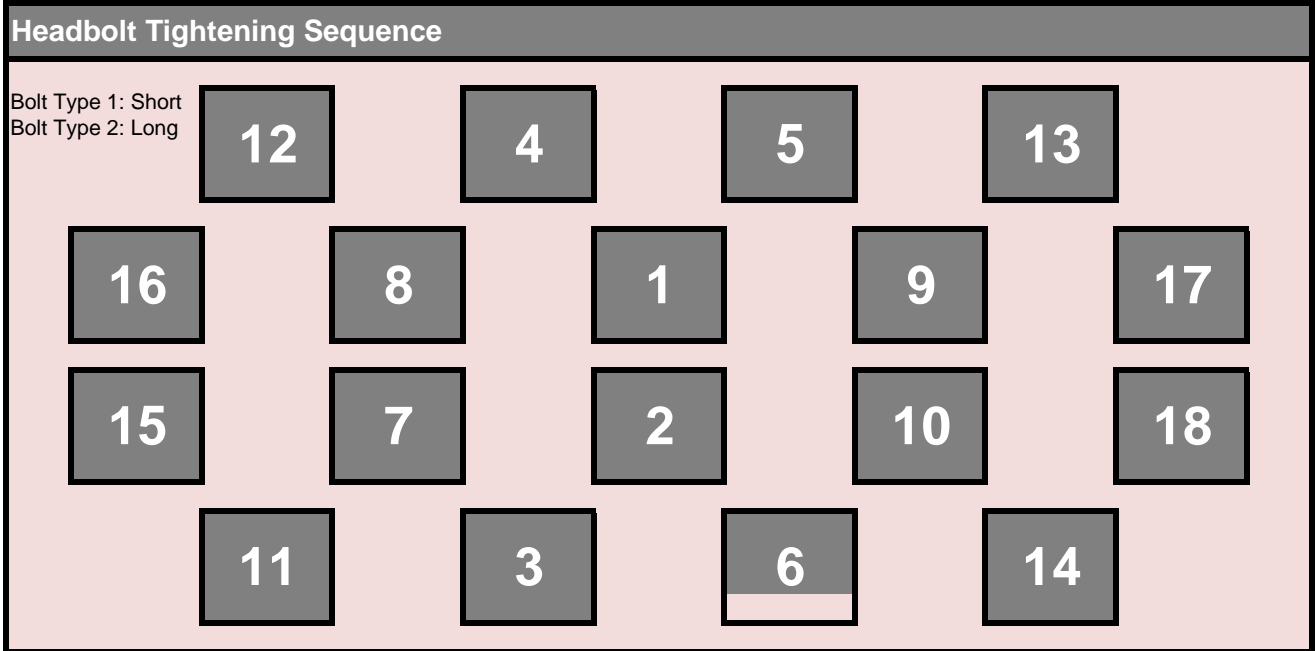


# Cylinder Head Tightening Instructions

# HG1811



	1	2	3	4	5	6
<b>Reference</b>	HG1811					
<b>Piston</b>						



### Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
<b>Bolt Type 1</b>	Kilos	3.5 Kpm	-90°+3.5 Kpm	+40°	+45°				
	Pounds	25 lbft	-90°+25 lbft	+40°	+45°				
	Newton M's	29.4Nm	-90°+29.4Nm	+40°	+45°				
<b>Bolt Type 2</b>	Kilos	3.5 Kpm	-90°+3.5 Kpm	+45°	+70°				
	Pounds	25 lbft	-90°+25 lbft	+45°	+70°				
	Newton M's	29.4Nm	-90°+29.4Nm	+45°	+70°				
<b>Bolt Type 3</b>	Kilos								
	Pounds								
	Newton M's								
<b>Bolt Type 4</b>	Kilos								
	Pounds								
	Newton M's								

Fitment Key	Description of Required Procedure
<b>-/+ X°</b>	Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.
<b>↔</b>	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.
<b>Retighten?</b>	If required, should be performed between 620-930 Miles (1000-1500 Km).