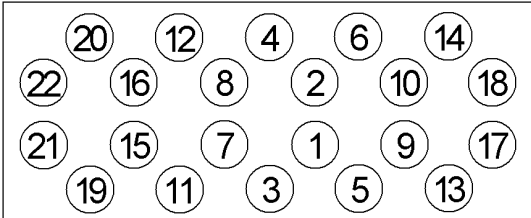


|                                                                                                                                   |                                                                                                                                    |                                                                                                                              |                                                                                                   |                                       |
|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                          |                                                                                                                                    | <b>833.048</b>                                                                                                               | <br>Das Original |                                       |
| <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                                                      |                                                                                                   |                                       |
|                                                  |                                                                                                                                    |                                             |                                                                                                   |                                       |
| 820.114<br>M 10x80/102/115                                                                                                        |                                                                                                                                    |                                                                                                                              |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                   | <div><div>&gt; 12/1988</div><div>* 25 Nm M 8: 25 Nm</div><div>40 Nm</div><div>● 10 min</div><div>➤ 90°</div><div>➤ 90°</div></div> | <div>01/1989 &gt;</div> <div>* 15 Nm</div> <div>35 Nm M 8: 23 Nm</div> <div>➤ 90°</div> <div>● 10 min</div> <div>➤ 90°</div> |                                                                                                   |                                       |
| 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                        |
| <b>Motortyp / Engine type / Type de moteur / Tipo de motor</b>                                                                    |                                                                                                                                    |                                                                                                                              |                                                                                                   |                                       |
| 87 Ø                                                                                                                              |                                                                                                                                    |                                                                                                                              |                                                                                                   |                                       |
| M.B. 602.911, Diesel, 2,5 l, 5 Cyl.<br>602.961, Turbo-Diesel, 66/90 kW (90/122 PS)<br>602.912,<br>602.962,<br>602-930/931/938/939 |                                                                                                                                    |                                                                                                                              |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                    |                                                                                                                                    |                                                                                                                              | <b>*833.048*</b>                                                                                  |                                       |