



June 2017

## 2.0L XE 16V

### 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 STD for standard gaskets**

*GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS*

SEE SEPARATE SHEET FOR TIGHTENING SEQUENCE

STAGE 1---18 LB/FT 25NM

STAGE 2---65 DEG

STAGE 3---65 DEG

STAGE 4---65 DEG

## **CYLINDER HEAD BOLTS STD for SBD Cometic gaskets**

*PLEASE SEE SEPARATE INSTRUCTION SHEET FOR GSK-VX2-C88-00-03 (5 layer gasket) & GSK-VX2-C88-00-04 (7 layer gasket)*

## 2.0L 16V HEAD BOLT TIGHTENING SEQUENCE

<b>9</b>	<b>5</b>	<b>1</b>	<b>3</b>	<b>7</b>
<b>10</b>	<b>6</b>	<b>2</b>	<b>4</b>	<b>8</b>

## 2.0L 16V HEAD BOLT REMOVAL SEQUENCE

<b>1</b>	<b>3</b>	<b>9</b>	<b>5</b>	<b>7</b>
<b>2</b>	<b>4</b>	<b>10</b>	<b>6</b>	<b>8</b>



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