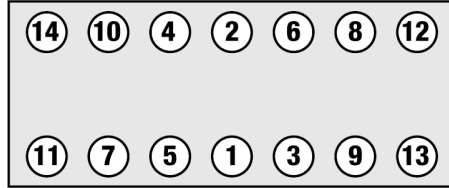




Anzugsrichtlinie für Zylinderkopfdichtungen  
 Torquing guideline for cylinder head gaskets  
 Directive de serrage pour les joints de culasse  
 Directriz para el apriete de juntas de culata  
 Direttiva per il serraggio delle viti delle guarnizioni testa cilindri  
 Инструкция по затягиванию прокладок головок блока цилиндров





Zylinderkopfschrauben immer erneuern. Schrauben bei kaltem Motor anziehen.  
 Always fit new cylinder head bolts. Tighten bolts with cold engine.  
 Toujours remplacer les vis de culasse par des neuves. Les resserrer lorsque le moteur est froid.  
 Los tornillos de culata deben sustituirse siempre. Apretar los tornillos con el motor en frío.  
 Sostituire sempre le viti della testa cilindri. Serrare le viti a motore freddo.  
 Винты с цилиндрическими головками всегда менять. Затягивать винты на холодном двигателе.

1.  $50 \pm 2 \text{ Nm}$
2.  $80 \pm 2 \text{ Nm}$
3.  15 min
4.  $100 \pm 2 \text{ Nm}$


Zeichenerklärung – Explanations – Explication – Leyenda – Spiegazione dei simboli – Объяснение символов

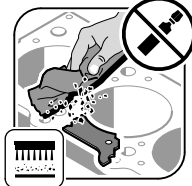


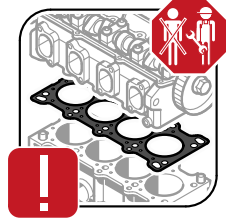
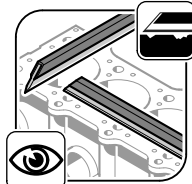
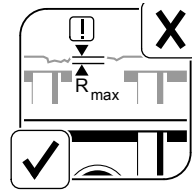

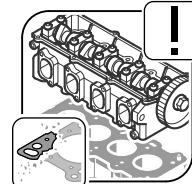
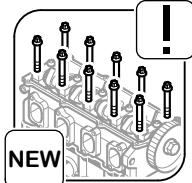
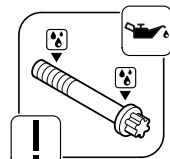
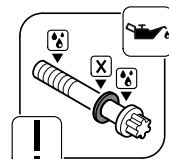
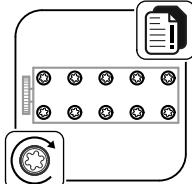
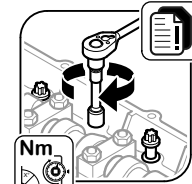
 Nachzug (nach) – retorque operation (after) – resserrage (après) – Reapriete (después de) – Post-serraggio (dopo) – Дополнительная затяжка (после)




 Warmlauf (Betriebstemperatur) – warm up time (Operating temperature) – chauffage (Température de service) – Marcha en caliente (Temperatura de servicio) – A motore caldo (Temperatura di esercizio) – Прогрев (Рабочая температура)

 Schrauben einzeln lösen und wieder anziehen – Loosen bolts individually and then retighten them – Desserrer individuellement les vis et les resserrer – Aflojar y volver a apretar los tornillos individualmente – Allentare e serrare nuovamente le viti una per una – Ослабить винты по одному и снова затянуть

 Setzzeit – relaxation time – durée de tassement – Tiempo de adaptación – Tempo di assettamento – Период усадки

 Drehwinkel – torque angle – angle de serrage – Ángulo de giro – Angolo di rotazione – Угол поворота

1. 
2.   
3.  
4. 
5. 
6.   
7.  

			
$R_z$	15-20 $\mu\text{m}$	11 $\mu\text{m}$	11-20 $\mu\text{m}$
$R_{max}$	20-25 $\mu\text{m}$	15 $\mu\text{m}$	15-20 $\mu\text{m}$
$W_t$	8-10 $\mu\text{m}$		