

4. Lightly lubricate new cylinder head bolts. Loosely install bolts with washers. Thread all bolts in finger tight.

CAUTION —

- Torx-type cylinder head bolts should not be reused. They are stretch-type bolts and must always be replaced whenever loosened.
- Do not wash protective coating from new bolts.
- Check that all washers for the head bolts are in place before installing bolts. Some washers may be staked to the cylinder head.

5. Tighten cylinder head bolts in stages, alternately and diagonally in the sequence shown. See Fig. 53.

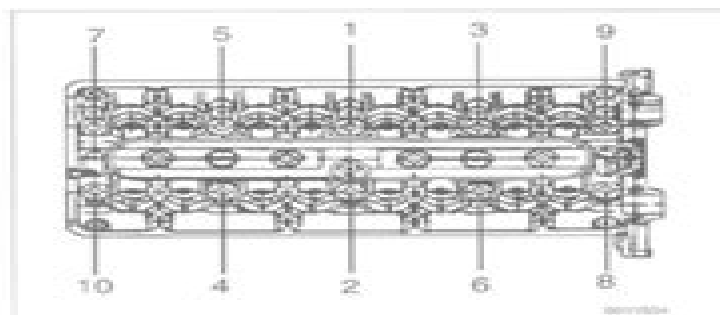


Fig. 53. Cylinder head bolt tightening sequence (M60 engines).

WARNING —

The use of a special tool (BMW Tool Kit, 11 21 1 10) or a suitable protractor is required to tighten head bolts to a specified torque angle. See Fig. 26, given earlier.

Tightening Torques

- Cylinder head to cylinder block (M60 engines)

stage 1	30 Nm (22 ft-lb)
stage 2	+80°
stage 3	+80°

6. Install chain guide rail and guide rail mounting bolt.

7. Position camshafts and crankshaft at TDC and lock shafts in position using BMW special tools. See 117 **Camshaft Timing Chain**.

8. Install intake sprocket (right cylinder head) to timing chain and camshaft with arrow on sprocket pointing up and dowel pin for camshaft position sensor in lower left. See Fig. 54.

- Bolt holes in sprocket should be centered to threaded bores in camshaft. Tighten sprocket bolts finger tight.

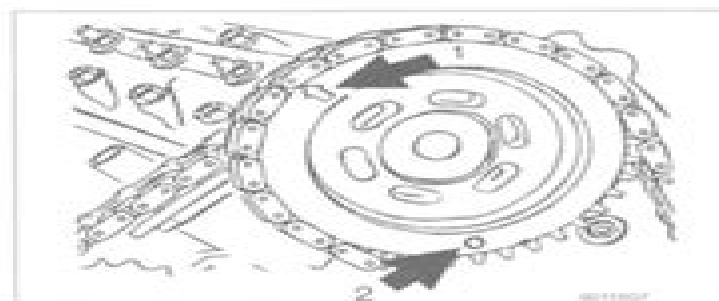


Fig. 54. Intake sprocket correctly aligned to camshaft, with arrow pointing up (1) and sensor pin in lower left (2).

9. Adjust camshaft timing and tighten sprocket mounting bolts as described in 117 **Camshaft Timing Chain**.

- Install front timing chain cover, using new gaskets and new O-ring for tensioner oil feed (between cover and cylinder head).

10. Remove protective film from gaskets. Seal lower corners of cover to cylinder head. Tighten bolts in two stages, tightening cover-to-cylinder block bolts first.

11. Install camshaft timing chain tensioner.

12. The remainder of installation is the reverse of removal, noting the following special instructions:

- Use new gaskets when mounting the intake manifold. Tighten nuts finger tight first, then torque to specification in stages working diagonally from inside to outside.
- Refill and bleed cooling system as described in 170 **Radiator and Cooling System**.
- Change the engine oil and filter as described in 020 **Maintenance Program**.

CAUTION —

To prevent damaging engine electronic systems, be sure to install all ground wires previously removed.

NOTE —

Tightening torques are given on the following page.

REMOVING AND INSTALLING CYLINDER HEAD

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