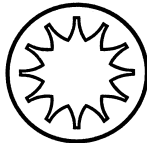
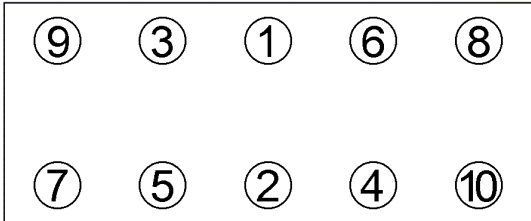


|                                                                                                                 |                                                                                   |                                                                                                   |                                |                                       |
|-----------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|--------------------------------|---------------------------------------|
| 531.281                                                                                                         |                                                                                   | <br>Das Original |                                |                                       |
| Tightening Instructions for Cylinder Head                                                                       |                                                                                   |                                                                                                   |                                |                                       |
| Instructions de serrage pour culasse                                                                            |                                                                                   |                                                                                                   |                                |                                       |
| Prescripciones de apriete para culatas                                                                          |                                                                                   |                                                                                                   |                                |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                  |                                                                                   | passend für / suitable for<br>adaptable à / adaptable a<br><br>VW                                 |                                |                                       |
| Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                         |                                                                                   |                                                                                                   |                                |                                       |
| <br><br>725.310<br>M9x1,25x158 |  |                                                                                                   |                                |                                       |
| 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                        |
| Motortyp / Engine type / Type de moteur / Tipo de motor                                                         |                                                                                   |                                                                                                   |                                |                                       |
| 1,4 Ltr.<br>44 kW ( 60 PS )<br>Mot. AKK, AKP, ANW, AUD<br><br>Caddy 09/2000 ><br>Lupo 09/2000 >                 |                                                                                   |                                                                                                   |                                |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                  |                                                                                   |                                                                                                   | *531.281*                      |                                       |