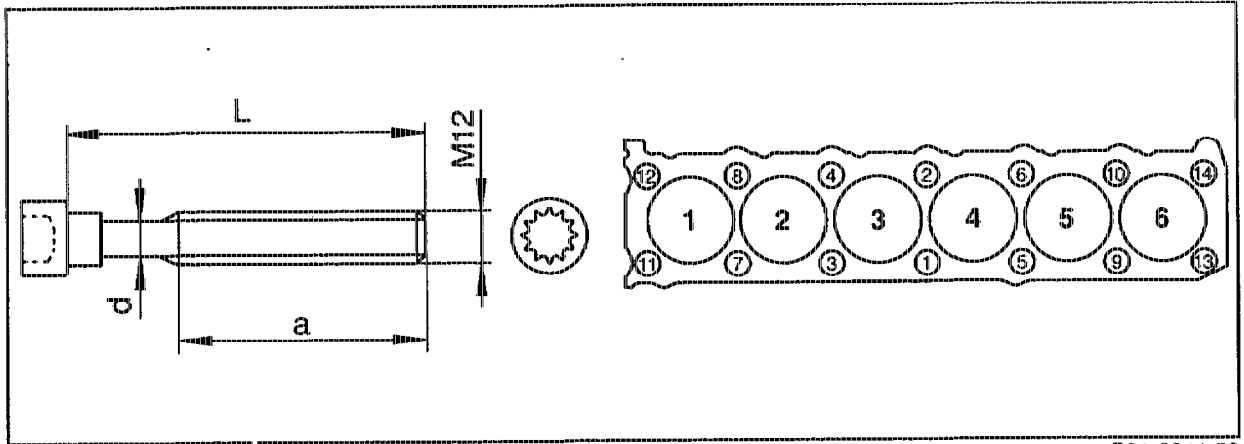


# 01-4050 Examining, tightening cylinder head bolts



P01-6044-53

## Examining

Length (L) of cylinder head bolts .....

examine.

### Note

The cylinder head bolts are subjected to a certain stretch each time they are tightened. If the maximum length (L) is exceeded, the bolts should be replaced.

## Tightening

Threads of cylinder head bolts and threaded holes in crankcase .....

clean.



Fluids forced into the threaded holes may damage the crankcase.

Threads of cylinder head bolts and contact surfaces of washers .....

oil with engine oil.

Cylinder head bolts .....

tighten in stages in the order of the tightening diagram, starting with 1.

- 1st stage 55 Nm
- 2nd stage 90° tightening angle
- 3rd stage 90° tightening angle



The cylinder head gasket is not watertight until the engine has reached its normal operating temperature and the gasket has swollen. For this reason, do not pressure-test the cooling system until the engine has reached normal operating temperature.

#### Tightening torques in Nm

Cylinder head bolts, engine cold	1st stage	55
	2nd stage 90° tightening angle	
	3rd stage 90° tightening angle	

#### Length of cylinder head bolt in mm

Length (L) when new	Maximum length (L)
160	163.5 mm

#### Special tool

