

114

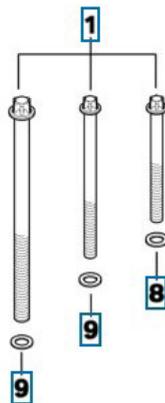
# TECHNICAL REPORT

Position and tightening of the  
cylinder head bolt in petrol  
engines of BMW



## PURPOSE

To report to the customer about the position and tightening of the cylinder head bolt kit which part number is 81029500 which is assembled in some **1.6, 1.8 and 2.0 petrol engines of BMW.**



Through the **Ajusa online catalogue** we can see all different engines where this bolt kit can be assembled.

<https://web.tecalliance.net/ajusa/en/home>

## POSITION

Now, we indicate the correct position of each bolt that belongs to 81029500 bolt kit.

| 81029500 BOLT KIT COMPOSITION |        |       |        |          |              |
|-------------------------------|--------|-------|--------|----------|--------------|
| TYPE                          | METRIC | PITCH | LENGTH | QUANTITY | POSITIONS    |
| A                             | M10    | 1,50  | 170    | 6        | From 1 to 6  |
| B                             | M8     | 1,25  | 125    | 3        | 8, 9 and 10  |
| C                             | M8     | 1,25  | 95     | 3        | 7, 11 and 12 |



## TIGHTENING

Bolts from **11 and 12 position** will have a tightening of **2,5 kpm**. The rest of bolts (1 - 10 positions) will have the **tightening indicated** in the torque sheet associated to the product.

### Tightening stages

- 1) 3 kpm
- 2)  $-90^\circ + 3 \text{ kpm}$
- 3)  $+90^\circ$
- 4)  $+90^\circ$