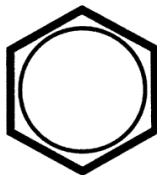
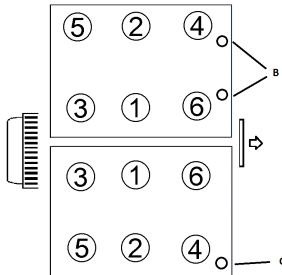


|                                                                                                                                                                                                                                              |                                                                                              |                                                                         |                                                                                                                      |                                       |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|-------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------|---------------------------------------|
| Anziehvorschrift für Zylinderkopf                                                                                                                                                                                                            |                                                                                              | 233.660                                                                 | <div></div> <div>Das Original</div> |                                       |
| Tightening Instructions for Cylinder Head                                                                                                                                                                                                    |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Instructions de serrage pour culasse                                                                                                                                                                                                         |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Prescripciones de apriete para culatas                                                                                                                                                                                                       |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                               |                                                                                              | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete |                                                                                                                      |                                       |
| <div></div>                                                                                                                                                 | <div></div> |                                                                         |                                                                                                                      |                                       |
| <div>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</div> <div><div>*</div><div>60 Nm</div><div>loosen 360°</div><div>20 Nm</div><div>60 Nm</div><div>➤ 90°</div><div>➤ 90°</div><div>Screw B: 18 Nm</div><div>Screw C: 6 Nm</div></div> |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                  |                                                                                              |                                                                         |                                                                                                                      |                                       |
| <div>*</div>                                                                                                                                                                                                                                 | neue Zylinderkopf-schrauben verwenden                                                        | use new cylinder head bolts                                             | utiliser des vis 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 und wieder anziehen                                                  | loosen and tighten each bolt                                            | deserrer et serrer vis par vis                                                                                       | aflojar y apretar 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                        |
| Motortyp / Engine type / Type de moteur / Tipo de motor                                                                                                                                                                                      |                                                                                              |                                                                         |                                                                                                                      |                                       |
| 2.0L Diesel                                                                                                                                                                                                                                  |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Ø: 86,8 mm / $\frac{1}{8}$ : 0,95 mm                                                                                                                                                                                                         |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Size: A                                                                                                                                                                                                                                      |                                                                                              |                                                                         |                                                                                                                      |                                       |
| Mot.: EE20Z                                                                                                                                                                                                                                  |                                                                                              |                                                                         |                                                                                                                      |                                       |
| assembly position: left side                                                                                                                                                                                                                 |                                                                                              |                                                                         |                                                                                                                      |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                               |                                                                                              |                                                                         | *233.660*                                                                                                            |                                       |