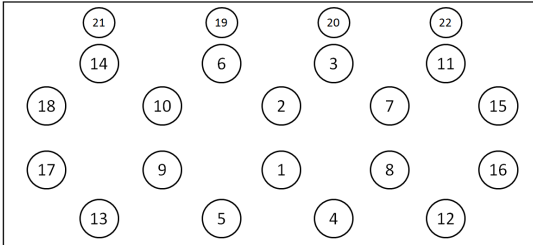


|                                                                                   |                                                                                                                           |                                                                          |                                                                                                   |                                       |
|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                                                                                           | <b>541.762</b>                                                           | <br>Das Original |                                       |
| <b>Tightening Instructions for Cylinder Head</b>                                  |                                                                                                                           | passend für / suitable for<br>adaptable à / adaptable a<br><br><b>GM</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                    |                                                                                                                           | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete  |                                                                                                   |                                       |
|  |                                                                                                                           |                                                                          |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | <div><div>✱</div><div>M12<br/>Pos. 1-18: 50 Nm<br/>Pos. 1-18: 80 Nm<br/>➤ Pos. 1-18: 60°<br/>➤ Pos. 1-18: 60°</div></div> | <div><div>M8<br/>Pos. 19-22: 25 Nm</div></div>                           |                                                                                                   |                                       |
| 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                        |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                    |                                                                                                                           |                                                                          |                                                                                                   |                                       |
| Ø: 105,36 mm; $\frac{1}{2}$ : 1,00 mm; RH                                         |                                                                                                                           |                                                                          |                                                                                                   |                                       |
| Mot: V8 Duramax<br>6.6 ltr.                                                       |                                                                                                                           |                                                                          |                                                                                                   |                                       |
| GMT 900, 610, 560                                                                 |                                                                                                                           |                                                                          |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                                                                                           |                                                                          | <b>*541.762*</b>                                                                                  |                                       |