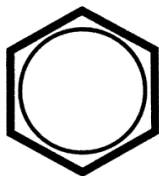
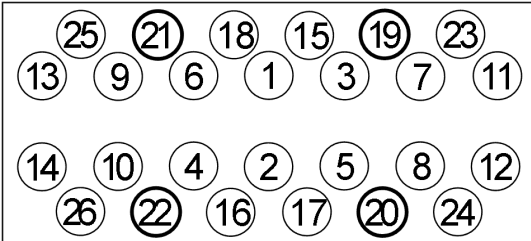


|                                                                                                                                                                                                                                                         |                                                                                                                                          |                                                                                                                             |                                                                                                                               |                                                                                                                                   |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                |                                                                                                                                          | <b>225.100</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>Volvo</b>                               | <br><b>Das Original</b>                      |                                                                                                                                   |
| <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>542.360<br>M 16x2,0x199                                                                                                                                        |                                                                                                                                          |                                            |                                                                                                                               |                                                                                                                                   |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                         | *<br><br>➤<br>➤                                                                                                                          | Volvo: D9A<br>30 Nm<br>60 Nm<br>90°<br>90°                                                                                  | Volvo: D11A/B<br>*<br>65 Nm<br>65 Nm (Kontrolle)<br>➤ 120°<br>➤ 90°                                                           | R.V.I.: DXi11<br>*<br>Pos. 19-22:<br>25 Nm<br>Pos. 1-26:<br>30 Nm<br>65 Nm<br>➤ 120°<br>➤ 90°                                     |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                             |                                                                                                                                          |                                                                                                                             |                                                                                                                               |                                                                                                                                   |
| *<br>★<br>□<br>●<br>➤                                                                                                                                                                                                                                   | neue Zylinderkopf-<br>schrauben verwenden<br>Warmlauf (80°C)<br>Schrauben einzeln lösen<br>und wieder anziehen<br>Setzzeit<br>Drehwinkel | use new cylinder<br>head bolts<br>warm up time (80°C)<br>loosen and tighten<br>each bolt<br>relaxation time<br>torque angle | utiliser des vis<br>neuves<br>chauffage (80°C)<br>deserrer et serrer<br>vis par vis<br>durée de tassement<br>angle de serrage | emplar tornillos nuevos<br>calentamiento (80°C)<br>aflojar y apretar<br>tornillo a tornillo<br>tiempo de espera<br>ángulo de giro |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b><br><br>Ø: 136 mm; $\frac{1}{2}$ : 1,25 mm<br><br>Mot: D9A, D11A, DXi11<br>9,4 ltr-10,8 ltr<br>191-331 kW (260-450PS)<br><br>FM, FM 9, 7700 ab 12/2001 →<br>Kerax, Premium 2 ab 10/2005 → |                                                                                                                                          |                                                                                                                             |                                                                                                                               |                                                                                                                                   |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                          |                                                                                                                                          |                                                                                                                             | <b>*225.100*</b>                                                                                                              |                                                                                                                                   |