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|--------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-----------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                               |                                                | <b>087.289</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>Volvo</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                       |                                                                                                          |                                          |
| <div><div><div>③</div><div>②</div><div>①</div><div>④</div></div></div>                                                                                 |                                                |                                                                                               |                                                                                                          |                                          |
| <div>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</div> <div><div>*</div><div>20 Nm<br/>100 Nm<br/>200 Nm<br/>320 Nm</div><div>➤ 60°</div></div> |                                                |                                                                                               |                                                                                                          |                                          |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                            |                                                |                                                                                               |                                                                                                          |                                          |
| <div>✱</div>                                                                                                                                           | neue Zylinderkopf-<br>schrauben verwenden      | use new cylinder<br>head bolts                                                                | utiliser des vis<br>neuves                                                                               | emplar tornillos nuevos                  |
| <div>★</div>                                                                                                                                           | Warmlauf (80°C)                                | warm up time (80°C)                                                                           | chauffage (80°C)                                                                                         | calentamiento (80°C)                     |
| <div>□</div>                                                                                                                                           | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt                                                               | deserrer et serrer<br>vis par vis                                                                        | aflojar y apretar<br>tornillo a tornillo |
| <div>●</div>                                                                                                                                           | Setzzeit                                       | relaxation time                                                                               | durée de tassement                                                                                       | tiempo de espera                         |
| <div>➤</div>                                                                                                                                           | Drehwinkel                                     | torque angle                                                                                  | angle de serrage                                                                                         | ángulo de giro                           |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                                         |                                                |                                                                                               |                                                                                                          |                                          |
| ✚ 1,4 mm, Ø 130 mm                                                                                                                                     |                                                |                                                                                               |                                                                                                          |                                          |
| Mot.: D 100 A/B, HD 100 A/B, TD 100 A/B,<br>THD 100 A/D/DA/DB/DC/DD                                                                                    |                                                |                                                                                               |                                                                                                          |                                          |
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