Supplemental Information & Instructions for 322-191 Flywheel Bolts, 12 Pt. ARP Austin Healey 100-6 & 3000 Triumph TR2, 3, 3A, 3B, 4 & 4A





About these very special bolts...

Everybody knows flywheel bolts are critical, no matter what you drive. We offer good quality replacement bolts for both the Healeys and the Triumphs, but we have had a number of people ask for something better/stronger/safer, and we are happy to be able to offer a superior alternative – flywheel bolts from ARP.

The experts at ARP have developed the Premium Grade Pro Series, originally developed for NASCAR competition. They are forged from an aerospace alloy and heat-treated. The threads are rolled, not cut. These bolts are rated at 200,000 PSI – far stronger than any original factory flywheel bolt, and stronger than the replacement bolts we currently offer. The underside of the head has a step that is dead flat and perfectly smooth. The length of the bolt under the head is 7/8". The distinctive flat 12-point head design makes them instantly recognizable.

Any general installation tips?

After explaining the situation to the Tech people at ARP, they made the following recommendations:

- 1) Check the surface of the flywheel where the underside of the bolt head will make contact. If it is badly chewed up, that will need to be cleaned up or you will not achieve proper torque on the bolts.
- 2) Do not use the originally fitted lock tabs. The lock tabs are relatively soft compared to the bolt and the flywheel, and this could lead to inaccurate torque readings which is a serious problem. Even if that were not a concern, the 12-point design of the ARP bolt head makes it very hard to fold up a section of the lock tab in a way that will actually lock the bolt in place.
- 3) Regardless of whether or not your application used lock tabs, ARP says that you're much better off using a non-permanent Loctite (blue) on the threads. That will prevent the bolts from working loose.
- 4) Put a drop or two of ARP Ultra-Torque® Lubricant (Moss 322-815) on the underside of the bolt head. This will reduce the friction between the bolt and the surface of the flywheel.
- 5) Torque the bolts to the original factory specification. These bolts (like any bolt) exert a clamping force pressing the flywheel and crankshaft flange together because when torqued properly, the bolt stretches a very small amount. Bumping up the torque applied "to be sure" can have serious consequences.

TR2, 3, 3A, 3B, TR4 and TR4A Flywheel Bolt Options

Original TR Number	Moss Europe	Moss US	Qty Req'd	Description	Comments	Available
102065	102065	320-740	4	Bolt, flywheel NLS, Use 320-770	Use w/ Lock Tab 837-560	NO
056524	056524	837-560	2	Lock Tab, Flywheel Bolt	For 320-740 Bolts	Yes
138527	138527	320-770	4	Bolt, flywheel, self-locking	Do Not Use Lock Tab	Yes
		OR USE				
NA		322-191	4	Bolt, flywheel, ARP 12 Point	Use Loctite on threads. w/ 322-816 ARP Lube under the head.	Yes
		322-815	1	ARP ultra torque® ass'y lube		Yes
		771-335	1	Loctite, Blue, 1 ml pouch		Yes

The original flywheel bolts 320-740 or 102065 for TR2, 3, 3A, 3B and TR4 to CT34071E were secured with lock tabs. The original bolts have not been available for quite some time. Standard practice has been to set the original locktabs aside and use the 320-770 or 138527 self-locking bolt which was designed to be used without any lock tabs on the TR4 from CT34072E on and on all TR4A. The self-locking 320-770 or 138527 bolts we offer are 7/8" long under the head, and they are X grade – 166,000 to 188,000 PSI- very high strength (exceeding the original specification).

For those looking for the absolute best in Triumph flywheel bolts, we offer 322-191, the very special 12 point ARP flywheel bolts. They are also 7/8" long under the head. On Triumph TR 2 through 4A, the ARP bolts should be used *without* the locktabs. A drop of 322-815 ARP Ultra-Torque® Assembly Lube between the flywheel and the flat surface under the head of the bolt will reduce friction with the flywheel when the ARP bolts are tightened. Blue Loctite should be used on the threads to secure the bolts and prevent them from backing out.

Austin Healey 100-6, 3000 (6 Cylinder Cars) Flywheel Bolt Options

Original AHY Number	Moss Europe	Moss US	Qty Req'd	Description	Comments	Available
AEC265	AEC265	322-190	4	Bolt, flywheel	Use w/ Lock Tab 031-209	Yes
2K7552	031-209	031-209	2	Lock Tab, Flywheel Bolt	Use w/ Bolt 322-190	Yes
		OR USE				
NA		322-191	4	Bolt, flywheel, ARP 12 Point	Use Loctite on threads. w/ 322-816 ARP Lube under the head.	Yes
		322-815	1	ARP ultra torque ass'y lube		Yes
		771-335	1	Loctite, Blue, 1 ml pouch		Yes

Original type flywheel bolts are available under 322-190, and they are used with lock tabs 031-209. The bolts we offer are 7/8" long under the head and 5/8" across the flats. They are either T grade 123,000 – 145,000 PSI (original specification) or X grade – 166,000 to 188,000 PSI- which is very high strength, exceeding the original specification.

For those looking for the absolute best in six cylinder Healey flywheel bolts, we offer 322-191, the very special 12 point ARP flywheel bolts. The ARP bolts should be used without lock tabs. A drop of 322-815 ARP Ultra-Torque Assembly Lube between the flywheel and the flat surface under the head of the bolt will reduce friction with the flywheel when the ARP bolts are tightened. Blue Loctite should be used on the threads to secure the bolts and prevent them from backing out.

Although every effort has been made to ensure the accuracy and clarity of this information, any suggestions that you may have that will improve the information (especially detailed installation notes) are welcome. Please use the simple email form on the "Contact Us" page on the Moss website: http://www.mossmotors.com/AboutMoss/ContactUs.aspx If you prefer, you may call our Technical Services Department at 805-681-3411. So many people call us for help that we are often not able to answer the calls as fast as we'd like, and you may be asked to leave a message. We apologize in advance for the inconvenience. We will get back to you as quickly as we can, usually within 2 to 4 business days.



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