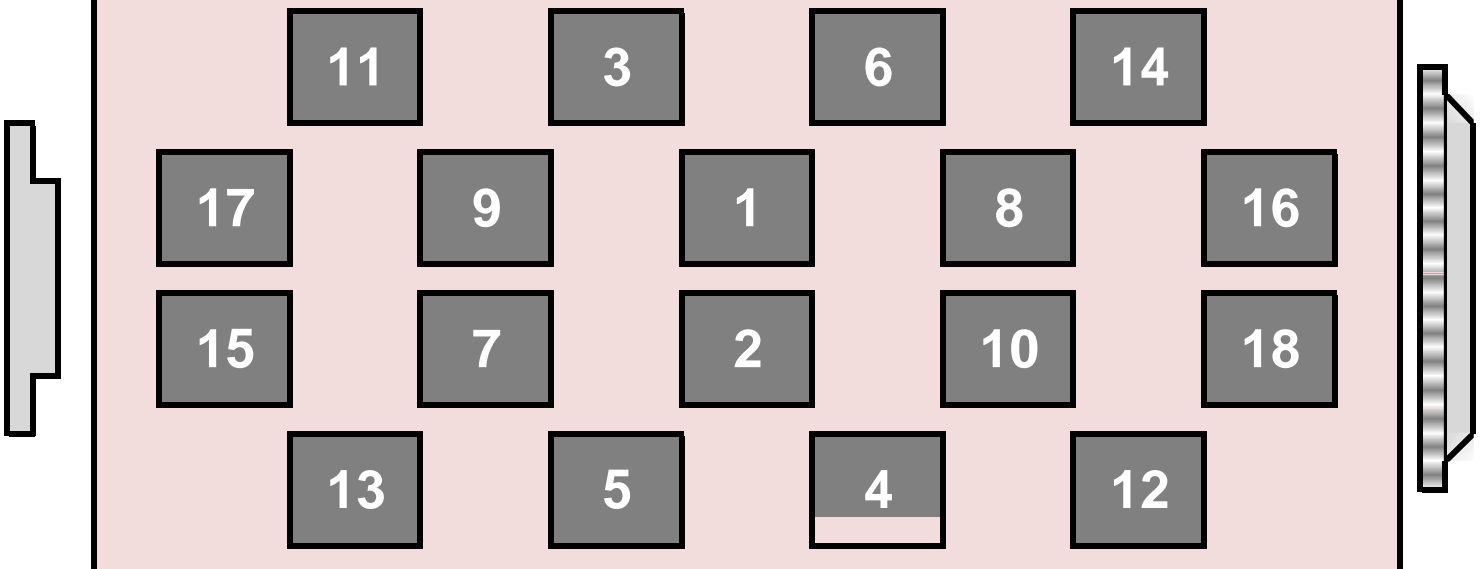


Cylinder Head Tightening Instructions **HG1827E**



	1	2	3	4	5	6
Reference	HG1827	HG1827A	HG1827B	HG1827C	HG1827D	HG1827E
Piston	0.230-0.255	0.256-0.280	0.281-0.305	0.306-0.330	0.331-0.355	0.356-0.400

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Bot Type 1									
Kilos	4 Kpm	+180°	-90°+4 Kpm	+90°	+90°				
Pounds	29 lbft	+180°	-90°+29 lbft	+90°	+90°				
Newton M's	39.2 Nm	+180°	-90°+39.2 Nm	+90°	+90°				
Bot Type 2									
Kilos									
Pounds									
Newton M's									
Bot Type 3									
Kilos									
Pounds									
Newton M's									
Bot 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).