



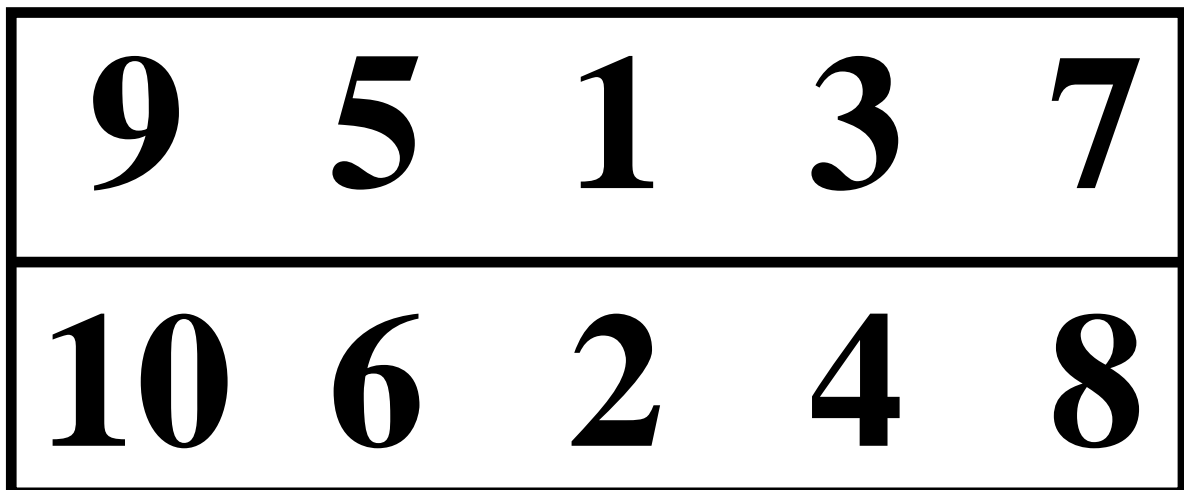
May 2017

**Torque settings SBD Cometic head gaskets**  
**GSK-VX2-C88.00-03**  
**Manufacture date May 2017 on>**

**These torque settings are designed for use with only SBD Cometic gaskets. Our gaskets also include cooling modifications and are dimpled to suit.**

**They cannot be used with any other Cometic gasket.**

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



**GM CYLINDER HEAD BOLTS with SBD Cometic gaskets**

*GRAPHITE GREASE UNDER HEADS & WASHERS, OIL THREADS*

STAGE 1---18 LB/FT, 25NM

STAGE 2---35 LB/FT, 47NM

STAGE 3---55 LB/FT, 75NM

**DO NOT RE-TIGHTEN HEAD BOLTS AFTER THE ENGINE HAS RUN.**

## Difference between pre 93 head bolts (BLT-H1) & post 93 head bolts (BLT-H2) on 2.0L XE engines

