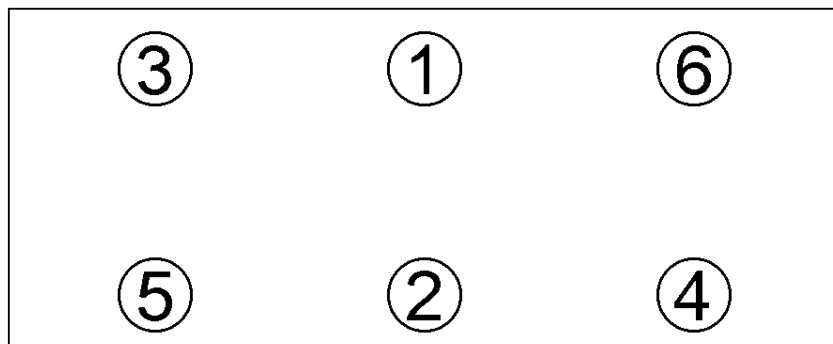
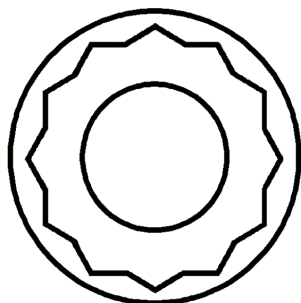


**Anziehvorschrift Zylinderkopf****Tightening Instructions for Cylinder Head****Instructions de serrage pour culasse****Prescripciones de apriete para culatas****649.280**passend für / suitable for  
adaptable à / adaptable a**Das Original**Schraubenkopf / Head shape  
Tête de vis / Cabeza de tornillo

Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete

Anziehen/  
Tightening/  
Serrage/  
Apriete

➤ -&gt; MY 2009

29 Nm

69 Nm

➤ losen 180°

➤ losen 180°

49 Nm

➤ 80° - 90°

➤ 40° - 45°

➤ only bolt 1&amp;2: 45°

➤ MY 2010 -&gt;

Step 1-5:

40 Nm

95 Nm

➤ losen 180°

➤ losen 180°

10 Nm

➤ MY 2010 -&gt;

Step 5-10:

30 Nm

70 Nm

➤ 80° - 90°

➤ 40° - 45°

➤ only bolt 1&amp;2: 45°

**Zeichenerklärung / Explanations / Explication / Explicacion**

|  |                                                |                                 |                                   |                                          |
|--|------------------------------------------------|---------------------------------|-----------------------------------|------------------------------------------|
|  | neue Zylinderkopf-<br>schrauben verwenden      | use new cylinder head<br>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<br>und wieder anziehen | loosen and tighten each<br>bolt | deserrer et serrer<br>vis par vis | aflojar y apretar<br>tornillo a tornillo |
|  | Setzzeit                                       | relaxation time                 | durée de tassement                | tiempo de espera                         |
|  | Drehwinkel                                     | torque angle                    | angle de serrage                  | ángulo de giro                           |

**Motortyp / Engine type / Type de moteur / Tipo de motor**

Ø: 93,5 mm; ÷: 0,6 mm

Mot: EJ20X/Y; EJ204; EJ205

2.0 ltr. 16V Boxer

2006 &gt;

Forester, Exiga, Legacy, Liberty, Impreza

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**\*649.280\***