
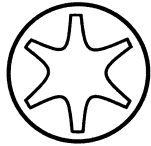


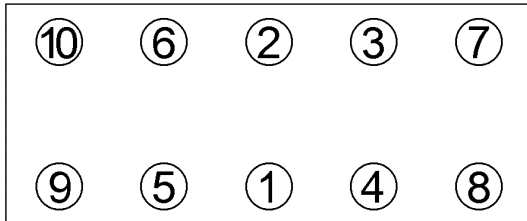
| | | |
|--|---|---|
| Anziehvorschrift für Zylinderkopf | 828.913 |  |
| Tightening Instructions for Cylinder Head | | |
| Instructions de serrage pour culasse | | |
| Prescripciones de apriete para culatas | | |
| | passend für / suitable for adaptable à / adaptable a | Opel |
| | | Das Original |

Schraubenkopf / Head shape
Tête de vis / Cabeza de tornillo

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



820.458
M 11 x 140



| | | | |
|---|---------------------|------------------------------------|----------------|
| Anziehen/ Tightening/ Serrage/ Apriete | 18 SV/18 SEH | E 18 NV/E 18 NVR S 18 NV | C 18 NZ |
| * | 25 Nm | * 25 Nm | * 25 Nm |
| ➤ | 60° | ➤ 60° | ➤ 90° |
| ➤ | 60° | ➤ 60° | ➤ 90° |
| ➤ | 60° | ➤ 30° | ➤ 90° |
| * | 15 min | * 15 min | |
| ➤ | 30° | ➤ 30° | |
| | | ➤ 15° | |

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

Mot. 1,8 l 18 SV / 18 SEH
E 18 NV / E 18 NVR
S 18 NV / C 18 NZ
C 18 LE

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828.913