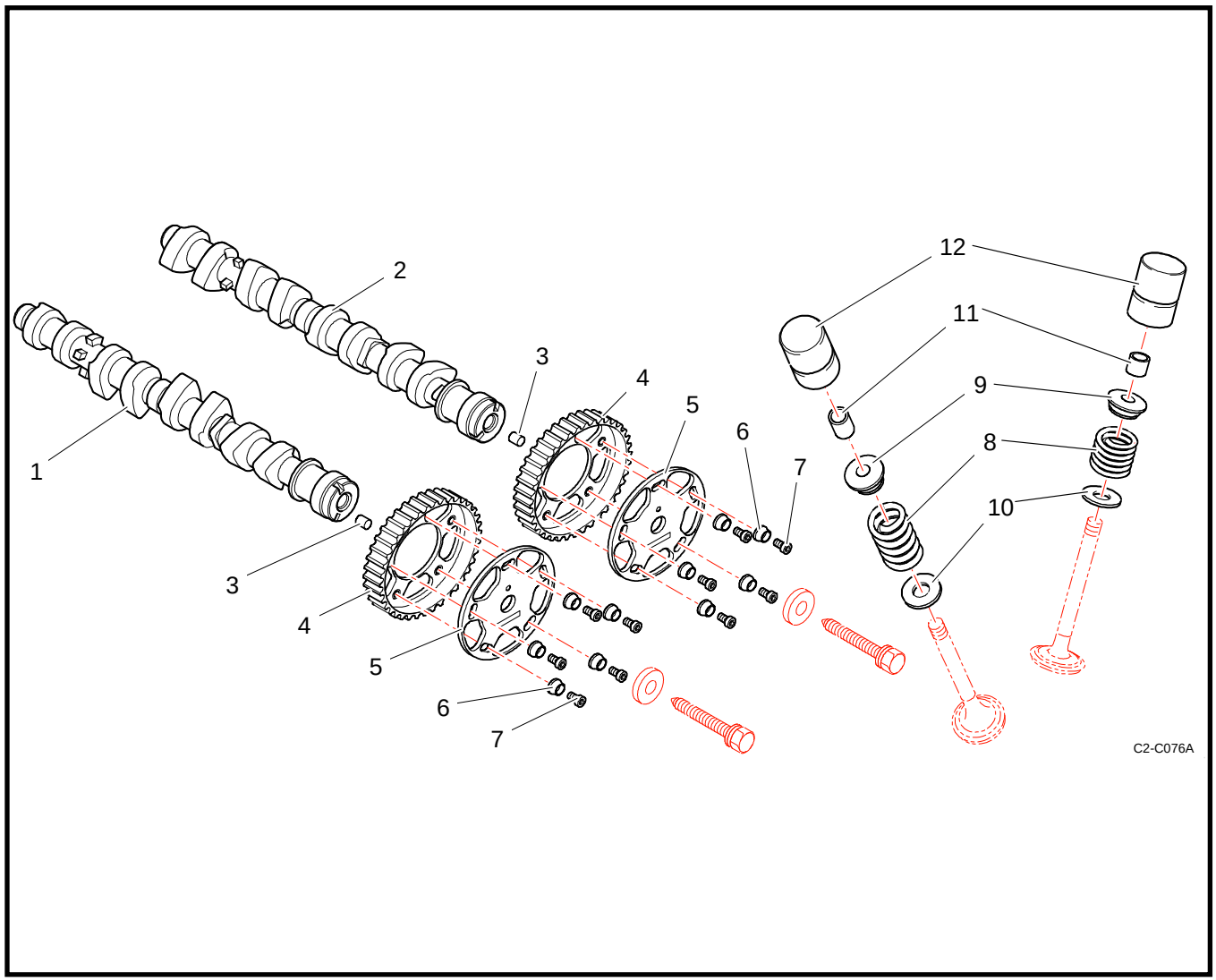
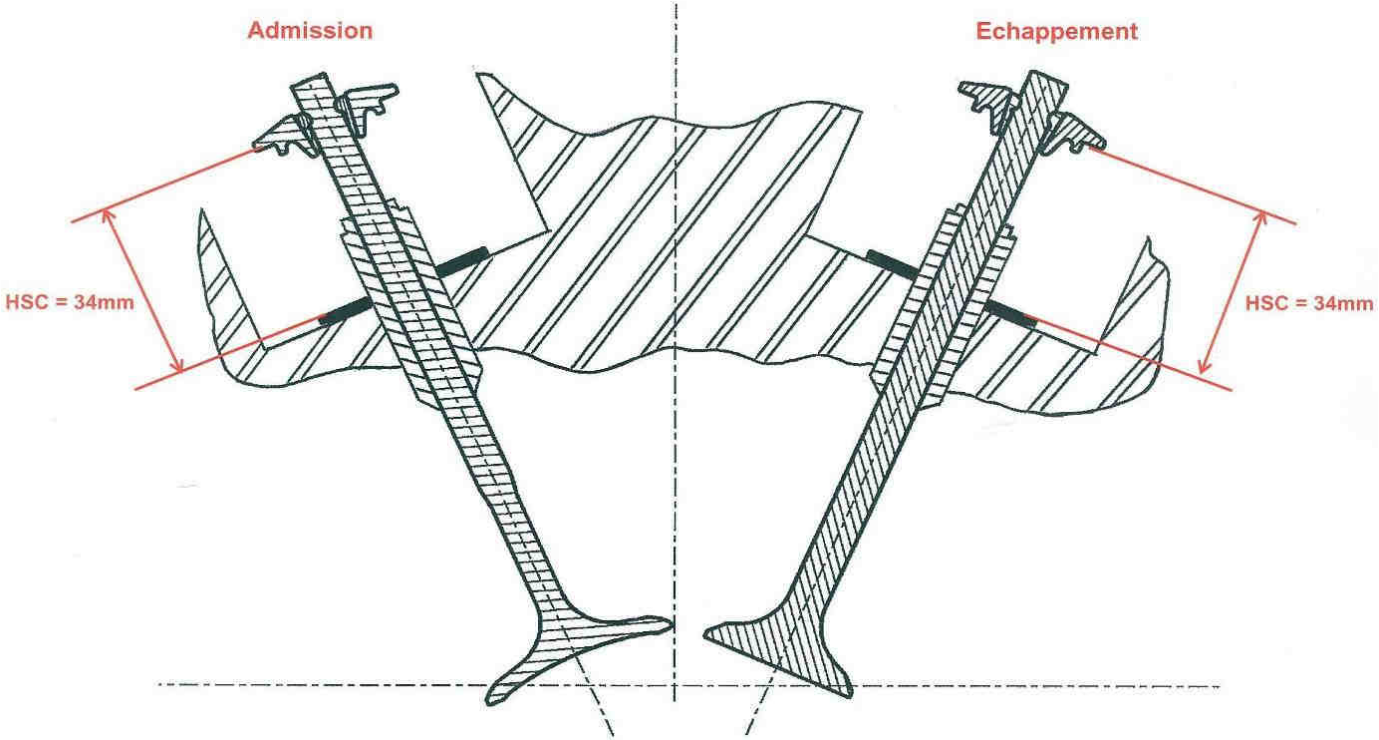
A14 : TIMING



REF	PART NUMBER	QTY	DESCRIPTION
1	0A1461453A	1	Intake camshaft
2	0A1461454A	1	Exhaust camshaft
3	PS78034A10	2	Camshaft lock pin
4	0A1461450A	2	Camshaft pulley
5	0A1461446A	2	Camshaft pulley hub
6	0A1461449A	10	Camshaft pulley specific washer
7	CS530167ST	10	Camshaft pulley alen screw M6 l12, cl8.8
8	0A1461445A	16	Valve spring
9	0A1461443A	16	Top spring cap
10	BCSP095327	16	Low spring cap
11	0A1462612A	16	Valve shim, thickness 3mm
12	0A1461444A	16	Tappet, ø28.37mm
13			
14			

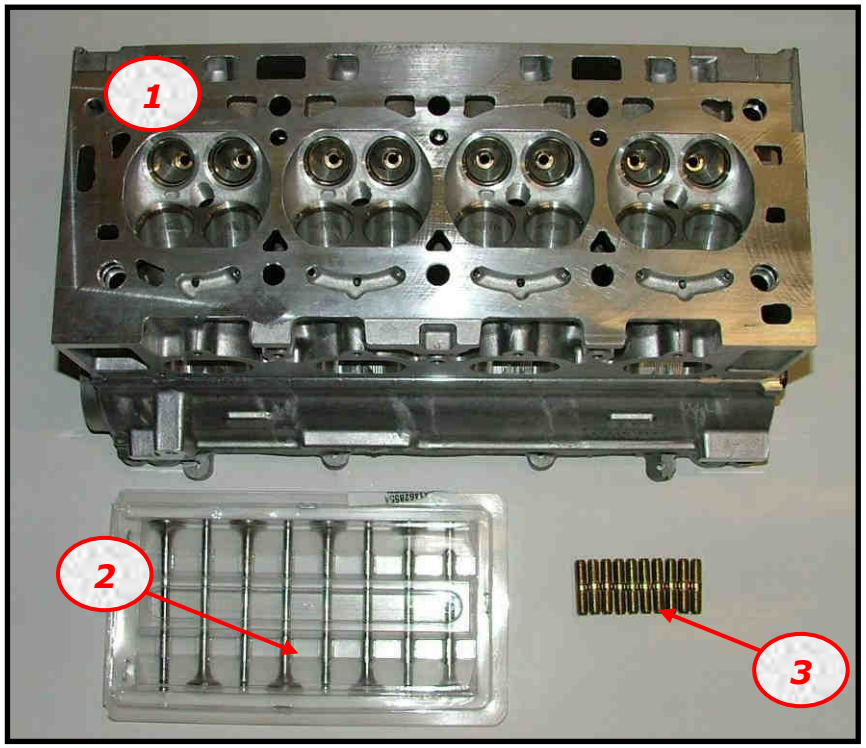
TIMING ASSEMBLY

	First of all, assembly without torquing the camshaft pulley hub with camshaft pulley, specific washers and screws.	
	Check the height between top and low cups, as shown on drawing below : 	Inlet = **34 mm** Exhaust = **34 mm**

! ! !	If you use the cylinder head **A6R2-A130.OPT.01** (see page 14), you need to readjust the height between low and top cups by using 2 low cups for the inlet, and 3 for the exhaust (part number BCSP095327, page 10). **!!! Check also the height between low and top cup it, if necessary readjust it !!!**	
	Assembly breaked in valves, low cups, valves springs, top cups, valve clips, valve shims and tappet	
	Do the valve clearance, before sealing the camshafts caps.	Inlet = **0.20** to **0.22**mm Exhaust = **0.25** to **0.28**mm
	Do the timing. The best and more precise way is to do with valve lifts, piston on dead top center position.	Inlet = **5.1**mm **! WHITOUT CLEARANCE !** Exhaust = **3**mm
	Camshaft pulley screws torque *(ref 7)*	**1** m.kg
	Camshaft pulley hub screw / camshaft torque	**5** m.kg + Loctite **242**

	Cylinder head screws torque	**2** m.kg + **260°** (apply some oil or copper grease on screw thread)
	Cylinder head camshaft caps screws	**1** m.kg + oil

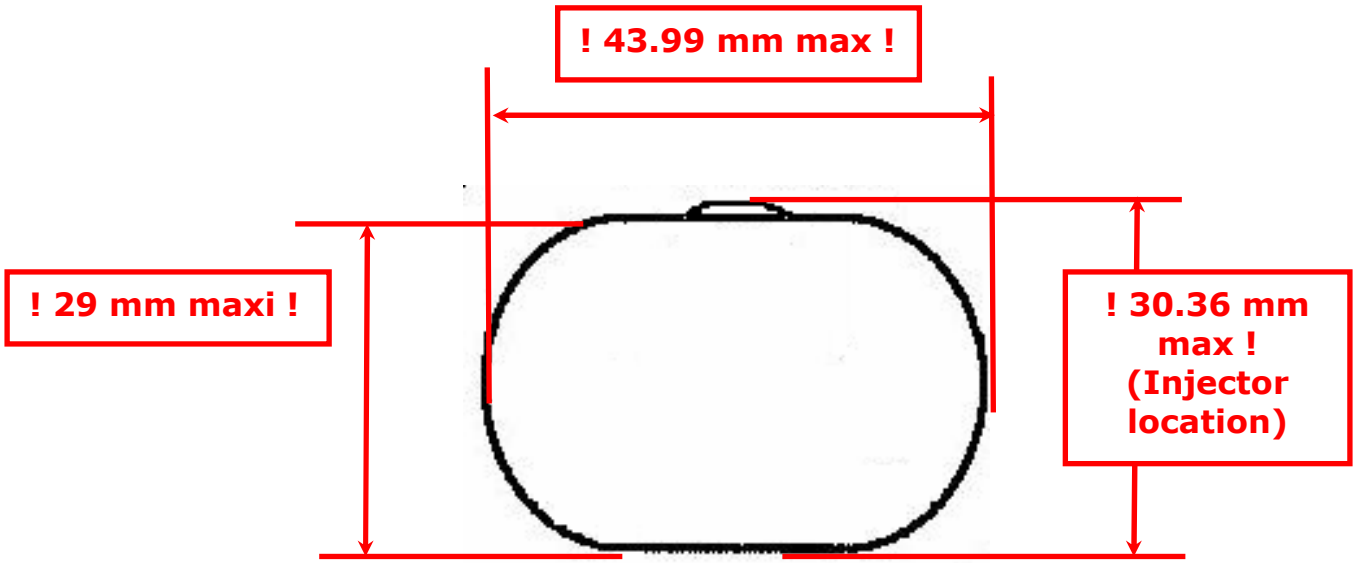
A14 : CYLINDER HEAD (OPTION)



MACHINED DUCTS DETAIL

REP	PART NUMBER	QTY	DESCRIPTION
A	A6R2-A130.OPT.01	1	Complete Machined Cylinder Head (1+2+3+4+5)
1	0A1362852D	1	Naked machined cylinder head
2	0A1462855A	8	Exhaust Valve
3	0A1362900A	10	Exhaust Short Stud
4	BCSP693644	10	Exhaust Stud Nut
5	9621308080	4	Spark plug hole
7			
8			
10			
11			
12			
13			
14			
15			

CYLINDER HEAD ASSEMBLY

	To have the right power of the engine, machine your inlet manifold (the surface in contact with the head) to the homologated maximum size, as shown on the picture below :  	
	Do a polishing of inlet manifold ducts, like the head ducts.	
	Check if inlet manifold ducts are centered with cylinder ducts. **Nota :** Head ducts are always bigger than the manifold ducts. Just check the centering, to have the best permeability as possible.	