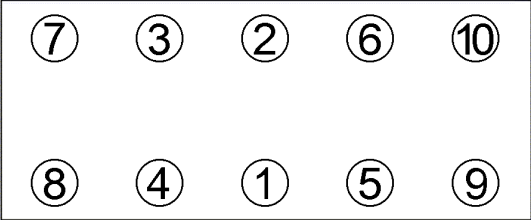


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                             |                                                                                                                                                              |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------|---------------------------------------|-----------------------------|-------------------------|-------------------------|-----|-----------------|---------------------|------------------|----------------------|---|---------------------------------------------|------------------------------|--------------------------------|---------------------------------------|---|----------|-----------------|--------------------|------------------|-----|------------|--------------|------------------|----------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                             | <b>470.080</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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                             | passend für / suitable for<br>adaptable à / adaptable a<br><b>Opel</b><br>Das Original                                                                       |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| <br>820.297<br>M 11 x 154                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                             | Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete<br> |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| <table border="0"> <tr> <td>Anziehen/</td> <td>★</td> <td>25 Nm</td> </tr> <tr> <td>Tightening/</td> <td>➤</td> <td>90°</td> </tr> <tr> <td>Serrage/</td> <td>➤</td> <td>90°</td> </tr> <tr> <td>Apriete</td> <td>➤</td> <td>45°</td> </tr> <tr> <td></td> <td>★</td> <td>15 min</td> </tr> <tr> <td></td> <td>➤</td> <td>30°</td> </tr> <tr> <td></td> <td>➤</td> <td>15°</td> </tr> </table>                                                                                                                                                                                                                                                                                                                                                                                               |                                             |                                                                                                                                                              |                                                                                   | Anziehen/                             | ★                                     | 25 Nm                       | Tightening/             | ➤                       | 90° | Serrage/        | ➤                   | 90°              | Apriete              | ➤ | 45°                                         |                              | ★                              | 15 min                                |   | ➤        | 30°             |                    | ➤                | 15° |            |              |                  |                |
| Anziehen/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | ★                                           | 25 Nm                                                                                                                                                        |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| Tightening/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | ➤                                           | 90°                                                                                                                                                          |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| Serrage/                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | ➤                                           | 90°                                                                                                                                                          |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| Apriete                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | ➤                                           | 45°                                                                                                                                                          |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | ★                                           | 15 min                                                                                                                                                       |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | ➤                                           | 30°                                                                                                                                                          |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | ➤                                           | 15°                                                                                                                                                          |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                             |                                                                                                                                                              |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| <table border="1"> <tr> <td>★</td> <td>neue Zylinderkopf-schrauben verwenden</td> <td>use new cylinder head bolts</td> <td>utiliser des vis neuves</td> <td>emplar tornillos nuevos</td> </tr> <tr> <td>★</td> <td>Warmlauf (80°C)</td> <td>warm up time (80°C)</td> <td>chauffage (80°C)</td> <td>calentamiento (80°C)</td> </tr> <tr> <td>☐</td> <td>Schrauben einzeln lösen und wieder anziehen</td> <td>loosen and tighten each bolt</td> <td>deserrer et serrer vis par vis</td> <td>aflojar y apretar tornillo a tornillo</td> </tr> <tr> <td>●</td> <td>Setzzeit</td> <td>relaxation time</td> <td>durée de tassement</td> <td>tiempo de espera</td> </tr> <tr> <td>➤</td> <td>Drehwinkel</td> <td>torque angle</td> <td>angle de serrage</td> <td>ángulo de giro</td> </tr> </table> |                                             |                                                                                                                                                              |                                                                                   | ★                                     | 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 |
| ★                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 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><br><br>1,7 Ltr. D<br><br>Mot. X 17 DTL , X 17 DR<br>÷ 1,4 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                             |                                                                                                                                                              |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                             | <b>*470.080*</b>                                                                                                                                             |                                                                                   |                                       |                                       |                             |                         |                         |     |                 |                     |                  |                      |   |                                             |                              |                                |                                       |   |          |                 |                    |                  |     |            |              |                  |                |