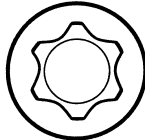
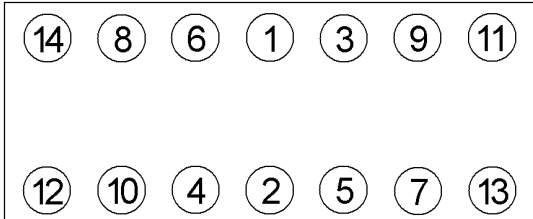


|                                                                                                                                                    |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
|----------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                           |                                                                                                                                          | <b>477.322</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>BMW</b>                                 | <br>Das Original                                                                                                                                                                  |
| <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                                                     |                                                                                                                                                                                                                                                                    |
|                                                                   |                                                                                                                                          |                                            |                                                                                                                                                                                                                                                                    |
| 233.380<br>M 12x1,5x200                                                                                                                            |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                    | * 70 Nm<br>□ 180°<br>50 Nm<br>➤ 120°<br>➤ 120°                                                                                           |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                        |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| *<br>★<br>□<br>●<br>➤                                                                                                                              | neue Zylinderkopf-<br>schrauben verwenden<br>Warmlauf (80°C)<br>Schrauben einzeln lösen<br>und wieder anziehen<br>Setzzeit<br>Drehwinkel | use new cylinder<br>head bolts<br>warm up time (80°C)<br>loosen and tighten<br>each bolt<br>relaxation time<br>torque angle | utiliser des vis<br>neuves<br>chauffage (80°C)<br>deserrer et serrer<br>vis par vis<br>durée de tassement<br>angle de serrage<br>emplar tornillos nuevos<br>calentamiento (80°C)<br>aflojar y apretar<br>tornillo a tornillo<br>tiempo de espera<br>ángulo de giro |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                                     |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Mot. N57 D30    1,55mm    Ø84,7mm                                                                                                                  |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| E90/E91/E92/93    325d, 330d, xd<br>F07GT/F10    525d, 530d, xd, 535d<br>F01/F02    730d, Ld, 740d<br>E70    X5 30dX, 40dX<br>E71    X6 30dX, 40dX |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                     |                                                                                                                                          | <b>*477.322*</b>                                                                                                            |                                                                                                                                                                                                                                                                    |