

2.0L Ford Duratec

ISSUE DATE: March 2010

TORQUE WRENCH SETTINGS

Specifications subject to change without prior notice

MAIN CAP BOLTS- STD

****IF REMOVED THESE MUST BE REPLACED WITH ARP STUD KIT****

MAIN CAP ARP STUDS

60lb Using ARP lube

BIG END BOLTS

STANDARD TYPE ROD BOLTS

****IF REMOVED THESE MUST BE REPLACED WITH ARP ROD BOLTS****

Heavy Duty Rods Bolts for Standard Rods

RB – **See separate assembly sheet**

Heavy Duty Rods Bolts for Steel Rods

RB - **See separate assembly sheet**

NOTE: - *When assembling the bolts, as of 2002, the manufacturers recommend only using ARP assembly lubricant as supplied, under the heads and on the threads and torque up to. These are lower torque settings than would have been used with normal oil. We cannot be held responsible for rod bolt stretch when an uncalibrated torque wrench has been used.*

OIL PUMP BOLTS

CRANK BOLT

GRAPHITE GREASE UNDER HEAD & WASHER, OIL THREAD

STAGE 1 – 74 LB/FT

STAGE 2 – 90 Degrees

CAM CAPS

STAGE 1 - 5 LB/FT
STAGE 1 - 12 LB/FT

CAM PULLEY BOLT (Vernier Cam Pulleys)

12 LB/FT

SUMP BOLTS

243 LOCTITE

ALLOY SUMP – 18LB/FT

DRY SUMP-----18LB/FT

FLYWHEEL BOLTS, Std

STAGE 1 – 37 LB/FT

STAGE 2 – 59 LB/FT

STAGE 3 – 83 LB/FT

FLYWHEEL BOLTS, ARP

Graphite grease under head of 243 LOCTITE on threads

STAGE 1 – 85lb/ft (115NM)

STAGE 2 – 105lb/ft (142NM)

CYLINDER HEAD BOLTS

GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS

SEE SEPARATE SHEET FOR TIGHTNING SEQUENCE

STAGE 1 – 4 LB/FT

STAGE 2 – 11 LB/FT

STAGE 3 – 33 LB/FT

STAGE 4 – 90*

STAGE 5 – 90*

ARP HEAD STUD KIT

60 LB/FT Only (Using ARP lube)

2.0L Duratec HEAD BOLT
TIGHTENING SEQUENCE

8	4	1	5	9
7	3	2	6	10

2.0L Duratec HEAD BOLT
REMOVAL SEQUENCE

4	8	9	5	1
3	7	10	6	2