

|                                                                                   |                                                |                                                                                                                                                                                                                                                               |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
|-----------------------------------------------------------------------------------|------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|---------------------------------------------------------------------------------------------------|----|---|---|---|---|---|---|---|---|---|---|---|---|---|---|----|---|---|---|---|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                | <b>538.140</b>                                                                                                                                                                                                                                                |                                   | <br>Das Original |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| <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>                                     |                                                | <b>Mercedes-Benz</b>                                                                                                                                                                                                                                          |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                    |                                                | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                                                                                                                                                                       |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
|  |                                                | <table><tr><td>10</td><td>6</td><td>2</td><td>4</td><td>8</td></tr><tr><td>9</td><td>5</td><td>1</td><td>3</td><td>7</td></tr><tr><td>9</td><td>5</td><td>1</td><td>3</td><td>7</td></tr><tr><td>10</td><td>6</td><td>2</td><td>4</td><td>8</td></tr></table> |                                   |                                                                                                   | 10 | 6 | 2 | 4 | 8 | 9 | 5 | 1 | 3 | 7 | 9 | 5 | 1 | 3 | 7 | 10 | 6 | 2 | 4 | 8 |
| 10                                                                                | 6                                              | 2                                                                                                                                                                                                                                                             | 4                                 | 8                                                                                                 |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| 9                                                                                 | 5                                              | 1                                                                                                                                                                                                                                                             | 3                                 | 7                                                                                                 |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| 9                                                                                 | 5                                              | 1                                                                                                                                                                                                                                                             | 3                                 | 7                                                                                                 |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| 10                                                                                | 6                                              | 2                                                                                                                                                                                                                                                             | 4                                 | 8                                                                                                 |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   |                                                | M 12<br>10 Nm<br>60 Nm<br>➤ 90°<br>➤ 90°<br>➤ 90°                                                                                                                                                                                                             |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
|                                                                                   |                                                | M 8<br>20 Nm                                                                                                                                                                                                                                                  |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| 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>                    |                                                |                                                                                                                                                                                                                                                               |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| OM 629.910/911/912                                                                |                                                |                                                                                                                                                                                                                                                               |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| links/left 1,2 mm                                                                 |                                                |                                                                                                                                                                                                                                                               |                                   |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                |                                                                                                                                                                                                                                                               | <b>*538.140*</b>                  |                                                                                                   |    |   |   |   |   |   |   |   |   |   |   |   |   |   |   |    |   |   |   |   |