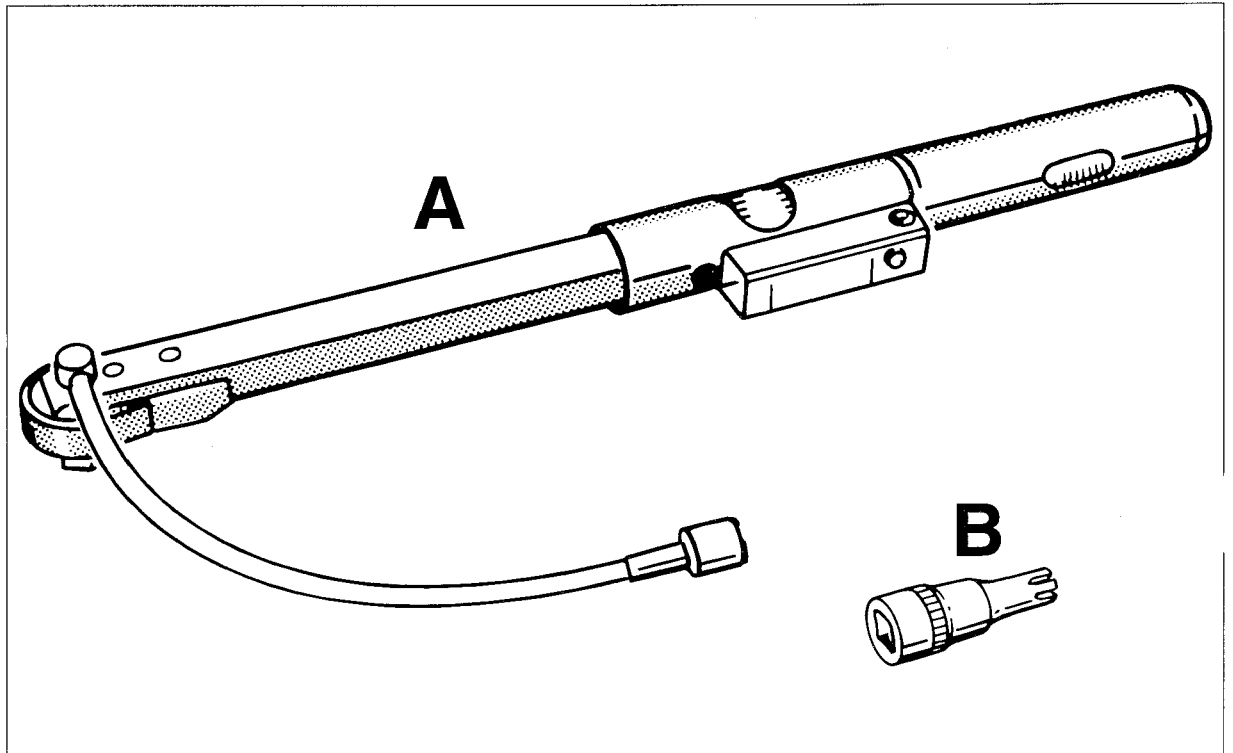


15 70 23 Installing cylinder head

Tools



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Item	Designation	Special tool	Explanation
A	Torque angle Torque wrench		Refer to Workshop Equipment Manual, Chapter 2.4, No. 88
B	Socket wrench insert Torx T50	9633	
	Socket wrench insert Torx T55	Commercially available	As of engine number M96/01 66X03084 M96/02 68X01044 (modified cylinder head screws)

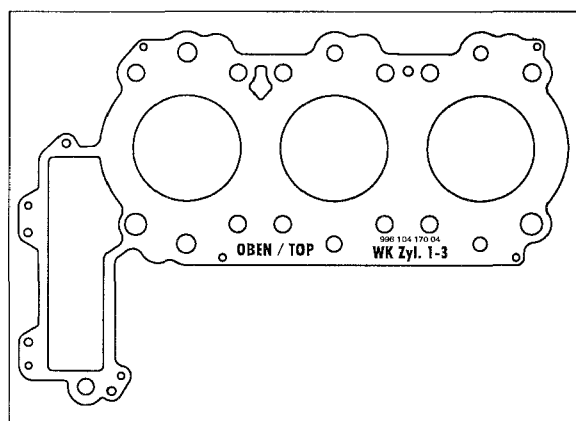
Installing cylinder head

1. Fit cylinder head gaskets.

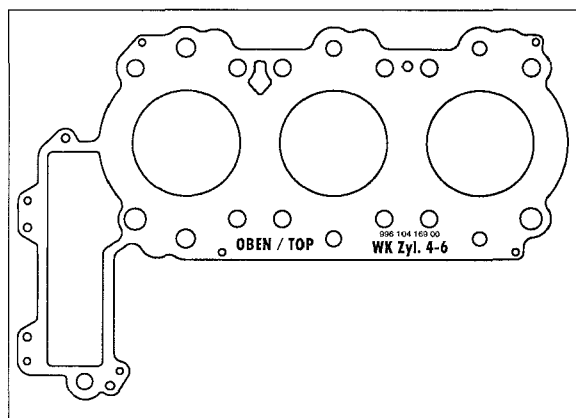
Note

The gaskets are identified by Zyl. 1 - 3 or Zyl. 4 - 6 with OBEN/TOP, plus the corresponding part number.

Ensure correct seating of dowel sleeves in crankcase. Put on gaskets.



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2. Fasten cylinder heads.

Moisten cylinder-head screws thinly
with engine oil.

Tightening sequence of cylinder-head screws**Initial tightening or tightening to flatten**

1st step: 30 Nm (23 ftlb.)

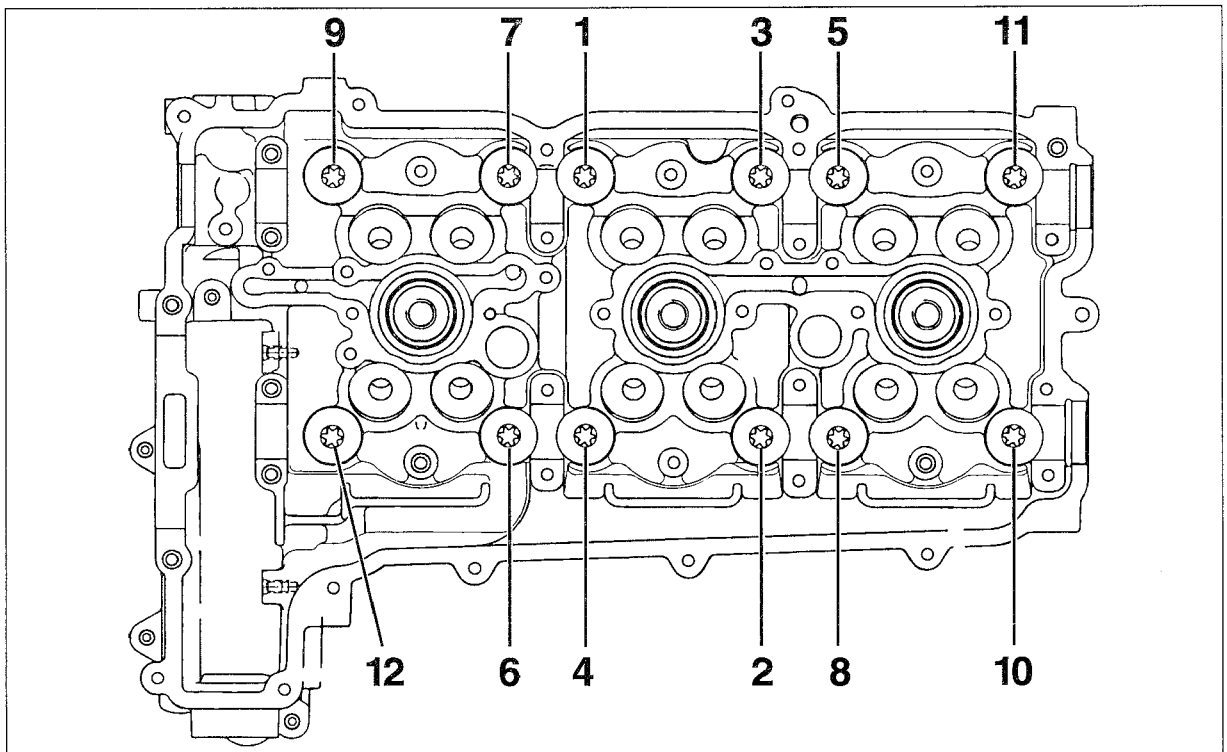
2nd step: Completely loosen cylinder head screws

Final tightening

1st step: Application torque **20 Nm (15 ftlb.)** in **prescribed** tightening sequence

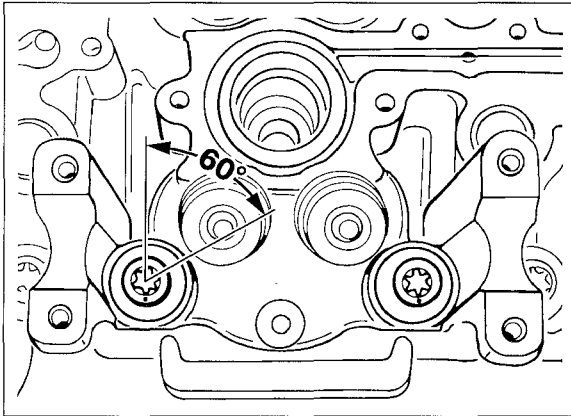
2nd step: Torque-angle tightening **1 x 60° ± 2°** in same sequence

3rd step: Torque-angle tightening **1 x 60° ± 2°** in same sequence



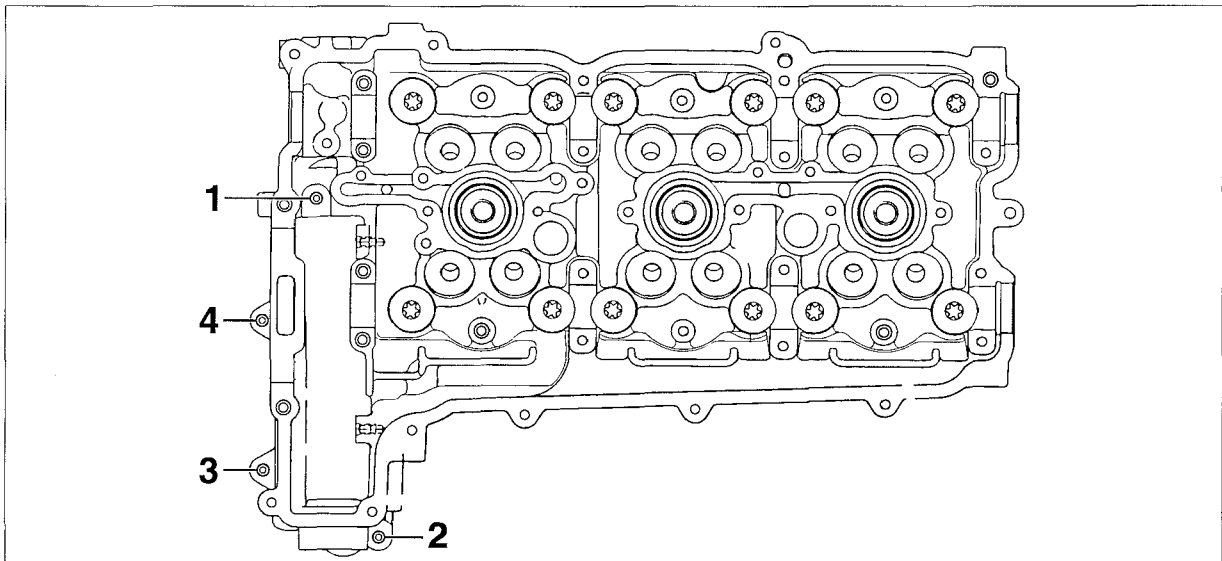
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Diagram shows torque-angle tightening with 60°



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3. After tightening the cylinder-head screws, additionally fasten four pan-head screws M6 x 35 (10.9) (with captive washers) in the area of the chain box.
Tightening torque 13 Nm (10 ftlb.)



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