

Cylinder Head Tightening Instructions

HG985

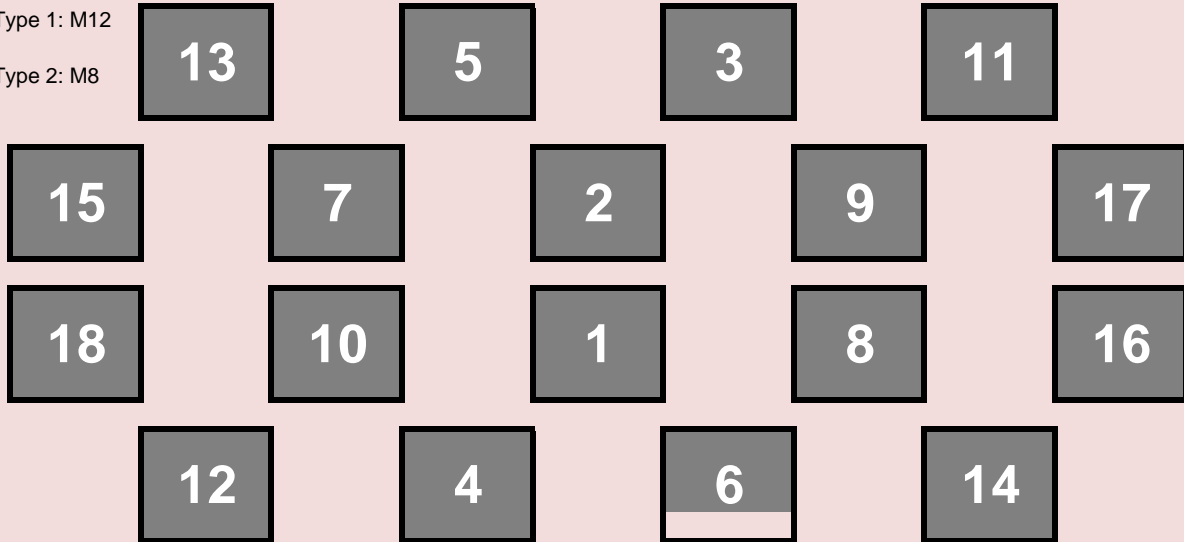


	1	2	3	4	5	6
Reference	HG985					
Piston	0.618-0.674					

Headbolt Tightening Sequence

Bolt Type 1: M12

Bolt Type 2: M8



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	10 Kpm	-180°	5 Kpm	+90°	+90°		
	Pounds	22 lbft	43 lbft	72 lbft	-180°	36 lbft	+90°	+90°		
	Newton M's	29.4 Nm	58.8 Nm	98 Nm	-180°	49 Nm	+90°	+90°		
Bolt Type 2	Kilos					2.5 Kpm				
	Pounds					18 lbft				
	Newton M's					24.5 Nm				
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).