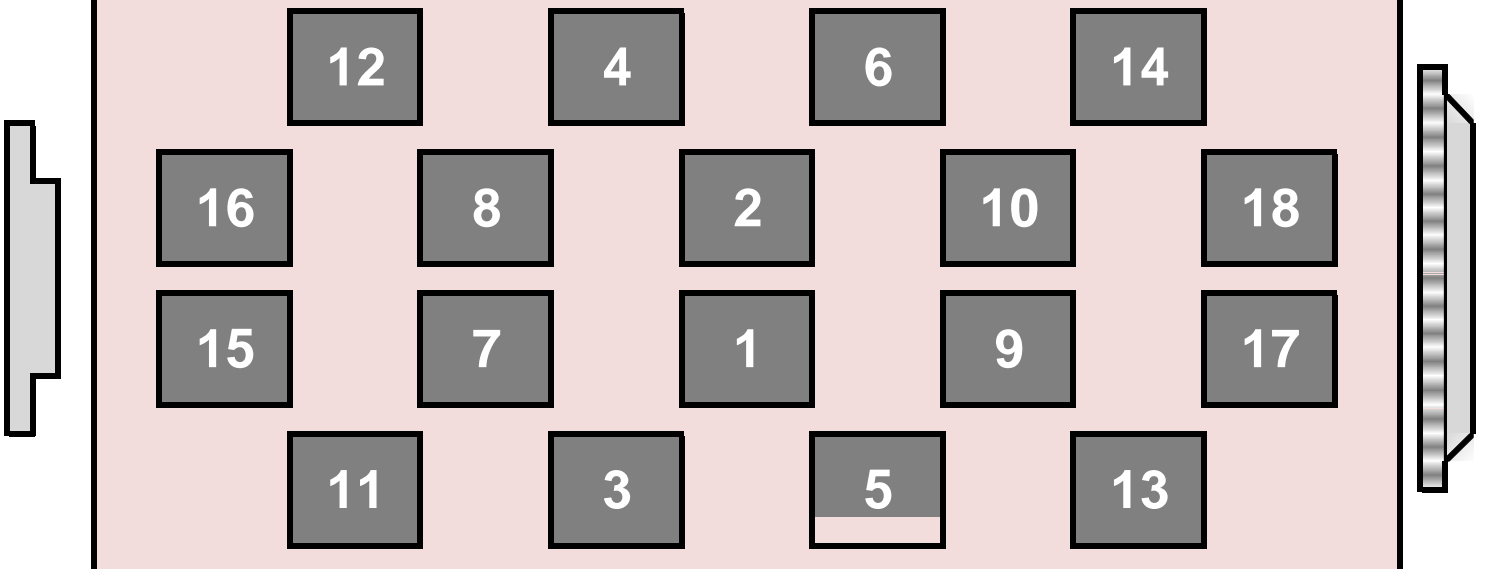


Cylinder Head Tightening Instructions **HG2119B**



	1	2	3	4	5	6
Reference	HG2119A	HG2119B				
Piston						

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	5 Kpm	-90°+5 Kpm	+120°	+90°					
Pounds	36 lbft	-90°+36 lbft	+120°	+90°					
Newton M's	49 Nm	-90°+49 Nm	+120°	+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).