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TECHNICAL REPORT

Assembly procedure for
cylinder head cover gasket
set 56044000 on PSA-BMW
(MINI) engines



01 introduction

The purpose of this technical report is to provide the required steps and considerations for the correct installation of the gaskets included in set 56044000, corresponding to the Cylinder head cover gasket on 1.4L and 1.6L PSA-BMW petrol engines, 4-cylinder, fitted on PSA (Citroën and Peugeot) and MINI vehicles produced from 2012 to the present.

This gasket set is used on engines installed in the following vehicle ranges:

Peugeot: 208, 508, 508 SW, 308 CC, 207 / 207+, 207 SW, 207 CC, 308, 308 SW, 3008, 5008, Partner / Partner Tepee, 408, 2008

Citroën: C4 II, C3 Picasso, C3 II, C4 Picasso I / Grand Picasso I, DS3, DS4, C4 Coupé, C4 I, C5 III / Break, Berlingo, C4 Picasso II / Grand Picasso II

MINI: Hatch, Clubman, Countryman, Paceman, Cabrio, Coupé, Roadster,

This gasket set is compatible with the following engines:

PSA (Peugeot and Citroën)

EP3 (1.4L): EP3, EP3C.

EP6 (1.6L): EP6, EP6B, EP6C, EP6CB, EP6CM.

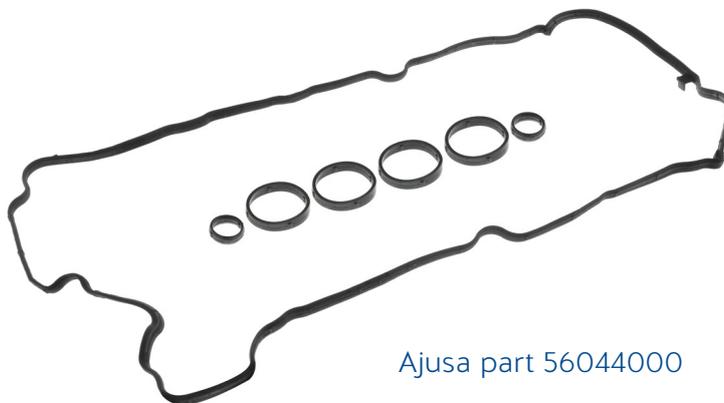
NFU (1.6L): TU5JP4.

MINI

N12 B16 A (1.6L)

N16 B16 A (1.6L)

N12 B14 A (1.4 L)



Ajusa part 56044000

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02 prior considerations

Before installing the gasket, the following aspects must be taken into account:

01 | Verify correct application. Confirm that the gasket matches the Cylinder head cover and engine variant of the vehicle. Refer to our online catalogue.

02 | Inspection of cylinder head cover and cylinder head. Ensure all mating surfaces are in good condition, free from warping, cracks, or surface defects.

03 | Cleaning of mating surfaces. Remove all residues from the previous gasket, dirt, and oil before positioning the new gasket.

04 | Click the button to access the full **assembly video tutorial** on our YouTube channel. If you have any questions, leave a comment below!



03 assembly

01 | Preparation of materials and surfaces

Required materials:

Cylinder head cover gasket kit with Ajusa reference 56044000

Silicone sealant with Ajusa reference 75000100 (200 ml) y 75000200 (75 ml).

Before reinstalling the Cylinder head cover onto the cylinder head, the following preliminary steps must be performed to achieve optimal sealing:

Clean the mating surfaces of the cylinder head and cylinder head cover to remove contaminants that may compromise sealing performance (Image 1). Use a clean cloth to remove grease and residues.

Remove all traces of old sealant at the “S” points indicated in the figure.

Clean the sealing areas around the four ignition-coil passages and the tightening screw passages.

Check the integrity and deformation of the cylinder head cover. Replace it if damaged or warped.



Image 1: cylinder head cleaning areas

02 | Assembly procedure

Once the cylinder head cover is completely clean and free from old sealant, install the new gasket, the four coil-pack seals, and the two seals for the central screw. Ensure uniform placement inside their grooves with no twists, deformation, or stretching.



Apply sealant on the "S" points shown in Image 2. Apply a bead of Ajusil 75000100 or 75000200, 20 mm long and 5 mm wide, on both sides of the camshaft supports.

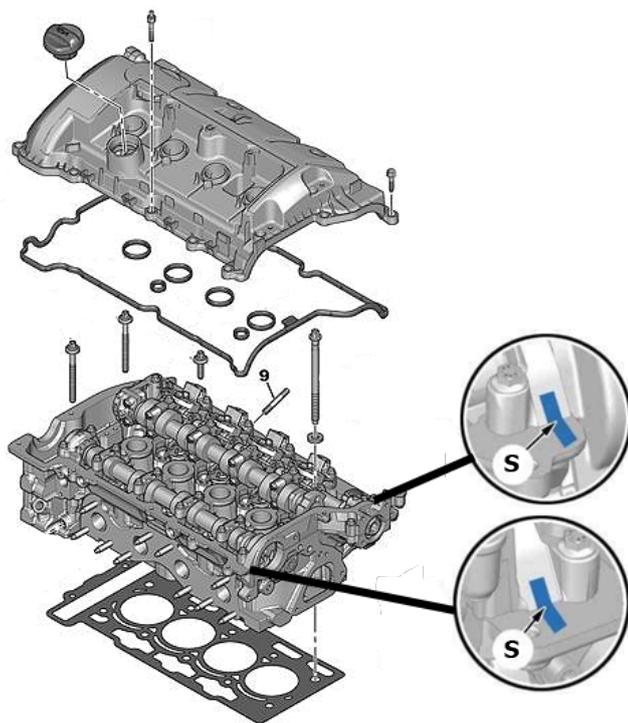


Image 2: Ajusil application areas

Tighten the cylinder head cover following the sequence shown in Figure 3. The specified torques are:

Pre-load torque: 2 Nm.

Final Torque: 10 Nm.

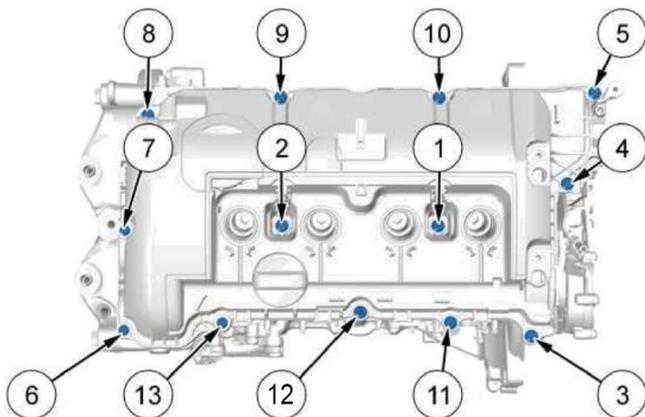


Image 3: cylinder head cover tightening sequence.