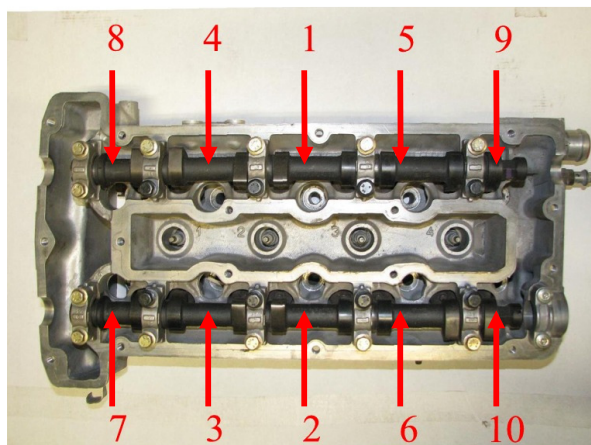


Montering av topplocks-bultar OE,9909



Verkt yg som beh vs; E16 torxh ylsa, momentnyckel minst till 100Nm, krafthandtag g rna med gradskiva, kort f rl ngare, oljekanna.

B rja med att g ra rent samtliga bulth l bl s rent h len med tryckluft. Mycket viktigt att g ngorna  r rena f r att r tt moment skall uppn s vid dragningen. Vid tveksamheter reng r med g ngtapp M14. Applicera tv  droppar olja p  var bults g ngor innan monteringen p b rjas. (pil)



Bultarna dras i tre steg i den ordning som visas p  bilden.

Steg 1; 40Nm
Steg 2; 60Nm
Steg 3; 90 grader (1/4 varv).

Dra f rst ALLA bultarna 40Nm, sedan alla 60Nm .
Efter det skall alla dras ytterligare 90 grader.
Dra dem ALLTID i r tt ordning!

 vre kamdrev dras med 63Nm
Ventilk pans bultar med 15Nm.

Tools to be used; E16 Torx socket, torque wrench, swivel grip, oil can and a short extender.

Start by clean the surfaces and use compressed air into the holes carefully. It's very important that the threads are clean to obtain the right tightness. If needed use a M14 taper tool. Apply 2 drops of oil onto the bolt (as shown in the picture

The tightening sequence is shown in the illustration. Tighten in three stages:

Stage I: 40 Nm (29.5 lbf ft)
Stage 2: 60 Nm (44.3 lbf ft)
Stage 3: A further 90 

Tighten all bolts to 40 Nm, then all to 60 Nm
Then all bolts shall be tighten further 90 
Very important that you follow the sequence

Upper cam gears 63 Nm (47 lbf ft)
Cam shaft cover: 15 Nm (11 lbf ft)