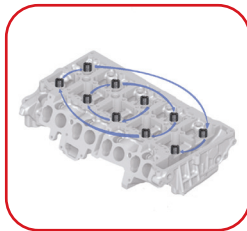
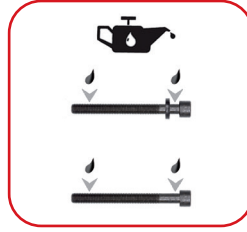
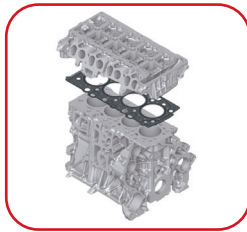
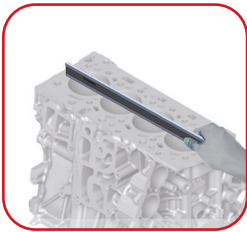
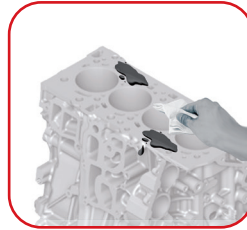
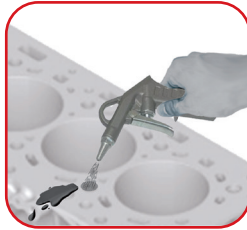
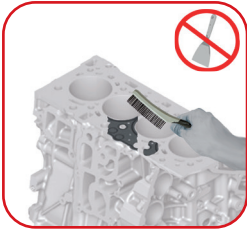




We emphasize that all spare parts must be installed by trained and specialized staff.  
Wir weisen ausdrücklich darauf hin dass alle Ersatzteile von geschultem Fachpersonal eingebaut werden müssen.  
Toutes les pièces de rechange doivent être montées par du personnel qualifié, formé à cet effet.  
Vi ricordiamo che tutte le parti di ricambio devono essere montate da personale specializzato.



Gaskets must be installed according to the engine manufacturer's instructions. These recommendations are issued in conformity with our latest technical data, and excludes all warranties.

Für den Einbau der Dichtungen sind die Vorschriften des Motorenherstellers verbindlich. Die vorliegenden Einbaulinien sind unter Ausschuss jeglicher Gewährleistung nach aktuellem Stand erstellt.

Respecter les instructions de montage indiquées sur cette notice ou le cas échéant par le constructeur. Les présentes instructions de montage ont été établies conformément aux dernières connaissances techniques avec exclusion de garantie.

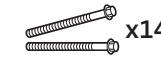
Per il montaggio sono impegnative le istruzioni del produttore del motore. Le presenti istruzioni di montaggio sono state preparate con le informazioni disponibili in data, con esclusione di ogni garanzia.

# TIGHTENING NOTICE FOR CYLINDER HEAD BOLTS

MONTAGEANLEITUNG FÜR ZYLINDERKOPFSCHRAUBEN  
NOTICE DE SERRAGE DES VIS DE CULASSE  
ISTRUZIONI DI SERRAGGIO PER VITI DI TESTATA






**016091B**



x14



M12 x 175 - L. 102


 		
MERCEDES-BENZ	E-CLASS - S-CLASS	OM 613.960/961 OM 648.960/961


**ALWAYS FIT NEW CYLINDER HEAD BOLTS  
ZYLINDERKOPFSCHRAUBEN IMMER ERNEUERN  
TOUJOURS REMPLACER LES VIS DE CULASSE PAR DES NEUVES  
SOSTITUIRE SEMPRE LE VITI DELLA TESTA CILINDRI**

Anzugsrichtlinie & Anzugsreihenfolge | Phases de serrage & Ordre de serrage | Fase di serraggio & Ordine di serraggio

## PHASE & ORDER OF TIGHTENING

OM 648.960 (S-CLASS - 320 CDI)  
OM 648.961 (E-CLASS - 280 CDI, 320 CDI)

1.  + 15 N.m

2.  + 60 N.m

3.  $\partial$  + 90°

4.  $\partial$  + 90°



OM 613.960 (S-CLASS - 320 CDI)  
OM 613.961 (E-CLASS - 320 CDI)

1.  + 60 N.m



2.  $\partial$  + 90°

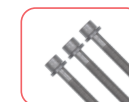
3.  $\partial$  + 90°



Anzugsrichtlinie | Type de serrage | Tipo di serraggio

## TYPE OF TIGHTENING

	EN	DE	FR	IT
	Torque Nm	Drehmoment Nm	Couple de serrage Nm	Coppia di serraggio Nm
$\partial$	Angular	Winkel	Angulaire	Angolare
	Angular loosening	Winckliges Lösen	Desserrage angulaire	Allentamento angolare
	Loosen	Lockern	Desserrer	Allentare
	Heat	Hitze	A chaud	Scaldare
	Cool	Kühl	A froid	Raffreddare
(1 - 4)	Headbolt position	Position Zylinderkopfschrauben	Position des vis de culasse	Posizione delle viti
	Kilometre / Miles	Kilometer / Miles	Kilomètre / Miles	Chilometro / Miles
	Wait	Warten	Attendre	Attesa
	RPM Revolutions per minute	U/M. Umdrehungen pro Minute	TR/MN Tours par minutes	G/M Giri al minuto



**016091B**



x14



M12 x 175 - L. 102