

AR01.30-P-5800-07VA	Tightening specifications for cylinder head bolts		
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**Modification notes**

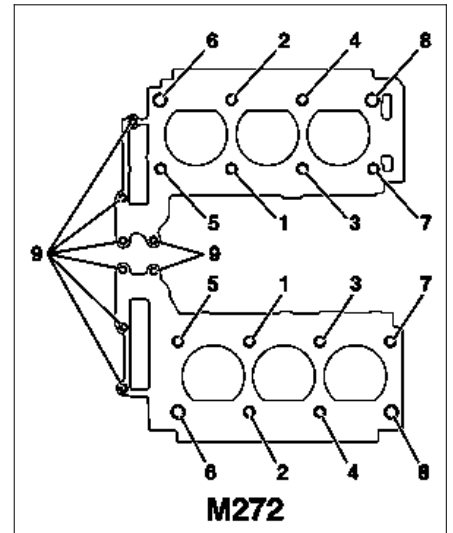
4.10.06	Cylinder head bolt to timing case	Engine 272	*BA01.30-P-1003-01O
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**Nm** **Cylinder head**

Number	Designation				Engine 272
BA01.30-P-1003-01O	Cylinder head bolt to timing case	M8	Stage 1	Nm	15
			Stage 2	Δ°	90
BA01.30-P-1016-01O	Bolt, cylinder head to crankcase	M11	Stage 1	Nm	20
			Stage 2	Nm	40
			Stage 3	Δ°	90
			Stage 4	Δ°	90

Tightening of the cylinder head bolts must take place according to the numerical sequence given in the figure. Loosening of bolts takes place in reverse order.

- 1 Tighten cylinder head bolts (1-8) to stage 1.
- 2 Tighten cylinder head bolts (1-8) to stage 2.
- 3 Tighten cylinder head bolts (1-8) to stage 2 (follow-up tightening).
- 4 Tighten cylinder head bolts (1-8) to stage 3.
- 5 Tighten cylinder head bolts (1-8) to stage 4.
- 6 Tighten bolts (9).



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