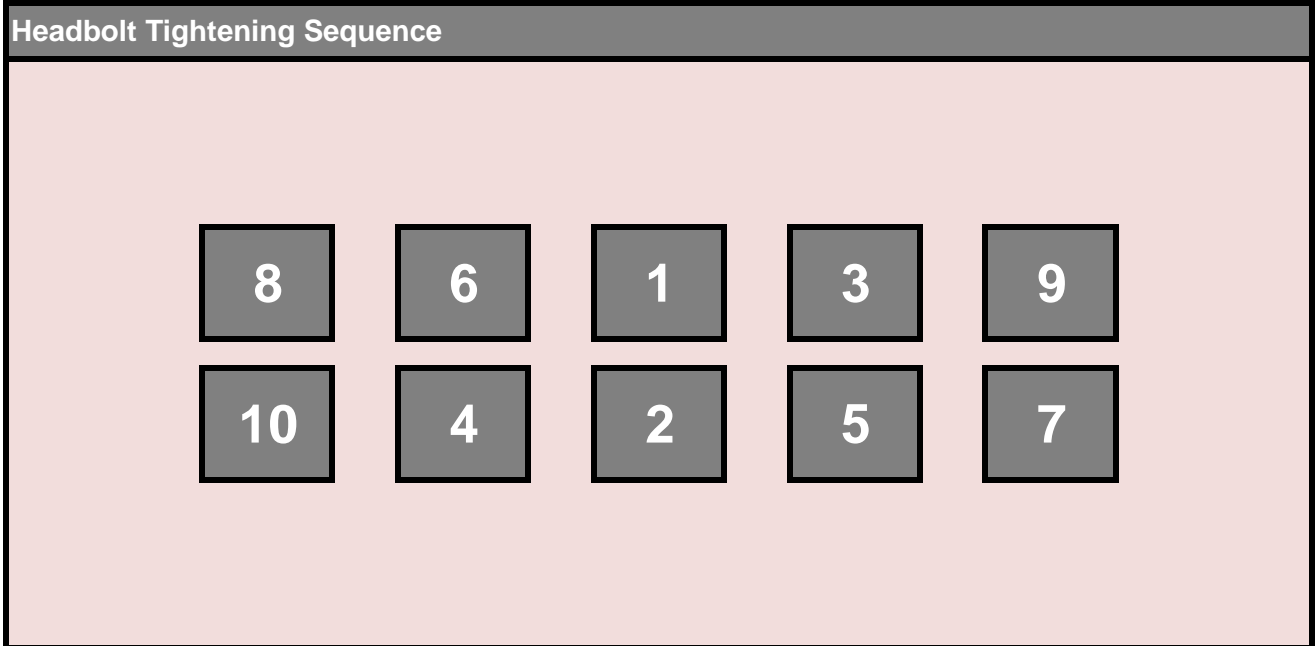


# Cylinder Head Tightening Instructions

## HG1534



	1	2	3	4	5	6
<b>Reference</b>	HG1534					
<b>Piston</b>						



### Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
<b>Bolt Type 1</b>									
Kilos	2.5 Kpm	5 Kpm	-90°+5 Kpm	+90°					
Pounds	18 lbft	36 lbft	-90°+36 lbft	+90°					
Newton M's	24.5 Nm	49 Nm	-90°+49 Nm	+90°					
<b>Bolt Type 2</b>									
Kilos									
Pounds									
Newton M's									
<b>Bolt Type 3</b>									
Kilos									
Pounds									
Newton M's									
<b>Bolt Type 4</b>									
Kilos									
Pounds									
Newton M's									

Fitment Key	Description of Required Procedure
<b>-/+ X°</b>	Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.
<b>&lt;&gt;</b>	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.
<b>Retighten?</b>	If required, should be performed between 620-930 Miles (1000-1500 Km).

