

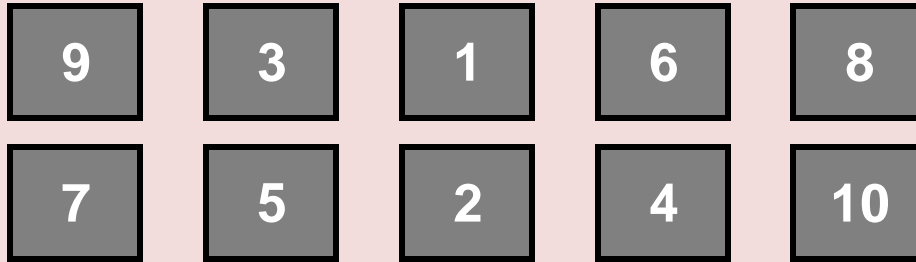
Cylinder Head Tightening Instructions

HG1510



	1	2	3	4	5	6
Reference	HG1510					
Piston						

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Bolt Type 1									
Kilos	5 Kpm	10 Kpm	-180°	4 Kpm	+80°	+80°			
Pounds	36 lbft	72 lbft	-180°	29 lbft	+80°	+80°			
Newton M's	49 Nm	98 Nm	-180°	39.2 Nm	+80°	+80°			
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).