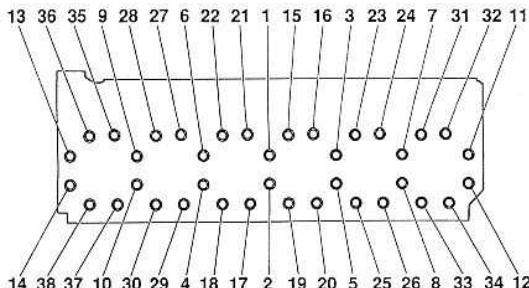


|                                                                                                                                        |                                                |                                                                                               |                                                                                                   |                                          |
|----------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-----------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                               |                                                | <b>115.151</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>VOLVO</b> | <br>Das Original |                                          |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                       |                                                |                                                                                               |                                                                                                   |                                          |
| <b>Instructions de serrage pour culasse</b>                                                                                            |                                                |                                                                                               |                                                                                                   |                                          |
| <b>Prescripciones de apriete para culatas</b>                                                                                          |                                                |                                                                                               |                                                                                                   |                                          |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                         |                                                | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                       |                                                                                                   |                                          |
| <br><br>136.680<br>M 16x2,0x199                       |                                                |              |                                                                                                   |                                          |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                        |                                                | * 60 Nm<br>60 Nm (Kontrolle)<br>➤ 90°<br>➤ 90°                                                |                                                                                                   |                                          |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                            |                                                |                                                                                               |                                                                                                   |                                          |
| *                                                                                                                                      | neue Zylinderkopf-<br>schrauben verwenden      | use new cylinder<br>head bolts                                                                | utiliser des vis<br>neuves                                                                        | emplar tornillos nuevos                  |
| ★                                                                                                                                      | Warmlauf (80°C)                                | warm up time (80°C)                                                                           | chauffage (80°C)                                                                                  | calentamiento (80°C)                     |
| □                                                                                                                                      | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt                                                               | deserrer et serrer<br>vis par vis                                                                 | aflojar y apretar<br>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. D 12 A/C/D<br>12,1 ltr<br>265-368 kW (340-520 PS)<br><br>FH12, FL12, FM12, NH12, B12B<br><br>Ø: 147,3 mm; $\frac{1}{2}$ : 1,25 mm |                                                |                                                                                               |                                                                                                   |                                          |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                         |                                                |                                                                                               | <b>*115.151*</b>                                                                                  |                                          |