
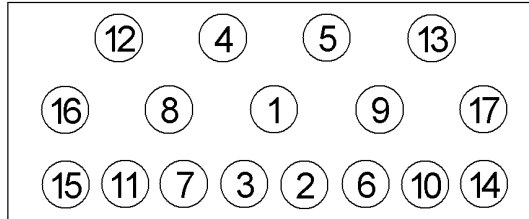


|  |   |   |
|--|---|---|
| <b>Anziehvorschrift für Zylinderkopf</b>         | <b>446.363</b>  | <br>Das Original |
| <b>Tightening Instructions for Cylinder Head</b> |   |   |
| <b>Instructions de serrage pour culasse</b>      |   |   |
| <b>Prescripciones de apriete para culatas</b>    |   |   |
|  | passend für / suitable for<br>adaptable à / adaptable a | <b>Renault</b>  |

Schraubenkopf / Head shape      Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete  
Tête de vis / Cabeza de tornillo



|   |   |  |   |
|---|---|--|---|
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete | * 30 Nm<br>50 Nm<br>□ 20 Nm   | ➤ Pos. 10, 11: 60°<br>➤ Pos. 12, 13: 70°<br>➤ Pos. 14, 15: 60°<br>➤ Pos. 16, 17: 80° | ➤ Pos. 8, 9: 105°<br>➤ Pos. 10, 11: 60°<br>➤ Pos. 12, 13: 70°<br>➤ Pos. 14, 15: 60°<br>➤ Pos. 16, 17: 80° |
|   | ➤ Pos. 1: 105°<br>➤ Pos. 2, 3: 60°<br>➤ Pos. 4, 5: 70°<br>➤ Pos. 6, 7: 60°<br>➤ Pos. 8, 9: 105° | ➤ Pos. 1: 105°<br>➤ Pos. 2, 3: 60°<br>➤ Pos. 4, 5: 70°<br>➤ Pos. 6, 7: 60°           |   |

Zeichenerklärung / Explanations / Explication / Explicacion

|   |   |                              |                                |                                       |
|---|---|------------------------------|--------------------------------|---------------------------------------|
| * | neue Zylinderkopfschrauben verwenden        | use new cylinder head bolts  | utiliser des vis neuves        | emplar tornillos nuevos               |
| ★ | Warmlauf (80°C)                             | warm up time (80°C)          | chauffage (80°C)               | calentamiento (80°C)                  |
| □ | Schrauben einzeln lösen und wieder anziehen | loosen and tighten each bolt | deserrer et serrer vis par vis | aflojar y apretar tornillo a tornillo |
| ● | Setzzeit                                    | relaxation time              | durée de tassement             | tiempo de espera                      |
| ➤ | Drehwinkel                                  | torque angle                 | angle de serrage               | ángulo de giro                        |

**Motortyp / Engine type / Type de moteur / Tipo de motor**

∅: 86,5 mm;  $\frac{1}{2}$ : 1,59/1,50 mm

Diesel/Turbo-Diesel J8S 2068 ccm ab 1980→

R 18, Fuego, R 20, R 21, R 25, R 30, Safrane

Espace, Master, Trafic

47/49/62/65/66 kW (64/67/85/88/90 PS)

Mot.852,852-50,852/720/750, J8S/140/240/600/

704/706/708/714/736/740/742/746/774/784/788

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**\*446.363\***