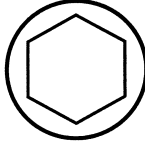


|                                                                                                                                                                                                                                                                               |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                      |                                                                                                                                          | <b>259.820</b>                                                                                                              |                                                                                                                                                                                   |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                                                                                                                                                              |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| <b>Instructions de serrage pour culasse</b>                                                                                                                                                                                                                                   |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| <b>Prescripciones de apriete para culatas</b>                                                                                                                                                                                                                                 |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                                                                |                                                                                                                                          | passend für / suitable for<br>adaptable à / adaptable a<br><b>GM</b><br>Das Original                                        |                                                                                                                                                                                                                                                                    |
| <br><br>595.200<br>M 10x1,5x110-10.9                                                                                                                                                         |                                                                                                                                          | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                                     |                                                                                                                                                                                                                                                                    |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                                               |                                                                                                                                          | *<br><br>➤                                                                                                                  | 15 Nm<br>30 Nm<br>240°                                                                                                                                                                                                                                             |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                                                   |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| *<br>★<br>□<br>●<br>➤                                                                                                                                                                                                                                                         | neue Zylinderkopf-<br>schrauben verwenden<br>Warmlauf (80°C)<br>Schrauben einzeln lösen<br>und wieder anziehen<br>Setzzeit<br>Drehwinkel | use new cylinder<br>head bolts<br>warm up time (80°C)<br>loosen and tighten<br>each bolt<br>relaxation time<br>torque angle | utiliser des vis<br>neuves<br>chauffage (80°C)<br>deserrer et serrer<br>vis par vis<br>durée de tassement<br>angle de serrage<br>emplar tornillos nuevos<br>calentamiento (80°C)<br>aflojar y apretar<br>tornillo a tornillo<br>tiempo de espera<br>ángulo de giro |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b><br><br>Ø: 75,2 mm; $\frac{1}{4}$ : 1,005 mm<br><br>Mot: LE2, LV7, B14XE, B14XFL, B14XFT, D14XFL<br>B14XFT, B15SFL, D15SFL, B15SFT, D15SFL<br>1,4 - 1,5 ltr.<br><br>Astra K, Mokka, Insignia B<br>Cruze, Encore |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                |                                                                                                                                          | <b>*259.820*</b>                                                                                                            |                                                                                                                                                                                                                                                                    |