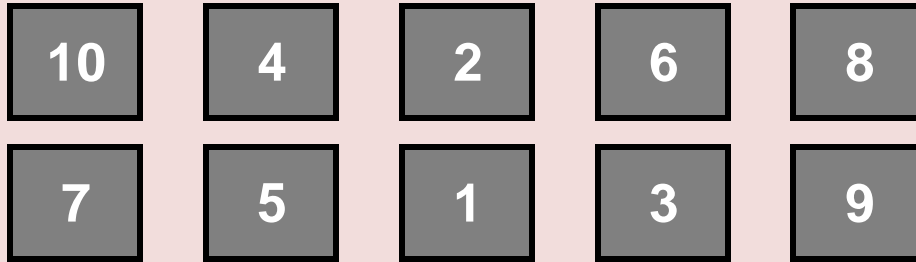


Cylinder Head Tightening Instructions **HG1410B**



	1	2	3	4	5	6
Reference	HG1410	HG1410A	HG1410B			
Piston	0.91-1.00	1.01-1.10	1.11-1.20			

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	3.5 Kpm	6 Kpm	-90°+6 Kpm	+90°	+90°				
Pounds	25 lbft	43 lbft	-90°+43 lbft	+90°	+90°				
Newton M's	29.4Nm	58.8 Nm	'-90°+58.8Nm	+90°	+90°				
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).