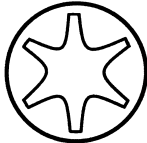
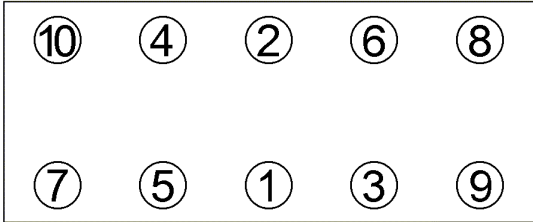


|                                                                                                                |                                             |                                                                                   |                                                                                                   |                                       |
|----------------------------------------------------------------------------------------------------------------|---------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Anziehvorschrift für Zylinderkopf</b>                                                                       |                                             | <b>646.480</b>                                                                    | <br>Das Original |                                       |
| <b>Tightening Instructions for Cylinder Head</b>                                                               |                                             | passend für / suitable for<br>adaptable à / adaptable a<br><b>Ford</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           |                                                                                                   |                                       |
| <br><br>802.870<br>M 10 x 102 |                                             |  |                                                                                                   |                                       |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                |                                             | * 20-30 Nm<br>40-50 Nm<br>➤ 90°-120°                                              |                                                                                                   |                                       |
| 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. 1,8 l ZETEC ZH 18, 77-95 kW (105-130 PS)                                                                  |                                             |                                                                                   |                                                                                                   |                                       |
| Fiesta, Escort, Orion 1/1992>                                                                                  |                                             |                                                                                   |                                                                                                   |                                       |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                 |                                             |                                                                                   | <b>*646.480*</b>                                                                                  |                                       |