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|--------------------------------------------------------------------------------|------------------------------------------------------------------|-----------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                       |                                                                  | <b>755.206</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><br><b>Volvo</b> | <br><b>Das Original</b> |                                       |
| <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                       |                                                                                                          |                                       |
| <div><div><div>③</div><div>②</div><div>①</div><div>④</div></div></div>         |                                                                  |                                                                                               |                                                                                                          |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                | * TD 100, TD 101<br>20 Nm<br>100 Nm<br>200 Nm<br>320 Nm<br>➤ 60° | * TD 102, TD 103<br>50 Nm<br>200 Nm<br>370 Nm<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: 137 mm; $\frac{1}{2}$ : 1,40 mm                                             |                                                                  |                                                                                               |                                                                                                          |                                       |
| Mot: TD 100 G/GA                                                               |                                                                  |                                                                                               |                                                                                                          |                                       |
| TD 101 F/FA/FC/FD/G/GA/GB                                                      |                                                                  |                                                                                               |                                                                                                          |                                       |
| TD 102 F/FBQ/FDQ/FF/FH/FL/FS/FT                                                |                                                                  |                                                                                               |                                                                                                          |                                       |
| TD 103 E/ES, D 10 A                                                            |                                                                  |                                                                                               |                                                                                                          |                                       |
| 9,6 ltr                                                                        |                                                                  |                                                                                               |                                                                                                          |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601 |                                                                  |                                                                                               | <b>*755.206*</b>                                                                                         |                                       |