

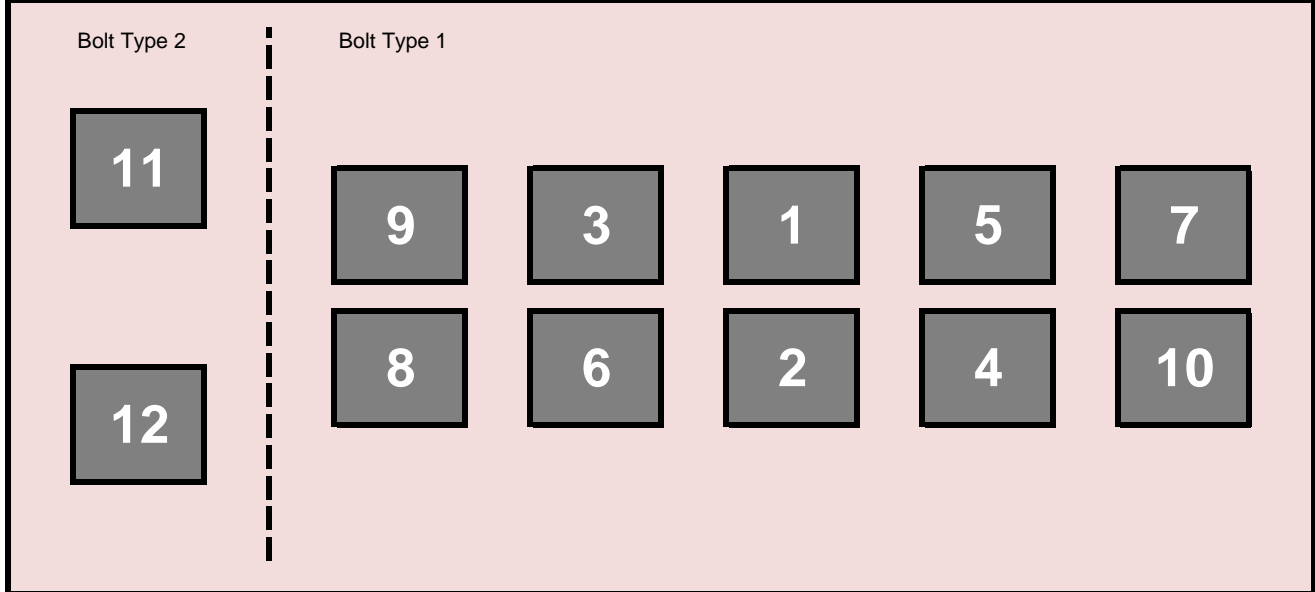
# Cylinder Head Tightening Instructions

# HG1154



	1	2	3	4	5	6
<b>Reference</b>	HG1154					
<b>Piston</b>						

## Headbolt Tightening Sequence



## Fitment Procedure

		Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
<b>Bolt Type 1</b>	Kilos	4 Kpm	-90°+4 Kpm	+120°						
	Pounds	29 lbft	-90°+29 lbft	+120°						
	Newton M's	39.2 Nm	-90°+39.2Nm	+120°						
<b>Bolt Type 2</b>	Kilos	1.5 Kpm	-90°+1.5 Kpm	+45°						
	Pounds	11 lbft	-90°+11 lbft	+45°						
	Newton M's	14.7 Nm	-90°+14.7Nm	+45°						
<b>Bolt Type 3</b>	Kilos									
	Pounds									
	Newton M's									
<b>Bolt Type 4</b>	Kilos									
	Pounds									
	Newton M's									

Fitment Key	Description of Required Procedure
<b>-/+ X°</b>	Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.
<b>&lt;&gt;</b>	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.
<b>Retighten?</b>	If required, should be performed between 620-930 Miles (1000-1500 Km).