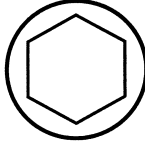


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|-------------------------------------------------|-------------------------------------------|--------------------------------|----------------------------|-------------------------|---------------------------|-----------------|---------------------|------------------|----------------------|---|------------------------------------------------|---------------------------------|-----------------------------------|------------------------------------------|---|----------|-----------------|--------------------|------------------|---|------------|--------------|------------------|----------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                | <b>094.561</b>                                                          | <br>Das Original |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                | passend für / suitable for<br>adaptable à / adaptable a                 |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Instructions de serrage pour culasse</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Prescripciones de apriete para culatas</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                | <b>Volkswagen</b>                                                       |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <div></div> <div>819.832<br/>M 11 x 98</div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</td><td>✱</td><td>50 Nm<br/>70 Nm<br/>90 Nm</td></tr><tr><td></td><td>★</td><td>80°C<br/>90 Nm<br/>1.000 km</td></tr><tr><td></td><td>☐</td><td>90 Nm</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                |                                                                         |                                                                                                   | Anziehen/<br>Tightening/<br>Serrage/<br>Apriete | ✱                                         | 50 Nm<br>70 Nm<br>90 Nm        |                            | ★                       | 80°C<br>90 Nm<br>1.000 km |                 | ☐                   | 90 Nm            |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | ✱                                              | 50 Nm<br>70 Nm<br>90 Nm                                                 |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | ★                                              | 80°C<br>90 Nm<br>1.000 km                                               |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | ☐                                              | 90 Nm                                                                   |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>✱</td><td>neue Zylinderkopf-<br/>schrauben verwenden</td><td>use new cylinder<br/>head bolts</td><td>utiliser des vis<br/>neuves</td><td>emplar tornillos nuevos</td></tr><tr><td>★</td><td>Warmlauf (80°C)</td><td>warm up time (80°C)</td><td>chauffage (80°C)</td><td>calentamiento (80°C)</td></tr><tr><td>☐</td><td>Schrauben einzeln lösen<br/>und wieder anziehen</td><td>loosen and tighten<br/>each bolt</td><td>deserrer et serrer<br/>vis par vis</td><td>aflojar y apretar<br/>tornillo a tornillo</td></tr><tr><td>●</td><td>Setzzeit</td><td>relaxation time</td><td>durée de tassement</td><td>tiempo de espera</td></tr><tr><td>➤</td><td>Drehwinkel</td><td>torque angle</td><td>angle de serrage</td><td>ángulo de giro</td></tr></table> |                                                |                                                                         |                                                                                                   | ✱                                               | neue Zylinderkopf-<br>schrauben verwenden | use new cylinder<br>head bolts | utiliser des vis<br>neuves | emplar tornillos nuevos | ★                         | Warmlauf (80°C) | warm up time (80°C) | chauffage (80°C) | calentamiento (80°C) | ☐ | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt | deserrer et serrer<br>vis par vis | aflojar y apretar<br>tornillo a tornillo | ● | Setzzeit | relaxation time | durée de tassement | tiempo de espera | ➤ | Drehwinkel | torque angle | angle de serrage | ángulo de giro |
| ✱                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | neue Zylinderkopf-<br>schrauben verwenden      | use new cylinder<br>head bolts                                          | utiliser des vis<br>neuves                                                                        | emplar tornillos nuevos                         |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ★                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Warmlauf (80°C)                                | warm up time (80°C)                                                     | chauffage (80°C)                                                                                  | calentamiento (80°C)                            |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ☐                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt                                         | deserrer et serrer<br>vis par vis                                                                 | aflojar y apretar<br>tornillo a tornillo        |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ●                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Setzzeit                                       | relaxation time                                                         | durée de tassement                                                                                | tiempo de espera                                |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ➤                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Drehwinkel                                     | torque angle                                                            | angle de serrage                                                                                  | ángulo de giro                                  |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ✱ 1,6 mm, Ø 78,5 mm, 5 Löcher/holes/trous/agujero                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Mot.: CK                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| 1,5 ltr. Diesel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Golf, Jetta, Passat                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                |                                                                         |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                | <b>*094.561*</b>                                                        |                                                                                                   |                                                 |                                           |                                |                            |                         |                           |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |