



## TORQUE SETTINGS

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

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