

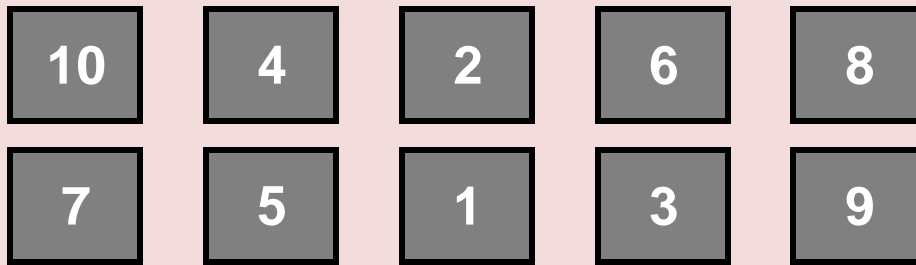
Cylinder Head Tightening Instructions

HG110



	1	2	3	4	5	6
Reference	HG110					
Piston						

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Bolt Type 1									
Kilos	3 Kpm	6 Kpm	9 Kpm	11 Kpm	-90°+11 Kpm	↔	-90°+11 Kpm	-90°+11 Kpm	-90°+11 Kpm
Pounds	22 lbft	43 lbft	65 lbft	80 lbft	-90°+80 lbft	↔	-90°+80 lbft	-90°+80 lbft	-90°+80 lbft
Newton M's	29.4 Nm	58.8 Nm	88.2 Nm	107.8 Nm	-90°+107.8Nrr	↔	-90°+107.8Nrr	-90°+107.8Nrr	-90°+107.8Nrr
Bolt Type 2									
Kilos									
Pounds									
Newton M's									
Bolt Type 3									
Kilos									
Pounds									
Newton M's									
Bolt 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).