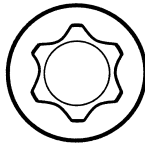


|                                                                                   |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                                                                                                          | <b>146.828</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>Opel</b><br>Das Original                                      |                                                                                                                                                                                                                                                                     |
|  |                                                                                                                                          | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                                     |                                                                                                                                                                                                                                                                     |
| 804.910<br>M 12 x 235                                                             |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | *<br>➤<br>➤<br>➤<br>➤<br>➤                                                                                                               | 25 Nm<br>65°<br>65°<br>65°<br>65°<br>15°                                                                                    |                                                                                                                                                                                                                                                                     |
| 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>desserrer 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>                    |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
| ✚ 1,3 mm, Ø 85,5 mm, 2 Löcher/holes/trous/<br>agujeros                            |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
| Mot.: X 20 DTH/DTL, Y 20 DTH/DTL, X 22 TH,<br>Y 22 DTH/DTR                        |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
| Astra, Frontera, Omega, Signum, Vectra, Zafira<br>Saab 9-3, 9-5                   |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                     |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                                                                                                          | <b>*146.828*</b>                                                                                                            |                                                                                                                                                                                                                                                                     |