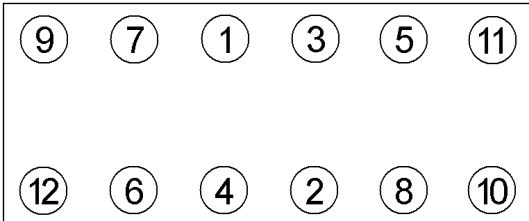


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                             |                                                                                   |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|---------------------------------------|-----------------------------|-------------------------|-------------------------|-----|-----------------|---------------------|------------------|----------------------|---|---------------------------------------------|------------------------------|--------------------------------|---------------------------------------|---|----------|-----------------|--------------------|------------------|---|------------|--------------|------------------|----------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                             | <b>184.931</b>                                                                    | <br>Das Original |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                             | passend für / suitable for                                                        |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Instructions de serrage pour culasse</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                             | adaptable à / adaptable a                                                         |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Prescripciones de apriete para culatas</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                             | <b>Fiat / Alfa Romeo</b>                                                          |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                             |  |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 152.760<br>M12x1,25x218                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                             |                                                                                   |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>Anziehen/</td><td>*</td><td>65 Nm</td></tr><tr><td>Tightening/</td><td>➤</td><td>90°</td></tr><tr><td>Serrage/</td><td>➤</td><td>90°</td></tr><tr><td>Apriete</td><td>➤</td><td>90°</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                             |                                                                                   |                                                                                                   | Anziehen/                             | *                                     | 65 Nm                       | Tightening/             | ➤                       | 90° | Serrage/        | ➤                   | 90°              | Apriete              | ➤ | 90°                                         |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Anziehen/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | *                                           | 65 Nm                                                                             |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Tightening/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | ➤                                           | 90°                                                                               |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Serrage/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | ➤                                           | 90°                                                                               |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | ➤                                           | 90°                                                                               |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Zeichenerklärung / Explanations / Explication / Explicacion</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                             |                                                                                   |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>✱</td><td>neue Zylinderkopf-schrauben verwenden</td><td>use new cylinder head bolts</td><td>utiliser des vis neuves</td><td>emplar tornillos nuevos</td></tr><tr><td>★</td><td>Warmlauf (80°C)</td><td>warm up time (80°C)</td><td>chauffage (80°C)</td><td>calentamiento (80°C)</td></tr><tr><td>□</td><td>Schrauben einzeln lösen und wieder anziehen</td><td>loosen and tighten each bolt</td><td>deserrer et serrer vis par vis</td><td>aflojar y apretar tornillo a tornillo</td></tr><tr><td>●</td><td>Setzzeit</td><td>relaxation time</td><td>durée de tassement</td><td>tiempo de espera</td></tr><tr><td>➤</td><td>Drehwinkel</td><td>torque angle</td><td>angle de serrage</td><td>ángulo de giro</td></tr></table> |                                             |                                                                                   |                                                                                                   | ✱                                     | neue Zylinderkopf-schrauben verwenden | use new cylinder head bolts | utiliser des vis neuves | emplar tornillos nuevos | ★   | Warmlauf (80°C) | warm up time (80°C) | chauffage (80°C) | calentamiento (80°C) | □ | Schrauben einzeln lösen und wieder anziehen | loosen and tighten each bolt | deserrer et serrer vis par vis | aflojar y apretar tornillo a tornillo | ● | Setzzeit | relaxation time | durée de tassement | tiempo de espera | ➤ | Drehwinkel | torque angle | angle de serrage | ángulo de giro |
| ✱                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | neue Zylinderkopf-schrauben verwenden       | use new cylinder head bolts                                                       | utiliser des vis neuves                                                                           | emplar tornillos nuevos               |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ★                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Warmlauf (80°C)                             | warm up time (80°C)                                                               | chauffage (80°C)                                                                                  | calentamiento (80°C)                  |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| □                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Schrauben einzeln lösen und wieder anziehen | loosen and tighten each bolt                                                      | deserrer et serrer vis par vis                                                                    | aflojar y apretar tornillo a tornillo |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ●                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Setzzeit                                    | relaxation time                                                                   | durée de tassement                                                                                | tiempo de espera                      |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ➤                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Drehwinkel                                  | torque angle                                                                      | angle de serrage                                                                                  | ángulo de giro                        |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             |                                                                                   |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 1,80 mm ÷<br>Marea, Kappa, Lybra<br>Mot. 138.A6.000, 838.A8.000<br><br>Alfa 156, 166<br>Mot. AR 32501                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                             |                                                                                   |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             | <b>*184.931*</b>                                                                  |                                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |