

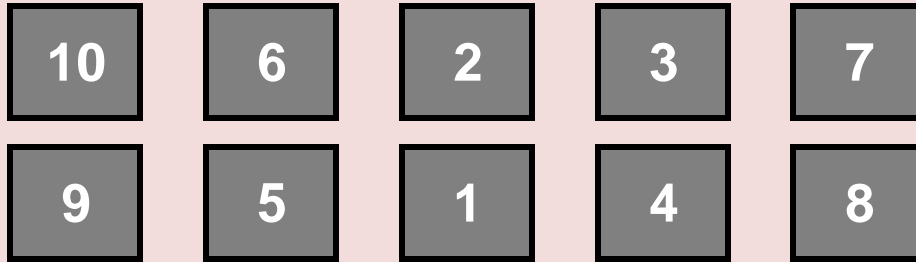
Cylinder Head Tightening Instructions

HG2109



| | | | | | | |
|------------------|--------|---|---|---|---|---|
| | 1 | 2 | 3 | 4 | 5 | 6 |
| Reference | HG2109 | | | | | |
| 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 | 2.5 Kpm | +70° | +70° | +50° | | | | | |
| | Pounds | 18 lbft | +70° | +70° | +50° | | | | | |
| | Newton M's | | +70° | +70° | +50° | | | | | |
| 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). |