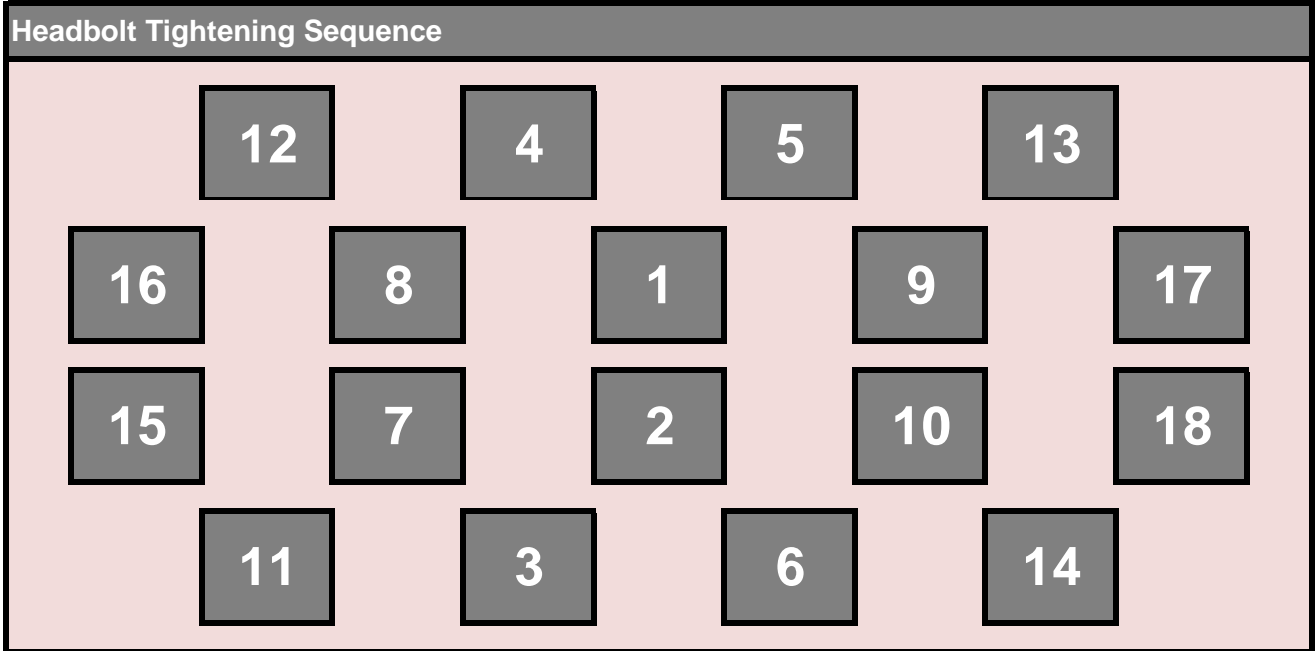


Cylinder Head Tightening Instructions

HG2102



	1	2	3	4	5	6
Reference	HG2102					
Piston						



Fitment Procedure		Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Botl Type 1	Kilos	3 Kpm	-90°+3 Kpm	+105°	+105°					
	Pounds	22 lbft	-90°+22 lbft	+105°	+105°					
	Newton M's									
Botl Type 2	Kilos									
	Pounds									
	Newton M's									
Botl Type 3	Kilos									
	Pounds									
	Newton M's									
Botl 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).