

4 - ENGINE

(CONTINUES FROM POINT 55)

56. Fit:

- The front timing chain roller (81).
- The cylinder head gasket (82) (new gasket).
- The coolant pipe (83).



N.B.

REMEMBER TO FIT THE FRONT CHAIN ROLLER BEFORE FITTING THE CYLINDER HEAD.



57. Fit:

- The cylinder head (84).



N.B.

TIE A PIECE OF WIRE TO THE TIMING CHAIN TO PREVENT IT FROM DROPPING INTO THE ENGINE.



CAUTION

APPLY OIL TO THE WASHERS OF THE 4 BOLTS JOINING THE CYLINDER HEAD TO THE CRANKCASE.

58. Fit:

- The washers (85) impregnated with engine oil onto the M8 bolts (86).
- The 4 M8 bolts (86) securing the cylinder head to the crankcase.
- The 2 M6 bolts (87) securing the cylinder head to the crankcase.

Bolts securing the cylinder head to the crankcase.

Bolts M8 - 2,7 kgf.m + 90° (27 N.m + 90°)

Bolts M6 - 1,1-1,3 kgf.m (11-13 N.m)



CAUTION

TIGHTEN THE M8 BOLTS FIRST.

TIGHTEN THE CYLINDER HEAD BOLTS IN SUCCESSION CROSSWISE, GOING FROM ONE TO THE OTHER TWO OR THREE TIMES.



N.B.

AFTER TIGHTENING THE M8 BOLTS TO THEIR INDICATED TORQUE, THEY SHOULD BE TURNED ANOTHER 90° (1/4 OF A TURN).

Manual Derbi Gpr 5

Volvo Penta



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Derbi GPR 50 R ,1997
MD 5 Volvo Penta,2015-04-13

Instruction Manual for the MG 1,5 Litre Anonym Anonym,2009-12
VCE-5 Milena Kovač,Eildert Groeneveld,2003

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