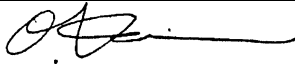
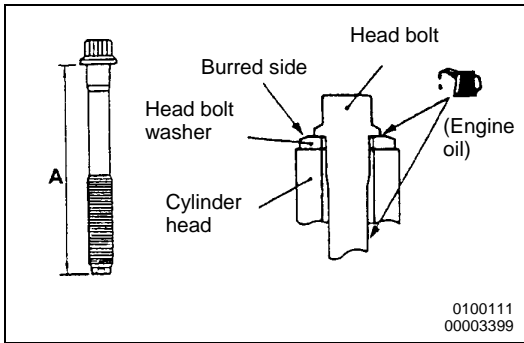




# SERVICE BULLETIN

PUBLICATION GROUP, AFTER SALES SERVICE DEP.  
MITSUBISHI MOTOR SALES EUROPE BV

<b>SERVICE BULLETIN</b>		No.: ESB-99E11-504	
		Date: 1999-07-15	<Model> <M/Y>
<b>Subject:</b> CORRECTION IN CYLINDER HEAD BOLTS INSTALLING PROCEDURE		(EC) SPACE STAR (DG0A)	99-10
<b>Group:</b> ENGINE			
<b>INFORMATION</b>		 O. Kai - E.V.P. & G.M. After Sales Service Dept.	
<b>1. Description:</b>			
This service bulletin informs you of the Correction in cylinder head bolts installing procedure.			
<b>2. Applicable Manuals:</b>			
<b>Manual</b>	<b>Pub. No.</b>	<b>Language</b>	<b>Page(s)</b>
'99 SPACE STAR Workshop Manual Chassis	CMXE99E1	(English)	11A-28
	CMXS99E1	(Spanish)	
	CMXF99E1	(French)	
	CMXG99E1	(German)	
	CMXD99E1	(Dutch)	
	CMXW99E1	(Swedish)	
	CMXI99E1	(Italian)	
<b>3. Details:</b>			
Refer to the attached sheet.			

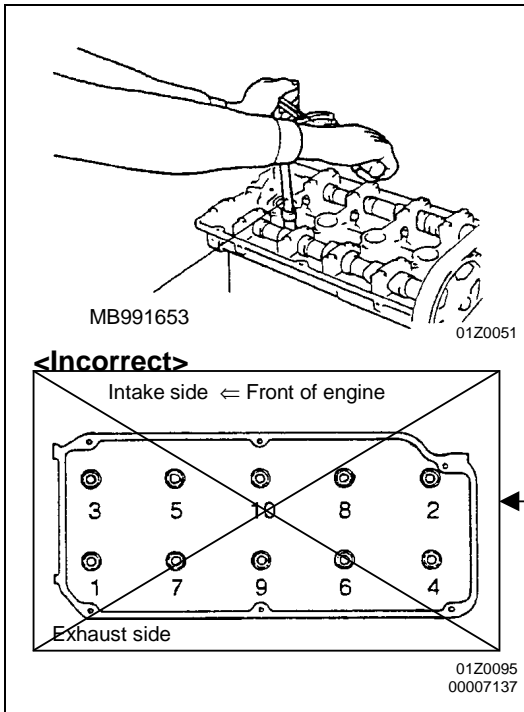


CYLINDER HEAD BOLT INSTALLATION

1. When installing the cylinder head bolts, the length below the head of the bolts should be within the limit. If it is outside the limit, replace the bolts.

**Limit (A): 96.4 mm**

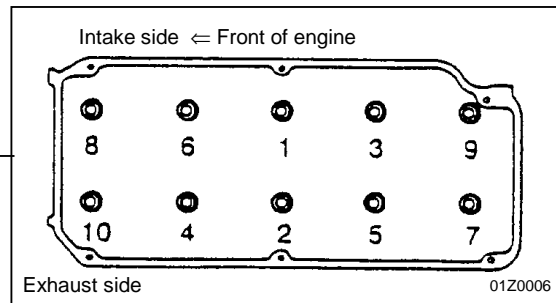
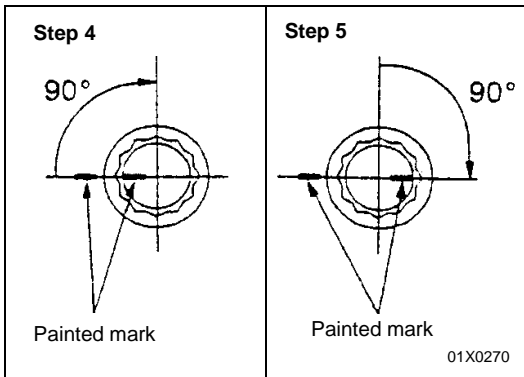
2. The head bolt washer should be installed with the burred side caused by tapping out facing upwards.
3. Apply a small amount of engine oil to the thread section and the washer of the cylinder head bolt.
4. Tighten the bolts by the following procedure.



Step	Operation	Remarks
1	Tighten to 74 Nm.	Carry out in the order shown in the illustration
2	Fully loosen	Carry out in the reverse order of that shown in the illustration
3	Tighten to 20 Nm.	Carry out in the order shown in the illustration
4	Tighten 90° of a turn.	In the order shown in the illustration. Mark the head of the cylinder head bolt and cylinder head by paint.
5	Tighten 90° of a turn.	In the order shown in the illustration. Check that the painted mark of the head bolt is lined up with that of the cylinder head.

**Caution**

- (1) Always make a tightening angle just 90°. If it is less than 90°, the head bolt will be loosened.
- (2) If it is more than 90°, remove the head bolt and repeat the procedure from step 1.



**<Correct>**