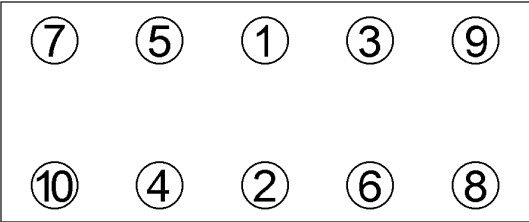


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------|-------------------------------------------|--------------------------------|----------------------------|-------------------------|---|-----------------|---------------------|------------------|----------------------|---|------------------------------------------------|---------------------------------|-----------------------------------|------------------------------------------|---|----------|-----------------|--------------------|------------------|---|------------|--------------|------------------|----------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                | <b>354.670</b>                                                                    |  |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Instructions de serrage pour culasse</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Prescripciones de apriete para culatas</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete           |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                |  |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| 803.320<br>M 10 x 115                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>Anziehen/<br/>Tightening/<br/>Serrage/<br/>Apriete</td><td>*</td><td>40 Nm<br/>90°<br/>90°</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                |                                                                                   |                                                                                   | Anziehen/<br>Tightening/<br>Serrage/<br>Apriete | *                                         | 40 Nm<br>90°<br>90°            |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | *                                              | 40 Nm<br>90°<br>90°                                                               |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <table><tr><td>*</td><td>neue Zylinderkopf-<br/>schrauben verwenden</td><td>use new cylinder<br/>head bolts</td><td>utiliser des vis<br/>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<br/>und wieder anziehen</td><td>loosen and tighten<br/>each bolt</td><td>deserrer et serrer<br/>vis par vis</td><td>aflojar y apretar<br/>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> |                                                |                                                                                   |                                                                                   | *                                               | neue Zylinderkopf-<br>schrauben verwenden | use new cylinder<br>head bolts | utiliser des vis<br>neuves | emplar tornillos nuevos | ★ | Warmlauf (80°C) | warm up time (80°C) | chauffage (80°C) | calentamiento (80°C) | □ | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt | deserrer et serrer<br>vis par vis | aflojar y apretar<br>tornillo a tornillo | ● | Setzzeit | relaxation time | durée de tassement | tiempo de espera | ➤ | Drehwinkel | torque angle | angle de serrage | ángulo de giro |
| *                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | neue Zylinderkopf-<br>schrauben verwenden      | use new cylinder<br>head bolts                                                    | utiliser des vis<br>neuves                                                        | emplar tornillos nuevos                         |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ★                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Warmlauf (80°C)                                | warm up time (80°C)                                                               | chauffage (80°C)                                                                  | calentamiento (80°C)                            |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| □                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Schrauben einzeln lösen<br>und wieder anziehen | loosen and tighten<br>each bolt                                                   | deserrer et serrer<br>vis par vis                                                 | aflojar y apretar<br>tornillo a tornillo        |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ●                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Setzzeit                                       | relaxation time                                                                   | durée de tassement                                                                | tiempo de espera                                |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ➤                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Drehwinkel                                     | torque angle                                                                      | angle de serrage                                                                  | ángulo de giro                                  |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| 2,0 Ltr. 80/85 kW (80/115 PS)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| Mot. BSX Erdgasmotor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ATM F7M-7-016 521 →                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| F7M-7-512 501 →                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| AXA F7J-7X024 001 →                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |                                                                                   |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                | <b>*354.670*</b>                                                                  |                                                                                   |                                                 |                                           |                                |                            |                         |   |                 |                     |                  |                      |   |                                                |                                 |                                   |                                          |   |          |                 |                    |                  |   |            |              |                  |                |