# Anziehvorschrift Zylinderkopf
# Tightening Instructions for Cylinder Head
# Instructions de serrage pour culasse
# Prescripciones de apriete para culatas

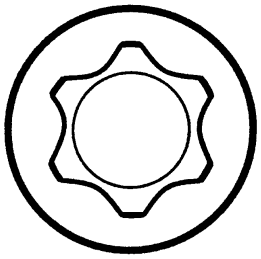
**612.332**

passend für / suitable for
adaptable à / adaptable a

**Mercedes-Benz**

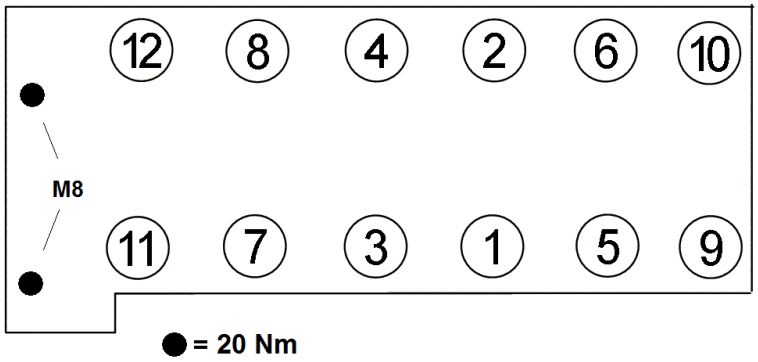
Das Original

Schraubenkopf / Head shape
Tête de vis / Cabeza de tornillo



760.120
M 12x1,75x102

Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete




| Anziehen/ Tightening/ Serrage/ Apriete | OM 612 | OM 612.990 | OM 647.961/981 |
|---|---|---|---|
| | ⚙ 60 Nm | ⚙ 30 Nm | ⚙ 15 Nm |
| | M8 = 20 Nm | M8 = 20 Nm | 60 Nm |
| | ➢ 90° | 70 Nm | M8 = 20 Nm |
| | M8 = 20 Nm | M8 = 20 Nm | ➢ 90° |
| | ➢ 90° | ➢ 90° | M8 = 20 Nm |
| | | ➢ 90° | ➢ 90° |

Zeichenerklärung / Explanations / Explication / Explicacion

| | | | | |
|---|---|---|---|---|
| ⚙ | neue Zylinderkopf-schrauben verwenden | use new cylinder head bolts | utiliser des vis neuves | emplar tornillos nuevos |
| ✱ | Warmlauf (80°C) | warm up time (80°C) | chauffage (80°C) | calentamiento (80°C) |
| ❐ | Schrauben einzeln lösen und wieder anziehen | loosen and tighten each bolt | deserrer et serrer vis par vis | aflojar y apretar tornillo a tornillo |
| ● | Setzzeit | relaxation time | durée de tassement | tiempo de espera |
| ➢ | Drehwinkel | torque angle | angle de serrage | ángulo de giro |

## Motortyp / Engine type / Type de moteur / Tipo de motor

1,40 mm ÷

Mot: OM 612.961/962/963/966/967/981/983/990
OM 647.961/981

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