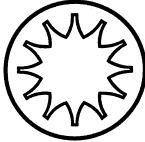
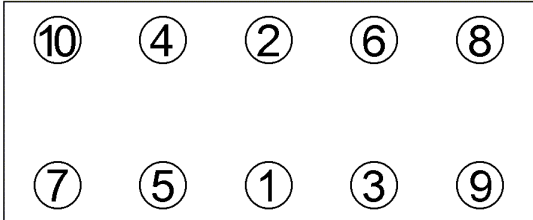


|                                                                                   |                                             |                                                                                   |                                                                                                   |                                       |
|-----------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                             | <b>473.550</b>                                                                    | <br>Das Original |                                       |
| <b>Tightening Instructions for Cylinder Head</b>                                  |                                             | passend für / suitable for                                                        |                                                                                                   |                                       |
| <b>Instructions de serrage pour culasse</b>                                       |                                             | adaptable à / adaptable a                                                         |                                                                                                   |                                       |
| <b>Prescripciones de apriete para culatas</b>                                     |                                             | <b>Volkswagen</b>                                                                 |                                                                                                   |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                    |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                                                                                   |                                       |
|  |                                             |  |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | * 30 Nm<br>➤ 90°<br>➤ 90°                   |                                                                                   |                                                                                                   |                                       |
| 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>                    |                                             |                                                                                   |                                                                                                   |                                       |
| 1,4/ 1,6 Ltr.                                                                     |                                             |                                                                                   |                                                                                                   |                                       |
| Mot. BKR, BAH, BJA, BLH, BPA, BLM                                                 |                                             |                                                                                   |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                             |                                                                                   | <b>*473.550*</b>                                                                                  |                                       |