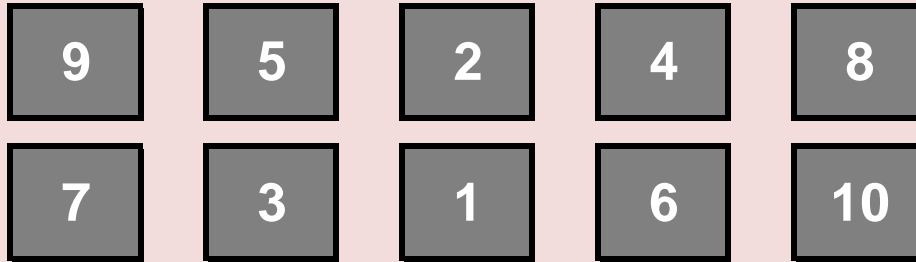


Cylinder Head Tightening Instructions **HG2111D**



	1	2	3	4	5	6
Reference	HG2111	HG2111B	HG2111C	HG2111D		
Piston	0.300-0.355	0.406-0.455	0.456-0.505	0.506-0.560		

Headbolt Tightening Sequence



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retightening
Bolt Type 1									
Kilos	5 Kpm	+90°	+180°	-90°	-90°	+90°	+90°	+90°	No
Pounds	36 lbft	+90°	+180°	-90°	-90°	+90°	+90°	+90°	No
Newton M's	49 Nm	+90°	+180°	-90°	-90°	+90°	+90°	+90°	No
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).