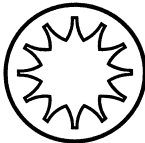
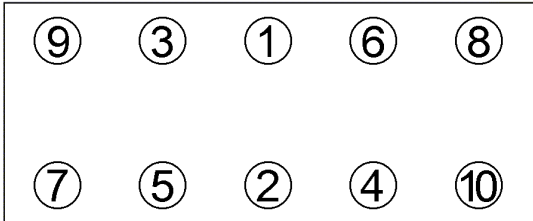


|                                                                                   |                                                |                                                                                   |                                                                                   |                                          |
|-----------------------------------------------------------------------------------|------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                | <b>252.750</b>                                                                    |  | <b>Das Original</b>                      |
| <b>Tightening Instructions for Cylinder Head</b>                                  |                                                | passend für / suitable for<br>adaptable à / adaptable a                           |                                                                                   |                                          |
| <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           |                                                                                   |                                          |
|  |                                                |  |                                                                                   |                                          |
| 864.450<br>M 12x1,75x209                                                          |                                                |                                                                                   |                                                                                   |                                          |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | *<br>➤<br>➤<br>➤                               | 30 Nm<br>40 Nm<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>                    |                                                |                                                                                   |                                                                                   |                                          |
| ✱ 1,63mm Ø 82mm 2-Loch/holes/trous/agujero                                        |                                                |                                                                                   |                                                                                   |                                          |
| Mot.: 2,0l TDI EA288 evo                                                          |                                                |                                                                                   |                                                                                   |                                          |
| A4, A5, A6, Q5                                                                    |                                                |                                                                                   |                                                                                   |                                          |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                |                                                                                   | <b>*252.750*</b>                                                                  |                                          |