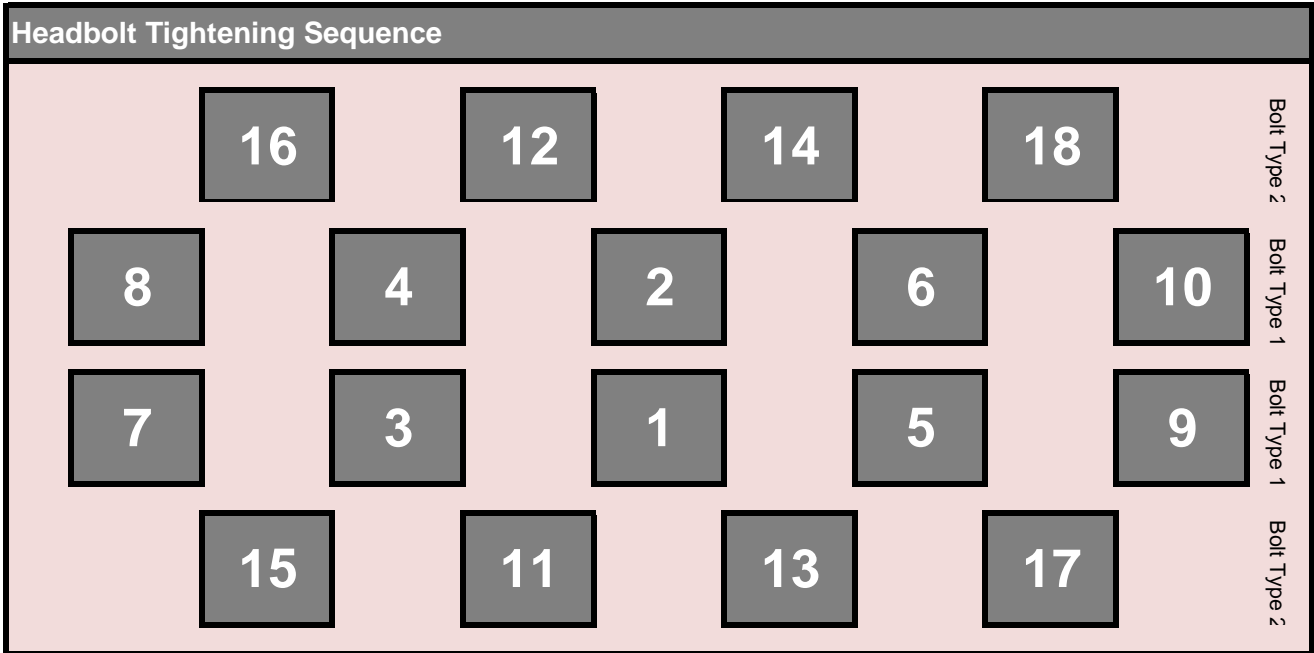


Cylinder Head Tightening Instructions

HG1002



	1	2	3	4	5	6
Reference	HG1002					
Piston	0.571-0.620					



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	4 Kpm	-90°+4 Kpm	+90°	+90°			
	Pounds	15 lbft	29 lbft	-90°+29 lbft	+90°	+90°			
	Newton M's	19.6 Nm	39.2 Nm	-90°+39.2Nm	+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).