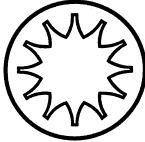
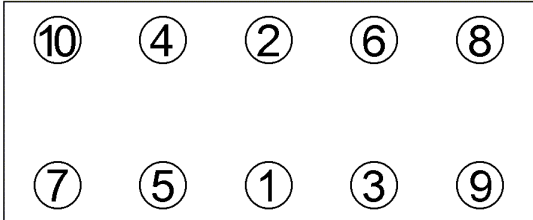


|                                                                                   |                                             |                                                                                   |                                |                                                                                                   |  |
|-----------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|--------------------------------|---------------------------------------------------------------------------------------------------|--|
| Anziehvorschrift für Zylinderkopf                                                 |                                             | 285.023                                                                           |                                | <br>Das Original |  |
| Tightening Instructions for Cylinder Head                                         |                                             | passend für / suitable for<br>adaptable à / adaptable a                           |                                |                                                                                                   |  |
| Instructions de serrage pour culasse                                              |                                             | Audi                                                                              |                                |                                                                                                   |  |
| Prescripciones de apriete para culatas                                            |                                             |                                                                                   |                                |                                                                                                   |  |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                    |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                |                                                                                                   |  |
|  |                                             |  |                                |                                                                                                   |  |
| 819.824<br>M 12 x 115                                                             |                                             |                                                                                   |                                |                                                                                                   |  |
| 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°        |                                |                                                                                                   |  |
| 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                           |                                             |                                                                                   |                                |                                                                                                   |  |
| 78,5 mm Ø, 1,59/1,50 mm ÷                                                         |                                             |                                                                                   |                                |                                                                                                   |  |
| 1,6 Ltr. Diesel, Mot.CR,JK 40 kW (54 PS)                                          |                                             |                                                                                   |                                |                                                                                                   |  |
| Audi 80 D, 08/1982>07/1989                                                        |                                             |                                                                                   |                                |                                                                                                   |  |
| Audi 4000 (USA)                                                                   |                                             |                                                                                   |                                |                                                                                                   |  |
| Audi 90 D, 04/1987>07/1989                                                        |                                             |                                                                                   |                                |                                                                                                   |  |
| 1,6 Ltr. Diesel, Mot.CR ab Mot.176 339>, JK                                       |                                             |                                                                                   |                                |                                                                                                   |  |
| Golf, ab Chassis 17 B 550 001>                                                    |                                             |                                                                                   |                                |                                                                                                   |  |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                             |                                                                                   | *285.023*                      |                                                                                                   |  |