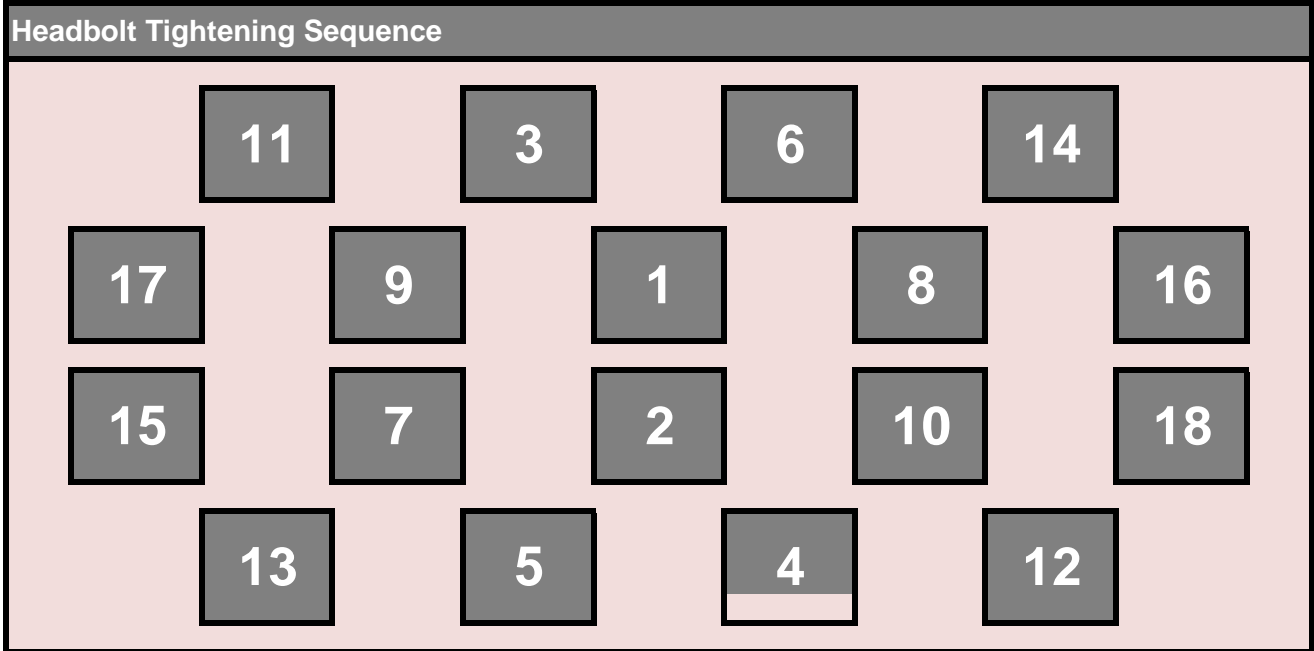


Cylinder Head Tightening Instructions **HG1539B**



	1	2	3	4	5	6
Reference	HG1539B	HG1539C				
Piston	0.78-0.82	0.83-0.88				



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Botl Type 1									
Kilos	5 Kpm	10 Kpm	-180°	5 Kpm	+90°	+90°			
Pounds	36 lbft	72 lbft	-180°	36 lbft	+90°	+90°			
Newton M's	49 Nm	98 Nm	-180°	49 Nm	+90°	+90°			
Botl Type 2									
Kilos									
Pounds									
Newton M's									
Botl Type 3									
Kilos									
Pounds									
Newton M's									
Botl 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).