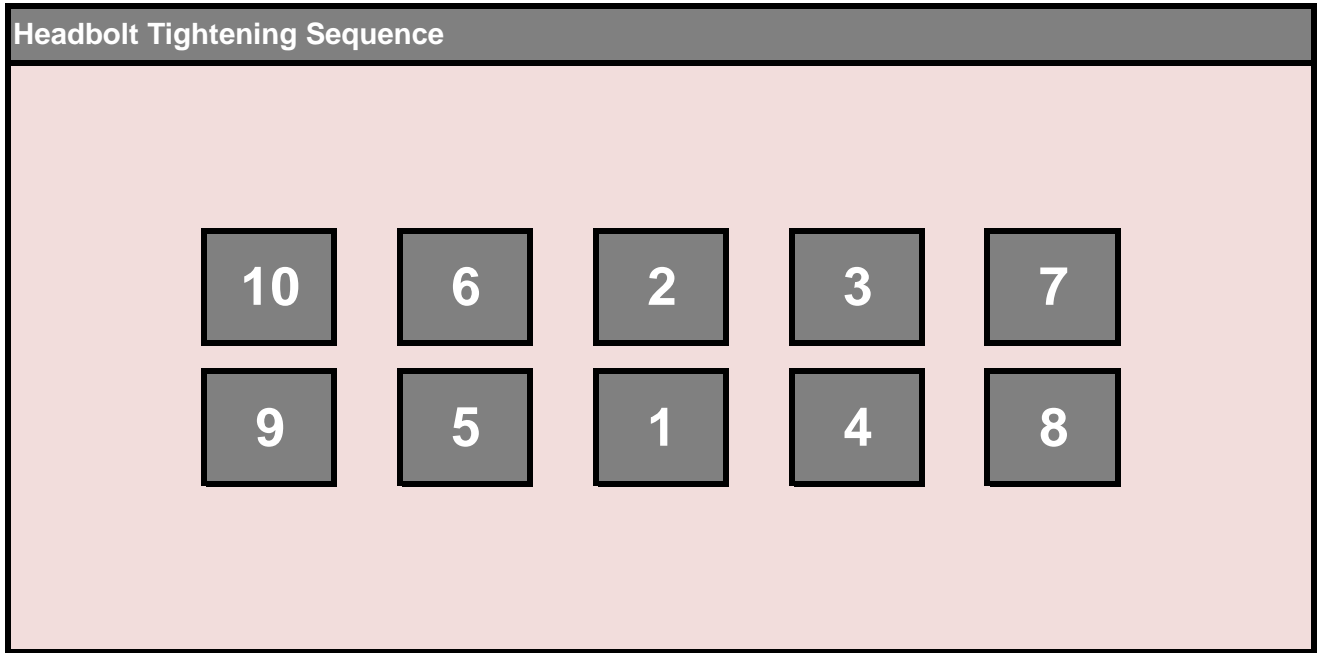


Cylinder Head Tightening Instructions

HG233



	1	2	3	4	5	6
Reference	HG233					
Piston						



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retightening
 Bolt Type 1	Kilos Pounds Newton M's	2 Kpm 15 lbft 19.6 Nm	+120° +120° +120°	+120° +120° +120°					
 Bolt Type 2	Kilos Pounds Newton M's								
 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).

