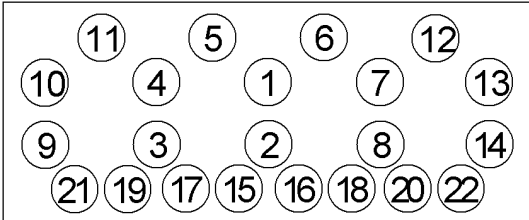


|                                                                                              |                                                                                             |                                                                                         |                                                                                                          |                                       |
|----------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                     |                                                                                             | <b>711.671</b><br>passend für / suitable for<br>adaptable à / adaptable a<br><b>PSA</b> | <br><b>Das Original</b> |                                       |
| <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                 |                                                                                                          |                                       |
| <div></div> |                                                                                             |                                                                                         |                                                                                                          |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                              | * M 12 (POS. 1-14):<br>50 Nm<br>* M 10 (POS. 15-22):<br>35 Nm<br>POS. 1-22:<br>120°±5°<br>➤ |                                                                                         |                                                                                                          |                                       |
| 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>                               |                                                                                             |                                                                                         |                                                                                                          |                                       |
| Mot. DK5ATE, DJ5, DJ5T<br>2446 ccm Diesel/Turbo-Diesel<br><br>605, Boxer                     |                                                                                             |                                                                                         |                                                                                                          |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601               |                                                                                             |                                                                                         | <b>*711.671*</b>                                                                                         |                                       |