

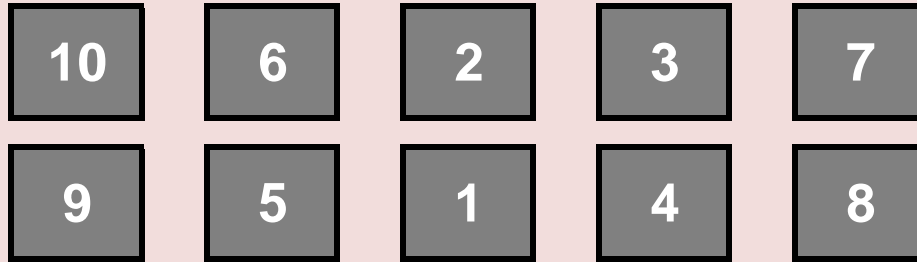
# Cylinder Head Tightening Instructions

## HG1136



|           | 1      | 2 | 3 | 4 | 5 | 6 |
|-----------|--------|---|---|---|---|---|
| Reference | HG1136 |   |   |   |   |   |
| Piston    |        |   |   |   |   |   |

### Headbolt Tightening Sequence



### Fitment Procedure

|                    | Stage 1 | Stage 2 | Stage 3      | Stage 4 | Stage 5 | Stage 6 | Stage 7 | Stage 8 | Retightening |
|--------------------|---------|---------|--------------|---------|---------|---------|---------|---------|--------------|
| <b>Bolt Type 1</b> |         |         |              |         |         |         |         |         |              |
| Kilos              | 2 Kpm   | 4 Kpm   | -90°+4 Kpm   | +90°    |         |         |         |         | No           |
| Pounds             | 15 lbft | 29 lbft | -90°+29 lbft | +90°    |         |         |         |         | No           |
| Newton M's         | 19.6 Nm | 39.2 Nm | -90°+39.2 Nm | +90°    |         |         |         |         | No           |
| <b>Bolt Type 2</b> |         |         |              |         |         |         |         |         |              |
| Kilos              |         |         |              |         |         |         |         |         |              |
| Pounds             |         |         |              |         |         |         |         |         |              |
| Newton M's         |         |         |              |         |         |         |         |         |              |
| <b>Bolt Type 3</b> |         |         |              |         |         |         |         |         |              |
| Kilos              |         |         |              |         |         |         |         |         |              |
| Pounds             |         |         |              |         |         |         |         |         |              |
| Newton M's         |         |         |              |         |         |         |         |         |              |
| <b>Bolt Type 4</b> |         |         |              |         |         |         |         |         |              |
| Kilos              |         |         |              |         |         |         |         |         |              |
| Pounds             |         |         |              |         |         |         |         |         |              |
| Newton M's         |         |         |              |         |         |         |         |         |              |

### Fitment Key Description of Required Procedure

|                   |  |
|-------------------|--|
| <b>-/+ X°</b>     | Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.  |
| <b>&lt;&gt;</b>   | Run the engine until it reaches working temperature.<br>Let the engine cool with the bonnet open for a minimum of four hours.<br>Remove the expansion tank cap.<br>Should retightening be required, loosen by 90° and then retighten observing the tightening procedure above. |
| <b>Retighten?</b> | If required, should be performed between 620-930 Miles (1000-1500 Km).   |