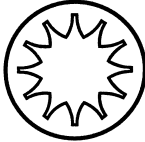


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|-------------------------------------------------|---------------------------------------|------------------------------|-------------------------|-------------------------|---|-----------------|---------------------|------------------|----------------------|---|---------------------------------------------|------------------------------|--------------------------------|---------------------------------------|---|----------|-----------------|--------------------|------------------|---|------------|--------------|------------------|----------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                             | <b>524.390</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>VW / Audi</b>                                                                                                                                                                                                    |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                                                                                                                             |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <br><br>586.360<br>M 12x1,5x175                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                             | <table><tr><td>⑦</td><td>①</td><td>④</td><td>⑥</td></tr><tr><td>⑤</td><td>③</td><td>②</td><td>⑧</td></tr><tr><td>⑤</td><td>③</td><td>②</td><td>⑧</td></tr><tr><td>⑦</td><td>①</td><td>④</td><td>⑥</td></tr></table> |                                                                                                   | ⑦                                               | ①                                     | ④                            | ⑥                       | ⑤                       | ③ | ②               | ⑧                   | ⑤                | ③                    | ② | ⑧                                           | ⑦                            | ①                              | ④                                     | ⑥ |          |                 |                    |                  |   |            |              |                  |                |
| ⑦                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | ①                                           | ④                                                                                                                                                                                                                   | ⑥                                                                                                 |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ⑤                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | ③                                           | ②                                                                                                                                                                                                                   | ⑧                                                                                                 |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ⑤                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | ③                                           | ②                                                                                                                                                                                                                   | ⑧                                                                                                 |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ⑦                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | ①                                           | ④                                                                                                                                                                                                                   | ⑥                                                                                                 |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</td><td>*<br/><br/>➤<br/>➤</td><td>35 Nm<br/>70 Nm<br/>90°<br/>90°</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                             |                                                                                                                                                                                                                     |                                                                                                   | Anziehen/<br>Tightening/<br>Serrage/<br>Apriete | *<br><br>➤<br>➤                       | 35 Nm<br>70 Nm<br>90°<br>90° |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | *<br><br>➤<br>➤                             | 35 Nm<br>70 Nm<br>90°<br>90°                                                                                                                                                                                        |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>✱</td><td>neue Zylinderkopf-schrauben verwenden</td><td>use new cylinder head bolts</td><td>utiliser des vis neuves</td><td>emplar tornillos nuevos</td></tr><tr><td>★</td><td>Warmlauf (80°C)</td><td>warm up time (80°C)</td><td>chauffage (80°C)</td><td>calentamiento (80°C)</td></tr><tr><td>□</td><td>Schrauben einzeln lösen und wieder anziehen</td><td>loosen and tighten each bolt</td><td>deserrer et serrer vis par vis</td><td>aflojar y apretar tornillo a tornillo</td></tr><tr><td>●</td><td>Setzzeit</td><td>relaxation time</td><td>durée de tassement</td><td>tiempo de espera</td></tr><tr><td>➤</td><td>Drehwinkel</td><td>torque angle</td><td>angle de serrage</td><td>ángulo de giro</td></tr></table> |                                             |                                                                                                                                                                                                                     |                                                                                                   | ✱                                               | 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 |
| ✱                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 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>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 3.0 V6 BiTDI / 1,58 mm / 1 Loch / links, left                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Mot: CGQB                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 230 KW (313 PS)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| A6, A7<br>SQ5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                             |                                                                                                                                                                                                                     |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                             | <b>*524.390*</b>                                                                                                                                                                                                    |                                                                                                   |                                                 |                                       |                              |                         |                         |   |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |