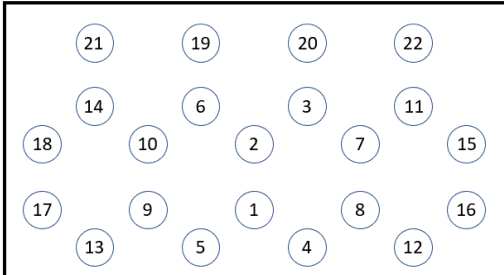


|                                                                                              |                                                                                     |                                                                         |                                                                                   |                                       |
|----------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                     |                                                                                     | <b>429.133</b>                                                          |  | <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                               |                                                                                     | passend für / suitable for<br>adaptable à / adaptable a                 |                                                                                   | <b>GM</b>                             |
|                                                                                              |                                                                                     | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete |                                                                                   |                                       |
| <div></div> |                                                                                     |                                                                         |                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                              | * 1-18 37 ft-lbs<br>1-18 59 ft-lbs<br>➤ 1-18 90°<br>➤ 1-18 75°<br>* 19-22 18 ft-lbs | * 1-18 50 Nm<br>1-18 80 Nm<br>➤ 1-18 90°<br>➤ 1-18 75°<br>* 19-22 24 Nm |                                                                                   |                                       |
| 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>                               |                                                                                     |                                                                         |                                                                                   |                                       |
|                                                                                              |                                                                                     |                                                                         |                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601               |                                                                                     |                                                                         | <b>*429.133*</b>                                                                  |                                       |