolt has stretched more than 0.001", or shows any galling/damage, replace it immediately.



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### NEED HELP?

For technical support, please email:  
[tech@xotic-performance.com](mailto:tech@xotic-performance.com)



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