

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
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	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

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.

④ 10-12 ft. lbs. +60-65 degrees

2003 Saab Torque Specifications

Bentley, Bentley Publishers



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