

# Anziehvorschrift Zylinderkopf

## Tightening Instructions for Cylinder Head

## Instructions de serrage pour culasse

## Prescripciones de apriete para culatas

986.518

passend für / suitable for  
adaptable à / adaptable a

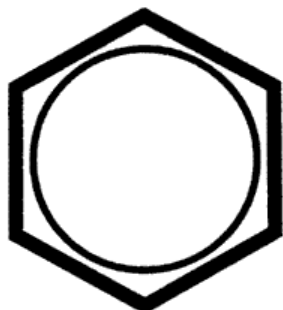
Fiat



Das Original

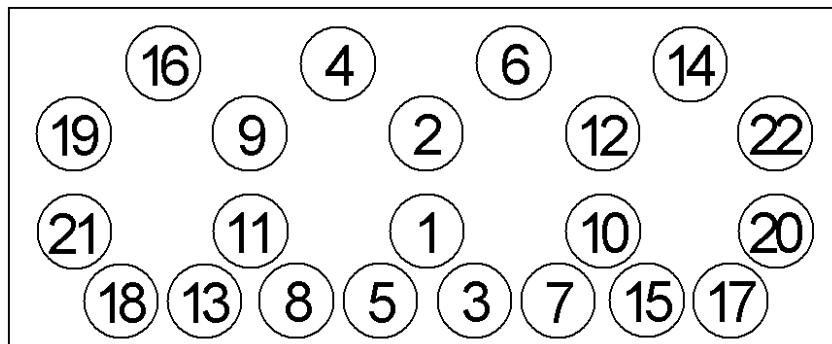
Schraubenkopf / Head shape  
Tête de vis / Cabeza de tornillo

Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete



760.300

M 12x1,25x119/163



Anziehen/  
Tightening/  
Serrage/  
Apriete

20 Nm  
40 Nm  
90°  
90°

## 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                        |

## Motortyp / Engine type / Type de moteur / Tipo de motor

1,43 mm ÷

|                     |          |          |
|---------------------|----------|----------|
| Nuovo Ducato TD     | 2499 ccm | ab 1989> |
| Nuovo Ducato 4x4 TD | 2499 ccm | ab 1989> |
| Master              | 2499 ccm | ab 1990> |

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**\*986.518\***