



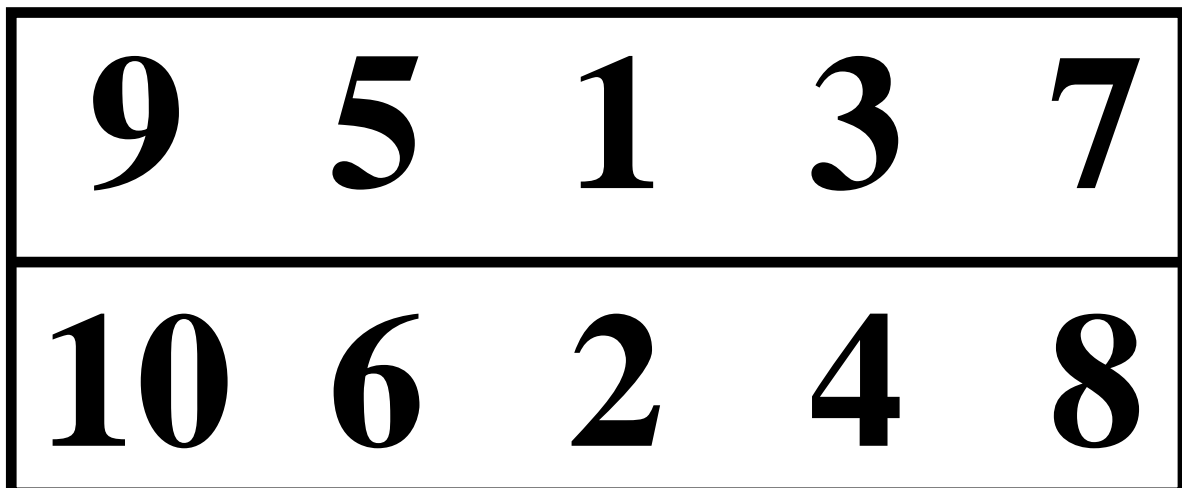
May 2017

Torque settings SBD Cometic head gaskets
GSK-VX2-C88.00-04
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---60 LB/FT, 81NM

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

