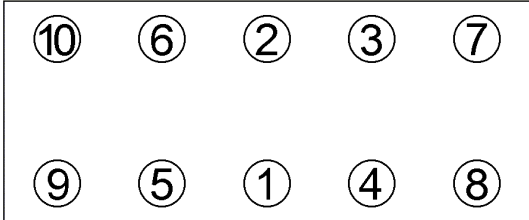


|                                                                                                                    |                                             |                                                                                   |                                                                                                   |                                       |
|--------------------------------------------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| Anziehvorschrift für Zylinderkopf                                                                                  |                                             | 808.884                                                                           | <br>Das Original |                                       |
| Tightening Instructions for Cylinder Head                                                                          |                                             | passend für / suitable for<br>adaptable à / adaptable a<br><br>Opel               |                                                                                                   |                                       |
| Instructions de serrage pour culasse                                                                               |                                             |                                                                                   |                                                                                                   |                                       |
| Prescripciones de apriete para culatas                                                                             |                                             |                                                                                   |                                                                                                   |                                       |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                     |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                                                                                   |                                       |
| <br><br>257.910<br>M11x1,5x162    |                                             |  |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                    | *<br>➤<br>➤<br>➤                            | 30 Nm<br>75°<br>75°<br>15°                                                        | M8:<br>35Nm                                                                                       |                                       |
| 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                                                            |                                             |                                                                                   |                                                                                                   |                                       |
| 2.2 Ltr.<br>110/114 KW (150/155PS)<br>Mot. Z22YH<br>4 Cyl.<br><br>Signum 2003-<br>Vectra C 2002-<br>Zafira B 2005- |                                             |                                                                                   |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                     |                                             |                                                                                   | *808.884*                                                                                         |                                       |