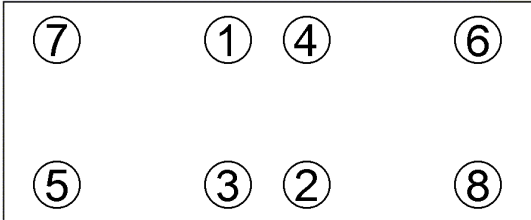


|                                                                                                                |                                                                 |                                                                                   |                                                                                                   |                                       |
|----------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                       |                                                                 | <b>194.460</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>MAN</b>                                                                        |                                                                                                   |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                 |                                                                 | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                                                                                   |                                       |
| <br><br>820.245<br>S 14 x 140 |                                                                 |  |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                | E08 industry<br>with cylinder-liner<br>10 Nm<br>80 Nm<br>150 Nm | E0836 LOH<br>truck-engine<br>10 Nm<br>80 Nm<br>150 Nm<br>➤ 90°<br>➤ 90°<br>➤ 90°  |                                                                                                   |                                       |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                    |                                                                 |                                                                                   |                                                                                                   |                                       |
| ✱                                                                                                              | 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>                                                 |                                                                 |                                                                                   |                                                                                                   |                                       |
| Mot. E0824 E<br>E0834 E/LE<br>E0826 E<br>E0836 E/LE<br>E0836 LOH                                               |                                                                 |                                                                                   |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                 |                                                                 |                                                                                   | <b>*194.460*</b>                                                                                  |                                       |