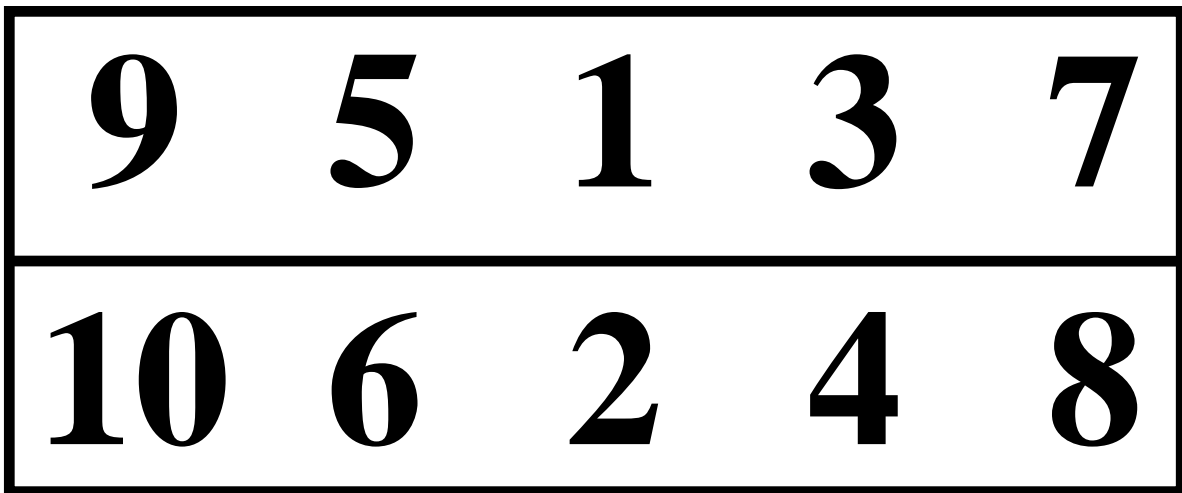


## Revised head bolt torque setting for Cometic head gaskets – From Jan 06

**If cooling mods have been done on head and block,  
then gasket must be dimpled prior to fitting.**

### 2.0L 16V HEAD BOLT TIGHTENING SEQUENCE



#### CYLINDER HEAD BOLTS for standard gaskets

*GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS*

STAGE 1---18 LB/FT 25NM

STAGE 2---65 DEG

STAGE 3---65 DEG

STAGE 4---65 DEG

#### CYLINDER HEAD BOLTS for Cometic gaskets

*GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS*

**IF COOLING MODS HAVE BEEN DONE THEN  
COMETIC GASKET MUST BE DIMPLED**

STAGE 1---25 LB/FT 34NM

STAGE 2---42 LB/FT 56NM

STAGE 3---59 LB/FT 79NM

STAGE 4---75 LB/FT 100NM

#### ARP HEAD STUD KIT PRE 93 ONLY

63 LB/FT Only (Using ARP lube)

80 LB/FT Only (Not using ARP lube, e.g. Graphite grease)