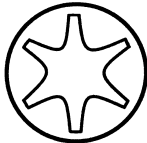
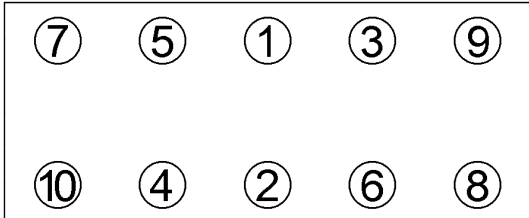


|                                                                                                                                 |                                                  |                                                                                              |                                                                                                          |                                       |
|---------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------|----------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                        |                                                  | <b>027.082</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>Ford</b> | <br><b>Das Original</b> |                                       |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                |                                                  |                                                                                              |                                                                                                          |                                       |
| <b>Instructions de serrage pour culasse</b>                                                                                     |                                                  |                                                                                              |                                                                                                          |                                       |
| <b>Prescripciones de apriete para culatas</b>                                                                                   |                                                  |                                                                                              |                                                                                                          |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                  |                                                  | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                      |                                                                                                          |                                       |
|                                                |                                                  |             |                                                                                                          |                                       |
| 027.850<br>M12x177+M12x137                                                                                                      |                                                  |                                                                                              |                                                                                                          |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                 | * M12 x 177:<br>20 Nm<br>54 Nm<br>➤ 90°<br>➤ 90° | * M12 x 137:<br>20 Nm<br>54 Nm<br>➤ 90°<br>➤ 70°                                             |                                                                                                          |                                       |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                     |                                                  |                                                                                              |                                                                                                          |                                       |
| ✱                                                                                                                               | neue Zylinderkopf-schrauben verwenden            | use new cylinder head bolts                                                                  | utiliser des vis neuves                                                                                  | emplar tornillos nuevos               |
| ★                                                                                                                               | Warmlauf (80°C)                                  | warm up time (80°C)                                                                          | chauffage (80°C)                                                                                         | calentamiento (80°C)                  |
| ☐                                                                                                                               | Schrauben einzeln lösen und wieder anziehen      | loosen and tighten each bolt                                                                 | deserrer et serrer vis par vis                                                                           | aflojar y apretar tornillo a tornillo |
| ●                                                                                                                               | Setzzeit                                         | relaxation time                                                                              | durée de tassement                                                                                       | tiempo de espera                      |
| ➤                                                                                                                               | Drehwinkel                                       | torque angle                                                                                 | angle de serrage                                                                                         | ángulo de giro                        |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                  |                                                  |                                                                                              |                                                                                                          |                                       |
| ✱ 1,37 mm, Ø 86,5 mm, 4 Zähne/Teeth                                                                                             |                                                  |                                                                                              |                                                                                                          |                                       |
| Mot.: BHDA, BHDB, BHPA, C9DA, C9DB, C9DC, F9DA, F9DB, FFDA, HCPA, HCPB, KKDA, RTN, RTP, RTQ<br>1,8 Ltr. TD 55-85 KW (75-115 PS) |                                                  |                                                                                              |                                                                                                          |                                       |
| Fiesta, Focus, Galaxy, Mondeo, Transit Connect                                                                                  |                                                  |                                                                                              |                                                                                                          |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                  |                                                  | <b>*027.082*</b>                                                                             |                                                                                                          |                                       |