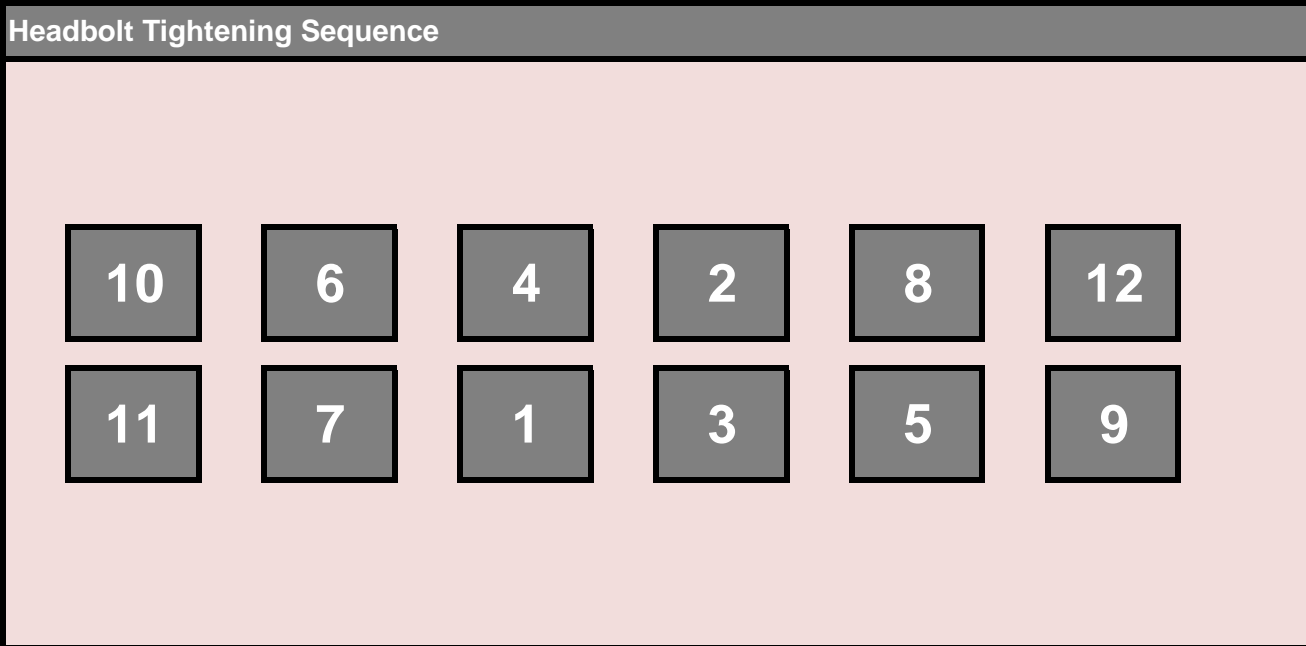


# Cylinder Head Tightening Instructions **HG1413B**



	1	2	3	4	5	6
<b>Reference</b>	HG1413	HG1413A	HG1413B			
<b>Piston</b>	0.39-0.49	0.50-0.54	0.55-0.65			



### 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	6 Kpm	-90°+6 Kpm	+90°	+90°	-90°			
Pounds	29 lbft	43 lbft	-90°+43 lbft	+90°	+90°	-90°			
Newton M's	39.2 Nm	58.8 Nm	-90°+58.8Nm	+90°	+90°	-90°			
<b>Bolt Type 2</b>									
Kilos									
Pounds									
Newton M's									
<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).

