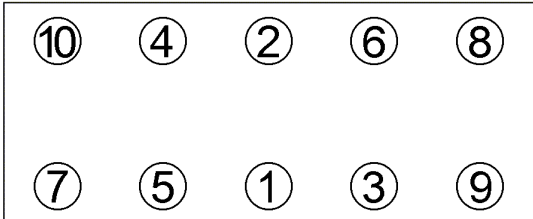


|                                                                                   |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                          |                                                                                                                                          | <b>627.811</b>                                                                                                              | <br>Das Original                                                                                                                                                                  |
| <b>Tightening Instructions for Cylinder Head</b>                                  |                                                                                                                                          | passend für / suitable for<br>adaptable à / adaptable a                                                                     |                                                                                                                                                                                                                                                                    |
| <b>Instructions de serrage pour culasse</b>                                       |                                                                                                                                          | <b>VW / AUDI / SEAT</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                                                     |                                                                                                                                                                                                                                                                    |
|  |                                                                                                                                          |                                            |                                                                                                                                                                                                                                                                    |
| 819.817<br>M 11x1,5x96                                                            |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                   | *<br><br>➤<br>➤                                                                                                                          | 40 Nm<br>60 Nm<br>90°<br>90°                                                                                                |                                                                                                                                                                                                                                                                    |
| Zeichenerklärung / Explanations / Explication / Explicacion                       |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| *<br>★<br>☐<br>●<br>➤                                                             | neue Zylinderkopf-<br>schrauben verwenden<br>Warmlauf (80°C)<br>Schrauben einzeln lösen<br>und wieder anziehen<br>Setzzeit<br>Drehwinkel | use new cylinder<br>head bolts<br>warm up time (80°C)<br>loosen and tighten<br>each bolt<br>relaxation time<br>torque angle | utiliser des vis<br>neuves<br>chauffage (80°C)<br>deserrer et serrer<br>vis par vis<br>durée de tassement<br>angle de serrage<br>emplar tornillos nuevos<br>calentamiento (80°C)<br>aflojar y apretar<br>tornillo a tornillo<br>tiempo de espera<br>ángulo de giro |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                    |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| 2,0 16V                                                                           |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Mot. ABF, ADY, AGG, AKR, AEP<br>85/110 kW (115/150 PS)                            |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| Seat Toledo, Ibiza, Cordoba, Alhambra<br>VW Golf, Vento, Passat, Sharan, Corrado  |                                                                                                                                          |                                                                                                                             |                                                                                                                                                                                                                                                                    |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601    |                                                                                                                                          | <b>*627.811*</b>                                                                                                            |                                                                                                                                                                                                                                                                    |