

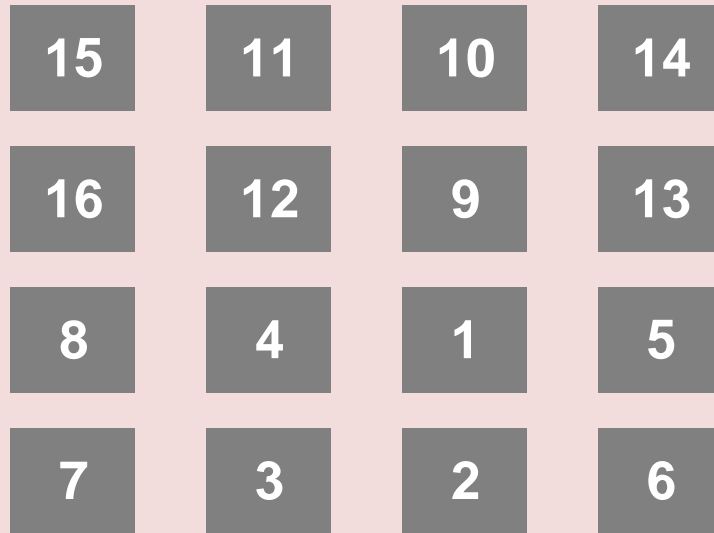
Cylinder Head Tightening Instructions

HG1044



	1	2	3	4	5	6
Reference	HG1044					
Piston						

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Bolt Type 1	Kilos	2.5 Kpm	-90°+2.5 Kpm	+90°	+90°				
	Pounds	18 lbft	-90°+18 lbft	+90°	+90°				
	Newton M's	24.5 Nm	-90°+24.5Nm	+90°	+90°				
Bolt Type 2	Kilos								
	Pounds								
	Newton M's								
Bolt Type 3	Kilos								
	Pounds								
	Newton M's								
Bolt Type 4	Kilos								
	Pounds								
	Newton M's								

Fitment Key	Description of Required Procedure
-/+ X°	Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.
↔	Run the engine until it reaches working temperature. Let the engine cool with the bonnet open for a minimum of four hours. Remove the expansion tank cap. Should retightening be required, loosen by 90° and then retighten observing the tightening procedure above.
Retighten?	If required, should be performed between 620-930 Miles (1000-1500 Km).