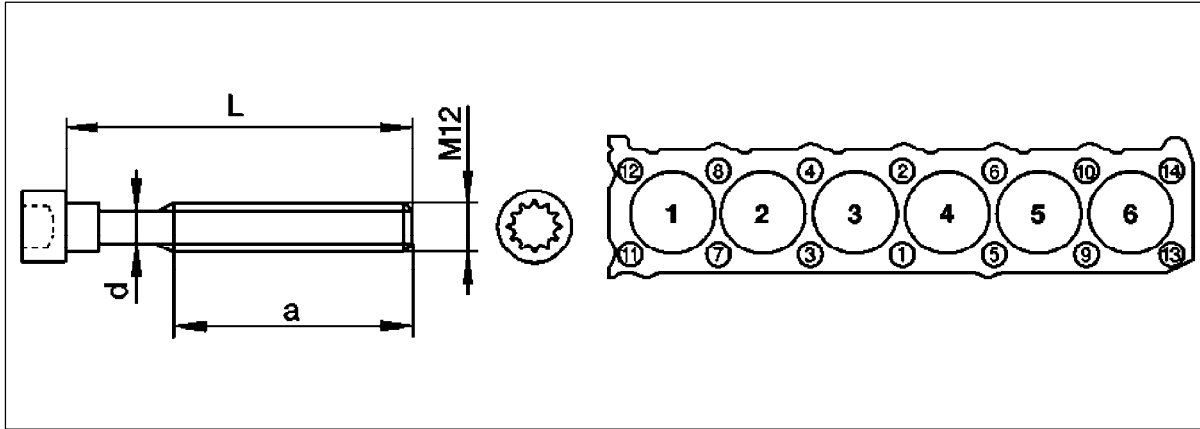


## 01-4050 Examining, tightening cylinder head bolts



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.

### M

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

### M

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

