
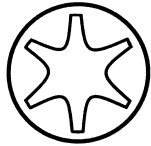


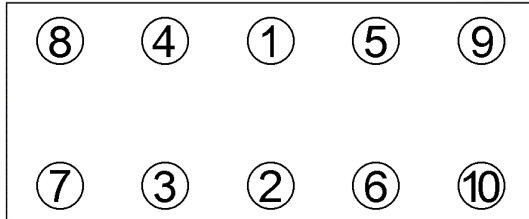
| | | |
|--|---|---|
| Anziehvorschrift für Zylinderkopf | 586.598 |  |
| Tightening Instructions for Cylinder Head | | |
| Instructions de serrage pour culasse | | |
| Prescripciones de apriete para culatas | | |
| | passend für / suitable for adaptable à / adaptable a | Saab Das Original |

Schraubenkopf / Head shape
Tête de vis / Cabeza de tornillo

Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete



221.280
M 12 x 99



| | | | |
|---|------------------------------|-----------------------------|-----------|
| Anziehen/ Tightening/ Serrage/ Apriete | HEX 15 mm, TORX bis 1988< | HEX 15 mm, TORX ab 1988> | HEX 17 mm |
| * | 60 Nm | * 60 Nm | * 60 Nm |
| | 80 Nm | 80 Nm | 95 Nm |
| ★ | 15 min | ▶ 90° | ★ 15 min |
| ● | 30 min | | ● 30 min |
| □ | 80 Nm | | □ 95 Nm |
| ▶ | 90° | | |

Zeichenerklärung / Explanations / Explication / Explicacion

| | | | | |
|---|---|------------------------------|--------------------------------|---------------------------------------|
| * | neue Zylinderkopfschrauben verwenden | use new cylinder head bolts | utiliser des vis neuves | emplar tornillos nuevos |
| ★ | Warmlauf (80°C) | warm up time (80°C) | chauffage (80°C) | calentamiento (80°C) |
| □ | Schrauben einzeln lösen und wieder anziehen | loosen and tighten each bolt | deserrer et serrer vis par vis | aflojar y apretar tornillo a tornillo |
| ● | Setzzeit | relaxation time | durée de tassement | tiempo de espera |
| ▶ | Drehwinkel | torque angle | angle de serrage | ángulo de giro |

Motortyp / Engine type / Type de moteur / Tipo de motor

Ø: 91 mm

Mot: B 202 i, B 234,
2,0 ltr-2,3 ltr

900 Turbo 16, i 16, 9000 Turbo 16, i 16,
CD Turbo 16, Cdi 16
9000 i 16V, Turbo 16V

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586.598