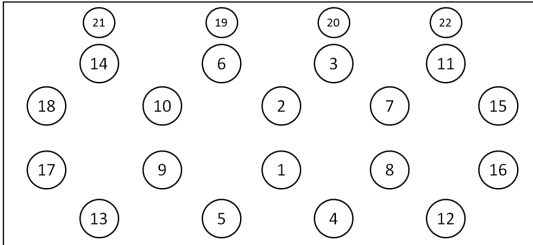


|                                                                                   |                                                                                                                           |                                                                          |                                                                                                   |
|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                                                                                           | <b>541.782</b>                                                           | <br>Das Original |
| <b>Tightening Instructions for Cylinder Head</b>                                  |                                                                                                                           | passend für / suitable for<br>adaptable à / adaptable a<br><br><b>GM</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  |                                                                                                   |
|  |                                                                                                                           |                                                                          |                                                                                                   |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | <div><div>*</div><div>M12<br/>Pos. 1-18: 50 Nm<br/>Pos. 1-18: 80 Nm<br/>➤ Pos. 1-18: 60°<br/>➤ Pos. 1-18: 60°</div></div> | <div><div>M8<br/>Pos. 19-22: 25 Nm</div></div>                           |                                                                                                   |
| Zeichenerklärung / Explanations / Explication / Explicacion                       |                                                                                                                           |                                                                          |                                                                                                   |
| <div><div>✱</div><div>neue Zylinderkopf-schrauben verwenden</div></div>           | <div><div></div><div>use new cylinder head bolts</div></div>                                                              | <div><div></div><div>utiliser des vis neuves</div></div>                 | <div><div></div><div>emplar tornillos nuevos</div></div>                                          |
| <div><div>★</div><div>Warmlauf (80°C)</div></div>                                 | <div><div></div><div>warm up time (80°C)</div></div>                                                                      | <div><div></div><div>chauffage (80°C)</div></div>                        | <div><div></div><div>calentamiento (80°C)</div></div>                                             |
| <div><div>☐</div><div>Schrauben einzeln lösen und wieder anziehen</div></div>     | <div><div></div><div>loosen and tighten each bolt</div></div>                                                             | <div><div></div><div>deserrer et serrer vis par vis</div></div>          | <div><div></div><div>aflojar y apretar tornillo a tornillo</div></div>                            |
| <div><div>●</div><div>Setzzeit</div></div>                                        | <div><div></div><div>relaxation time</div></div>                                                                          | <div><div></div><div>durée de tassement</div></div>                      | <div><div></div><div>tiempo de espera</div></div>                                                 |
| <div><div>➤</div><div>Drehwinkel</div></div>                                      | <div><div></div><div>torque angle</div></div>                                                                             | <div><div></div><div>angle de serrage</div></div>                        | <div><div></div><div>ángulo de giro</div></div>                                                   |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                    |                                                                                                                           |                                                                          |                                                                                                   |
| Ø: 105,36 mm; $\frac{1}{2}$ : 0,95 mm; LH                                         |                                                                                                                           |                                                                          |                                                                                                   |
| Mot: V8 Duramax<br>6.6 ltr.                                                       |                                                                                                                           |                                                                          |                                                                                                   |
| GMT 900, 610, 560                                                                 |                                                                                                                           |                                                                          |                                                                                                   |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                                                                                           | <b>*541.782*</b>                                                         |                                                                                                   |