

# Cylinder Head Tightening Instructions

## HG882

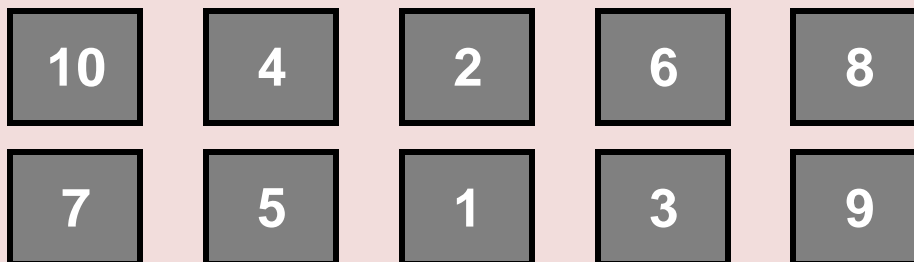


	1	2	3	4	5	6
<b>Reference</b>	HG882D	HG882C	HG882B	HG882A	HG882	
<b>Piston</b>	0.601-0.650	0.651-0.700	0.701-0.750	0.751-0.800	0.801-0.850	

### Headbolt Tightening Sequence

**Bolt Type 1:** 175mm

**Bolt Type 2:** 135mm



### 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	2.5 Kpm	5.5 Kpm	-90°+5.5 Kpm	+90°	+90°			
	Pounds	18 lbft	40 lbft	-90°+40 lbft	+90°	+90°			
	Newton M's	24.5 Nm	53.9 Nm	-90°+53.9 Nm	+90°	+90°			
<b>Bolt Type 2</b>	Kilos	2.5 Kpm	5.5 Kpm	-90°+5.5 Kpm	+80°	+80°			
	Pounds	18 lbft	40 lbft	-90°+40 lbft	+80°	+80°			
	Newton M's	24.5 Nm	53.9 Nm	-90°+53.9 Nm	+80°	+80°			
<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).