



TORQUE SETTINGS

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| Big end cap nuts | 50 Nm |
| Camshaft bearing cap nuts | 17.5 Nm |
| Camshaft gear bolt | 40 Nm |
| Crankshaft pulley bolt | 40 + 60 Nm |
| Cylinder head bolts: | |
| pre - tightening | 30 Nm |
| tightening | 60 Nm |
| slackening | 1/4 turn |
| re - tightening | 70 Nm |
| Cylinder head cover bolts | 10 Nm |
| Exhauster pulley bolts | 35 Nm |
| Flywheel bolts | 50 Nm |
| Glow plugs | 22 Nm |
| Injection pump gear bolts | 50 Nm |
| Injectors | 90 Nm |
| Main bearing cap bolts | 70 Nm |
| Oil pump bolts | 20 Nm |
| Oil seal carrier bolts, timing gear end | 15 Nm |
| Sump to block bolts | 20 Nm |
| Timing belt tensioner | 15 Nm |

TOOL NUMBERS

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| 18G 55A | Piston ring compressor |
| 18G 1507 | Oil seal replacer |
| 18G 1509 | Oil seal replacer |
| 18G 1519 | Valve spring compressor |
| 18G 1627 | Oil seal replacer - rear main bearing cap side seal |
| 18G 1628 | Oil seal replacer |