

## **1. Mounting cylinder head:**

- . Never place the cylinder head on the coupling face, this may cause damage to the face or valves.
- . Try to find the cause of the cylinder head damage and fix it first.
- . Check the cylinder walls and pistons for damage and remove carbon residues.
- . Thoroughly clean all parts to be transferred and check them for wear or damage.
- . Check the head gasket surface of the engine for damage and deformation.
- . Clean the fitting surface and bolt holes, paying attention to the roughness of the block (as smooth as possible).
- . Always use new bolts (if specified) of the correct dimensions.
- . Mount head gasket of the correct thickness and type with the right side up.
- . Follow the prescribed tightening torques and sequence.
- . Note that the timing marks of the distribution are correct and install new timing belts and tension / rollers.
- . Allow hydraulic tappets to rest for at least one hour after installation to be able to adjust. Preferably rest overnight.
- . Adjust the valve clearance for fixed tappets / damper plates with a margin of 0.05mm extra.
- . After adjusting the distribution, first turn the engine by hand two turns to check that the valves do not touch the piston.
- . Always replace the oil, oil filter, thermostat and coolant according to the type and type designation prescribed by the manufacturer.
- . Check the radiator and water pump for leaks and operation.
- . In an LPG installation, allow the engine to run on petrol for the first 1000 kilometers and then adjust the installation.
- . Check ignition / injection system / fuel pump adjustment.
- . take a test drive and check everything again.

If you have any questions, please contact our sales department.

The above information is only intended as advice to our customers. No rights can be derived from the information. Manufacturer's instructions always take precedence.