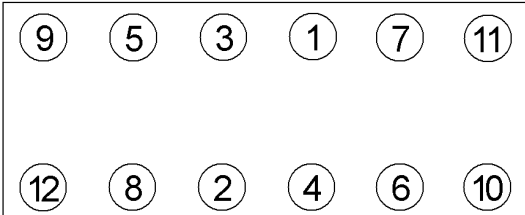


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                            |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|-------------------------------------------------------------|----------------------------------------------------------------------------|--|--|---|---------------------------------------|-----------------------------|-------------------------|-------------------------|---|-----------------------------------------|---------------------|------------------|----------------------|---|---------------------------------------------|------------------------------|--------------------------------|---------------------------------------|---|----------|-----------------|--------------------|------------------|---|------------|--------------|------------------|----------------|
| Anziehvorschrift für Zylinderkopf                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                            | 892.343                                                                           | <br>Das Original |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Tightening Instructions for Cylinder Head                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                            | passend für / suitable for<br>adaptable à / adaptable a<br><br>Audi               |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 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>819.875<br>M 12 x 115                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                            |  |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</td><td>* 40 Nm<br/>60 Nm<br/>➤ 90°<br/>➤ 90°<br/>★ 80°C<br/>➤ 90°<br/>1.000 km<br/>➤ 90°</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                            |                                                                                   |                                                                                                   | Anziehen/<br>Tightening/<br>Serrage/<br>Apriete             | * 40 Nm<br>60 Nm<br>➤ 90°<br>➤ 90°<br>★ 80°C<br>➤ 90°<br>1.000 km<br>➤ 90° |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | * 40 Nm<br>60 Nm<br>➤ 90°<br>➤ 90°<br>★ 80°C<br>➤ 90°<br>1.000 km<br>➤ 90° |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td colspan="4">Zeichenerklärung / Explanations / Explication / Explicacion</td></tr><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> |                                                                            |                                                                                   |                                                                                                   | 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 |
| 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                                              |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td colspan="5">Motortyp / Engine type / Type de moteur / Tipo de motor</td></tr><tr><td colspan="5">76,5 Ø</td></tr><tr><td colspan="5">Mot. CN, 5 Cyl., 2,0 l, 51,5 kW (70 PS)</td></tr><tr><td colspan="5">DE, 5 Cyl., 2,0 l, 66 kW (90 PS)</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                            |                                                                                   |                                                                                                   | Motortyp / Engine type / Type de moteur / Tipo de motor     |                                                                            |  |  |   | 76,5 Ø                                |                             |                         |                         |   | Mot. CN, 5 Cyl., 2,0 l, 51,5 kW (70 PS) |                     |                  |                      |   | DE, 5 Cyl., 2,0 l, 66 kW (90 PS)            |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Motortyp / Engine type / Type de moteur / Tipo de motor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                            |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| 76,5 Ø                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                            |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| Mot. CN, 5 Cyl., 2,0 l, 51,5 kW (70 PS)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                            |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| DE, 5 Cyl., 2,0 l, 66 kW (90 PS)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                            |                                                                                   |                                                                                                   |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                            |                                                                                   | *892.343*                                                                                         |                                                             |                                                                            |  |  |   |                                       |                             |                         |                         |   |                                         |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |   |            |              |                  |                |