

TORQUE SPECIFICATIONS

All readings in ft. lbs.

Year	Engine Displacement Liters	Engine ID	Cylinder Head Bolts	Main Bearing Bolts	Rod Bearing Bolts	Crankshaft Damper Bolts	Flywheel Bolts	Manifold		Spark Plugs	Oil Pan Drain Plug
								Intake	Exhaust		
2001	2.4	KA24DE	①	34-41	②	105-112	105-112	12-14	27-35	14-22	22-29
	3.3	VG33E	②	67-74	②	141-156	61-69	③	21-25	14-22	22-29
2002	2.4	KA24DE	①	34-41	③	105-112	105-112	12-14	27-35	14-22	22-29
	3.3	VG33E	②	67-74	②	141-156	61-69	③	21-25	14-22	22-29
	3.3	VG33ER	②	67-74	④	141-156	61-69	③	21-25	14-22	22-29
2003	2.4	KA24DE	①	34-41	②	105-112	105-112	12-14	27-35	14-22	22-29
	3.3	VG33E	②	67-74	②	141-156	61-69	③	21-25	14-22	22-29
	3.3	VG33ER	②	67-74	④	141-156	61-69	③	21-25	14-22	22-29
2004	2.4	KA24DE	①	34-41	②	105-112	105-112	12-14	27-35	14-22	22-29
	3.3	VG33E	②	67-74	②	141-156	61-69	③	21-25	14-22	22-29
	3.3	VG33ER	②	67-74	④	141-156	61-69	③	21-25	14-22	22-29

① Step 1: 22 ft. lbs.

Step 2: 59 ft. lbs.

Step 3: Loosen completely then retorque to 22 ft. lbs.

Step 4: 18-25 ft. lbs.

Step 5: Plus 65-91 degrees

④ 10-12 ft. lbs. +60-65 degrees

② 10-12 ft. lbs. plus 60-65 degrees or 28-33 ft. lbs.

③ The cylinder heads and the lower intake manifold are installed together

Step 1: Tighten the cylinder head bolts to 22 ft. lbs.

Step 2: Tighten the cylinder head bolts to 43 ft. lbs.

Step 3: Loosen the cylinder head bolts completely

Step 4: Tighten the cylinder head bolts to 84 inch lbs.

Step 5: Tighten the intake manifold fasteners to 35 inch lbs.

Step 6: Tighten the intake manifold fasteners to 13 ft. lbs.

Step 7: Tighten the intake manifold fasteners to 12-14 ft. lbs.

Step 8: Loosen all intake manifold fasteners completely

Step 9: Tighten the cylinder head bolts to 22 ft. lbs.

Step 10: Tighten the cylinder head bolts 60-65 degrees

Step 11: Tighten the cylinder head sub-bolts to 80-105 inch lbs.

Step 12: Tighten the intake manifold fasteners to 35 inch lbs.

Step 13: Tighten the intake manifold fasteners to 78 inch lbs.

Step 14: Tighten the intake manifold fasteners to 70-84 inch lbs.

2003 Saab Torque Specifications

Sebastian Brünink



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Table of Contents 2003 Saab Torque Specifications

1. Understanding the eBook 2003 Saab Torque Specifications
 - The Rise of Digital Reading 2003 Saab Torque Specifications
 - Advantages of eBooks Over Traditional Books
2. Identifying 2003 Saab Torque Specifications
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 2003 Saab Torque Specifications
 - User-Friendly Interface
4. Exploring eBook Recommendations from 2003 Saab Torque Specifications
 - Personalized Recommendations
 - 2003 Saab Torque Specifications User Reviews and Ratings

- 2003 Saab Torque Specifications and Bestseller Lists
- 5. Accessing 2003 Saab Torque Specifications Free and Paid eBooks
 - 2003 Saab Torque Specifications Public Domain eBooks
 - 2003 Saab Torque Specifications eBook Subscription Services
 - 2003 Saab Torque Specifications Budget-Friendly Options
- 6. Navigating 2003 Saab Torque Specifications eBook Formats
 - ePub, PDF, MOBI, and More
 - 2003 Saab Torque Specifications Compatibility with Devices
 - 2003 Saab Torque Specifications Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 2003 Saab Torque Specifications
 - Highlighting and Note-Taking 2003 Saab Torque Specifications
 - Interactive Elements 2003 Saab Torque Specifications
- 8. Staying Engaged with 2003 Saab Torque Specifications
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 2003 Saab Torque Specifications
- 9. Balancing eBooks and Physical Books 2003 Saab Torque Specifications
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 2003 Saab Torque Specifications
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 2003 Saab Torque Specifications
 - Setting Reading Goals 2003 Saab Torque Specifications
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 2003 Saab Torque Specifications
 - Fact-Checking eBook Content of 2003 Saab Torque Specifications
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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