

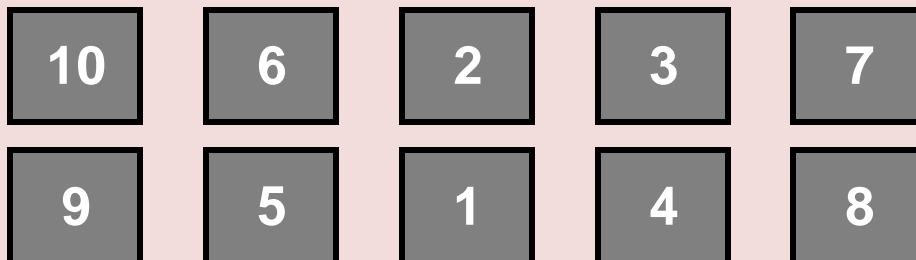
# Cylinder Head Tightening Instructions

# HG1186



	1	2	3	4	5	6
Reference	HG1186	HG234				
Piston						

## Headbolt Tightening Sequence



## Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retightening
<b> Bolt Type 1</b>									
Kilos	2 Kpm	+120°	+120°						No
Pounds	15 lbft	+120°	+120°						No
Newton M's	19.6 Nm	+120°	+120°						No
<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>↔</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).