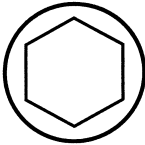


|                                                                                                                                                                                                                                                                               |                                             |                                                         |                                                                                   |                                       |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|---------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                      |                                             | <b>259.820</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                                                                                                                                                                                                                |                                             | passend für / suitable for<br>adaptable à / adaptable a | <b>GM</b><br>Das Original                                                         |                                       |
| <div><div><div>8</div><div>4</div><div>1</div><div>5</div><div>9</div><div>7</div><div>3</div><div>2</div><div>6</div><div>10</div></div><p>595.200<br/>M 10x1,5x110-10.9</p></div>          |                                             |                                                         |                                                                                   |                                       |
| <div>Anziehen/ * 15 Nm<br/>Tightening/ 30 Nm<br/>Serrage/ ➤ 240°<br/>Apriete</div>                                                                                                                                                                                            |                                             |                                                         |                                                                                   |                                       |
| 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><br><br>Ø: 75,2 mm; $\frac{1}{4}$ : 1,005 mm<br><br>Mot: LE2, LV7, B14XE, B14XFL, B14XFT, D14XFL<br>B14XFT, B15SFL, D15SFL, B15SFT, D15SFL<br>1,4 - 1,5 ltr.<br><br>Astra K, Mokka, Insignia B<br>Cruze, Encore |                                             |                                                         |                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                |                                             | <b>*259.820*</b>                                        |                                                                                   |                                       |