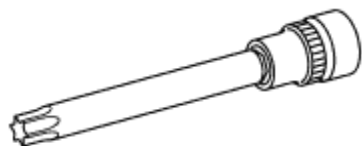


AR01.30-P-5800-07B	Tightening instructions for cylinder head bolts		
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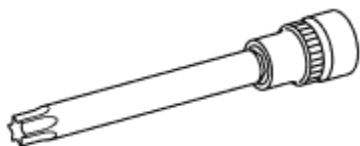
Hm Cylinder head

Number	Designation		Engines 112.920	Engines 113.944	
BA01.30-P-1001-01D	Bolt of cylinder head on crankcase	1st stage	Nm	10	10
		2nd stage	Nm	30	30
		Step 3	4°	90	90
		4th stage	4°	90	90



000 589 03 10 00

Screwdriver insert

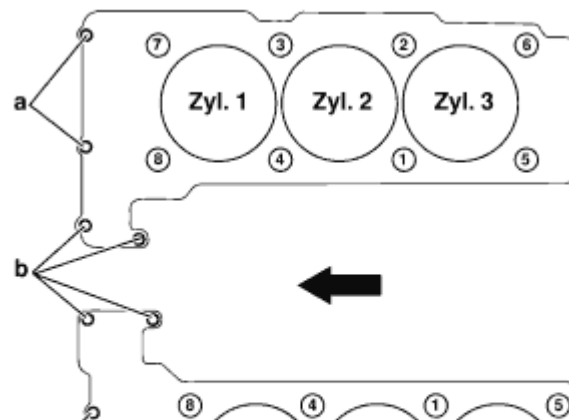


000 589 04 10 00

Screwdriver insert

**Tightening pattern/bolt assignment
Left and right cylinder head M 112**

- 1-8 Collar bolt M11
- A Combination screws M 8×50
(to timing case cover)
- B Combination screws M 8×30
(to timing case cover)



P01.30-2021-11

Tightening instructions for left and right cylinder heads M 112

Use  wrench bit to tighten cylinder head bolts.



Observe sequence, see tightening pattern.

Tightening pattern/bolt assignment Left and right cylinder head M 113

1-10 Collar bolt M11

A Combination screws M 8×50
(to timing case cover)

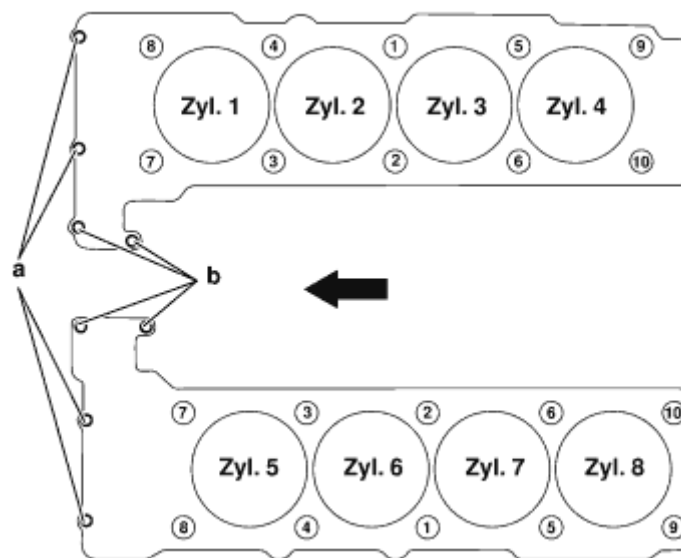
B Combination screws M 8×30
(to timing case cover)



If the tightening torque is exceeded at a cylinder head bolt, unscrew the cylinder head bolt, inspect shank length of the cylinder head bolt in question (replace bolt if necessary) and tighten again fully, beginning with stage 1.



Cylinder head bolts must not be re-tightened.



P01.30-2020-11

Tightening instructions for left and right cylinder head M 113

Use  wrench bit to tighten cylinder head bolts.



Observe sequence, see tightening pattern.



If the tightening torque is exceeded at a cylinder head bolt, unscrew the cylinder head bolt, inspect shank length of the cylinder head bolt in question (replace bolt if necessary) and tighten again fully, beginning with stage 1.



Cylinder head bolts must not be re-tightened.