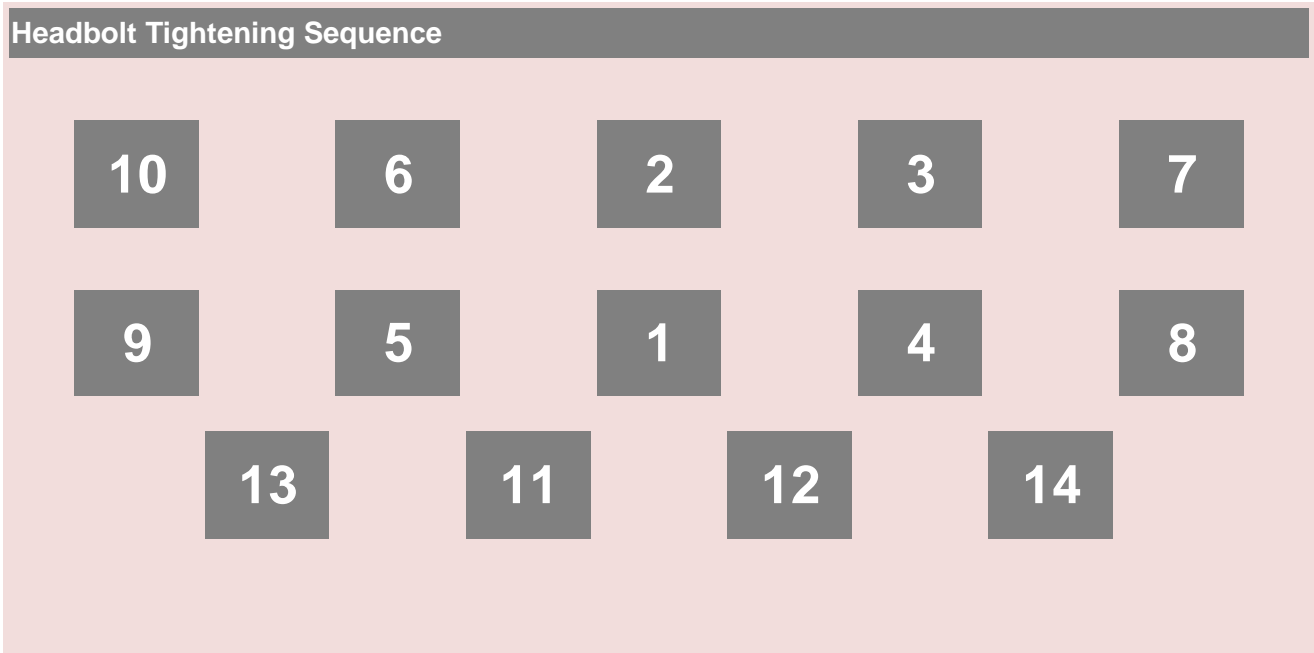


Cylinder Head Tightening Instructions

HG529



	1	2	3	4	5	6
Reference	HG529					
Piston						



Fitment Procedure

		Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Bolt Type 1	Kilos	2 Kpm	+90°	+90°						
	Pounds	15 lbft	+90°	+90°						
	Newton M's	19.6 Nm	+90°	+90°						
Bolt Type 2	Kilos	1 Kpm	2 Kpm	-90°+2 Kpm	+90°	+90°				
	Pounds	7 lbft	15 lbft	-90°+15 lbft	+90°	+90°				
	Newton M's	9.8 Nm	19.6 Nm	-90°+19.6Nm	+90°	+90°				
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).