

2.0L 16V

Issue Date: July 2009

TORQUE WRENCH SETTINGS

Specifications subject to change without prior notice

MAIN CAP BOLTS- STD & H/D

GRAPHITE GREASE UNDER HEAD, OIL THREADS

STAGE 1---37 LB/FT 50NM

STAGE 2---40 DEG-50 DEG

BIG END BOLTS

STANDARD TYPE GM ROD BOLTS

STAGE 1---26 LB/FT (GRAPHITE GREASE UNDER HEAD, OIL THREADS)

STAGE 2---45 DEG-60 DEG

Heavy Duty Rods Bolts

SEE SEPARATE 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

4 LB/FT, 6NM(243 LOCTITE)

CRANK BOLT

GRAPHITE GREASE UNDER HEAD & WASHER, OIL THREAD

STAGE 1---184 LB/FT. 250NM

STAGE 2---40 DEG-50 DEG

CAM CAPS

15 LB/FT 20 NM

CAM PULLEY BOLT

STAGE 1---37 LB/FT. 50NM(243 LOCTITE)

STAGE 2---40 DEG-50 DEG

CAM VERNIER PULLEY BOLTS

14 LB/FT

CAM BELT AUTO TENSIONER BOLT – XE/LN ONLY

15 LB/FT

IDLER PULLEY BOLTS

STAGE 1---18 LB/FT. 25NM (243 LOCTITE)

STAGE 2---45 DEG-60 DEG

FRONT PULLEY TORX SCREWS

15 LB/FT. 20NM(243 LOCTITE)

SUMP BOLTS

243 LOCTITE

STEEL SUMP---4 LB/FT

ALLOY SUMP--11 LB/FT

DRY SUMP-----10 NM

FLYWHEEL BOLTS, Std

242 LOCTITE

STAGE 1---48 LB/FT

STAGE 2---30 DEG-45 DEG

FLYWHEEL BOLTS – ARP

Graphite grease under head of bolt, LOCTITE 243 on threads

STAGE 1 – 48lb/ft (65NM)

STAGE 2 – 65lb/ft (88NM)

CYLINDER HEAD BOLTS for standard gaskets

GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS

SEE SEPARATE SHEET FOR TIGHTNING SEQUENCE

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)

**2.0L 16V HEAD BOLT
TIGHTENING SEQUENCE**

9	5	1	3	7
10	6	2	4	8

**2.0L 16V HEAD BOLT
REMOVAL SEQUENCE**

1	3	9	5	7
2	4	10	6	8