

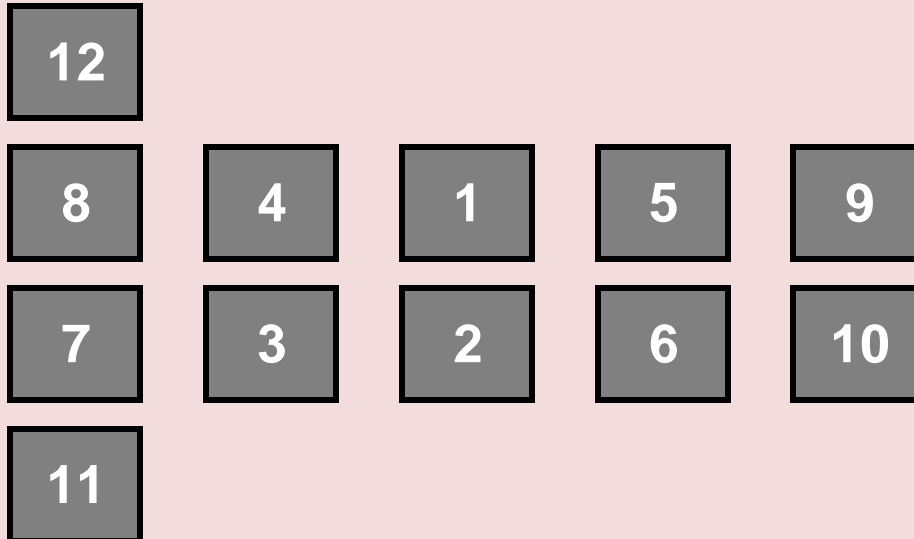
Cylinder Head Tightening Instructions

HG1442



	1	2	3	4	5	6
Reference	HG1442					
Piston						

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retightening
Bot Type 1									
Kilos	2 Kpm	+120°	+120°						No
Pounds	15 lbft	+120°	+120°						No
Newton M's	19.6 Nm	+120°	+120°						No
Bot Type 2									
Kilos									
Pounds									
Newton M's									
Bot Type 3									
Kilos									
Pounds									
Newton M's									
Bot Type 4									
Kilos									
Pounds									
Newton M's									

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