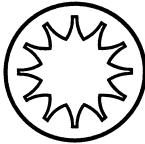


|                                                                                                                          |                                             |                                                                                   |                                |                                                                                                          |
|--------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|--------------------------------|----------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                 |                                             | <b>732.110</b>                                                                    |                                | <br><b>Das Original</b> |
| <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</b>                                                                         |                                |                                                                                                          |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                           |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                |                                                                                                          |
|                                         |                                             |  |                                |                                                                                                          |
| 189.380<br>M 12x1,75x137                                                                                                 |                                             |                                                                                   |                                |                                                                                                          |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                          | 60 Nm<br>* 35 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>                                                           |                                             |                                                                                   |                                |                                                                                                          |
| Ø 80,7 ± 1,71 mm                                                                                                         |                                             |                                                                                   |                                |                                                                                                          |
| Mot. CAYA, CAYB, CAYC, CAYD, CAYE, CLNA                                                                                  |                                             |                                                                                   |                                |                                                                                                          |
| Caddy, Golf, Jetta, New Beetle, Passat, Polo, Touran, Al, A3, Fabia, Octavia, Roomster, Superb, Yeti, Altea, Ibiza, Leon |                                             |                                                                                   |                                |                                                                                                          |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                           |                                             | <b>*732.110*</b>                                                                  |                                |                                                                                                          |