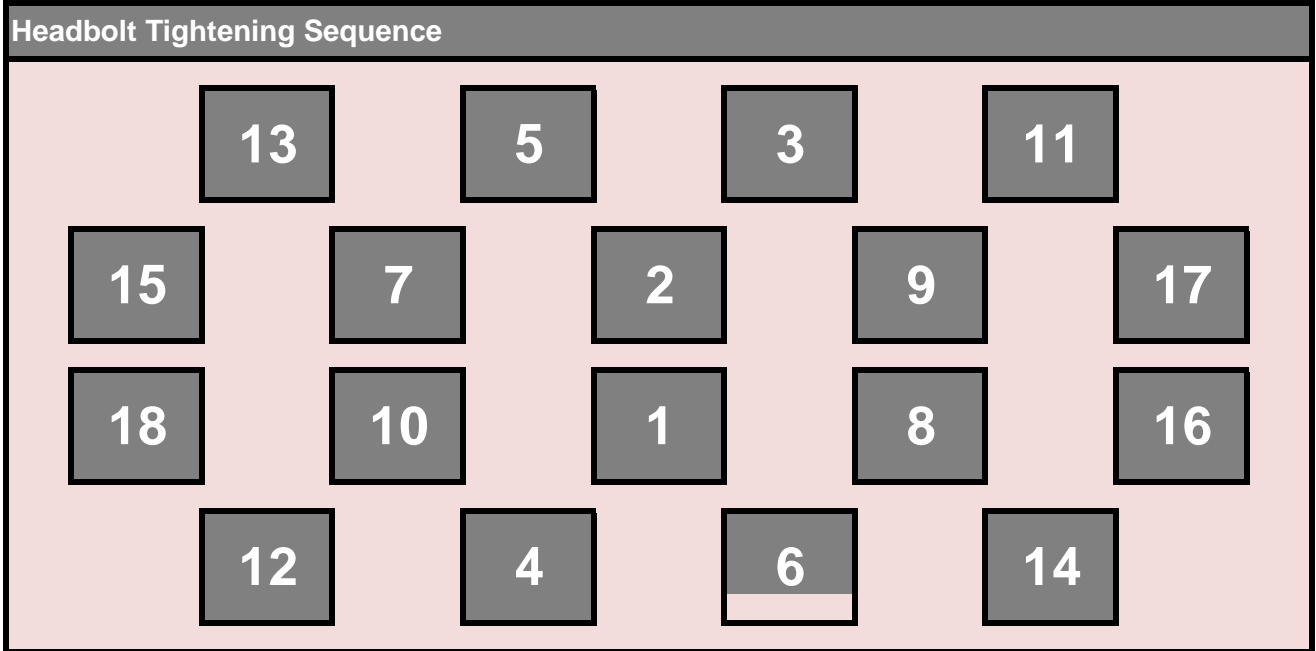


Cylinder Head Tightening Instructions

HG654



	1	2	3	4	5	6
Reference	HG654					
Piston	0.680-0.744					



Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
Botl Type 1									
Kilos	4 Kpm	8 Kpm	12 Kpm	-90°+12 Kpm	↔	-90°+12 Kpm			-90°+12 Kpm
Pounds	29 lbft	58 lbft	87 lbft	-90°+87 lbft	↔	-90°+87 lbft			-90°+87 lbft
Newton M's	39.2 Nm	19.6 Nm	117.6 Nm	-90°+117.6Nrr	↔	-90°+117.6Nrr			-90°+117.6Nm
Botl Type 2									
Kilos									
Pounds									
Newton M's									
Botl Type 3									
Kilos									
Pounds									
Newton M's									
Botl 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).