

INSTRUCCIONES PARA EL MONTAJE Y AJUSTE DE JUNTAS DE CULATA
INSTRUCTIONS FOR HEAD GASKETS ASSEMBLY AND ADJUSTMENT

1 Quitar todo el resto de suciedad sobre el plano de la culata, no dañando en especial las tapas de aluminio.
Remove the grime remaining, degreasing with an adequate solvent.

1 Remove all dirt from the plane of the head gasket. Remove the remaining grease by using a proper solvent.

2 Pasar un macho roscado por los alojamientos de los tornillos en el block y aspirar mediante una jeringa toda suciedad, agua o aceite que pueda hallarse en el fondo de los orificios, ya que al ajustar el tornillo esto haría de cuerpo sólido ocasionando una falsa lectura con su consiguiente perjuicio (junta floja.)

2 Put a taper tap through the screw housing in the block and remove by means of a syringe all dirt, water or oil that can be found at the hole bottom, since this would act as solid body while tightening the screw resulting in a false reading with subsequent damage (loose gasket)

3 Comprobar la planitud del block y la tapa en el plano de la junta.

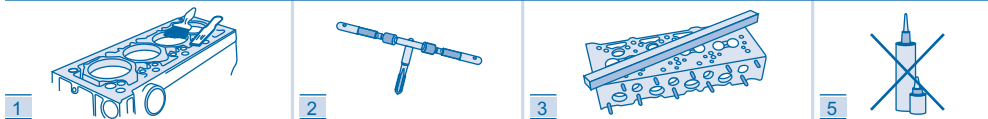
3 Check the block flatness and the lid in the gasket plane

4 Comprobar que la junta seleccionada sea la correcta. (Ver pág. 2/3).

4 Verify the chosen gasket is the correct one (See pag 2/3).

5 No aplicar ningún producto sellante sobre la junta de culata (adhesivos, selladores, etc.) Las juntas Taranto cuentan con selladores incorporados en zonas específicas que le brindan una mayor fuerza de cierre. Además cuentan con recubrimientos selladores superficiales con propiedades antiadherentes.

5 Do not apply any sealing product over the head gasket (adhesives, sealers, etc.) Taranto gaskets have sealing products in specific areas which provide a greater close strength. They also have superficial sealing coating with anti adherent properties.



6 En los casos de tapa de cilindros con apriete angular es imprescindible utilizar tornillos nuevos al montar la junta.

6 In case of cylinder lid with angular tightening, it is essential to use new screws when assembling the gasket.

7 Engrasar ligeramente los tornillos en la rosca, debajo de la cabeza de los mismos y/o arandelas. Utilice la grasa especial proporcionada por Taranto en los nuevos tornillos.

7 Slightly grease screws in the thread, under their head, and/or washers. Use special grease provided by Taranto in the new screws.

8 Ajustar los tornillos siguiendo el orden y secuencia indicados en el diagrama de apriete (Página 2/3). Para las tapas de cilindro de aluminio, debido a su alta dilatación térmica, el ajuste debe realizarse en frío. En caso de tapas de cilindro de fundición, pueden ajustarse tanto en frío como en caliente.

8 Tighten screws following the order and sequence indicated in the diagram. (Página 2/3) For the aluminium cylinder lid, due to its high thermal expansion, the adjustment must be done when cold. In case of casting cylinder lids, they can be either hot or cold adjusted.

TORNILLOS DE CULATA CON FLANGE
Cylinder head Capscrews with flange

TORNILLOS DE CULATA CON ARANDELA
Cylinder head Capscrews with washer



ATENCIÓN!!!
Nunca lubricar la cara de la arandela contra la culata.
Never do lubricate the face of the washer Over the cylinder head.



Cuando se aplica un apriete por ángulo es imprescindible sustituir todos los tornillos de culata de cilindros.
When tightening by angle it is essential the replacement of all bolts of cylinder head.

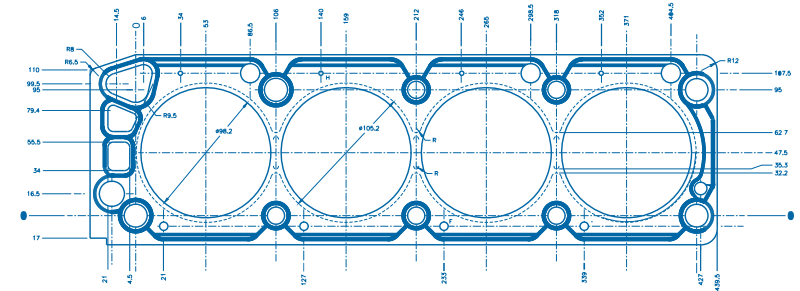
CUIDADOS AMBIENTALES - Environmental Care



Finalizada la vida útil de este producto, por estar en contacto con aceite, debe desecharse de acuerdo a los requerimientos de la legislación local. After the service life of this product to be in contact with oil should be discarded according to the requirements of local legislation.



CONSIDERACIONES GENERALES - General Consideration



MATERIALES JUNTAS TAPA DE CILINDROS - Cylinder Head Gaskets Material

07 JUNTAS EN MATERIAL FIBRA ORIGINAL - Fiber Material Gaskets - Standard

08 JUNTAS MULTILAYER STEEL (MLS) - Multilayer Steel Gaskets (MLS)

 NO RETORQUE

05 JUNTAS EN MATERIAL FIBRA - STANDARD - Fiber Material Gaskets - Standard

 RETORQUE

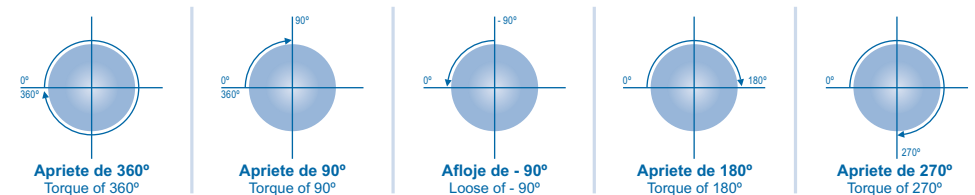
Juntas 05 son RETORQUEABLES. Se recomienda reajustar o retorquear entre los 500 y 1000 Km.

Gaskets 05 are Retorqueable. It is recommended to retorque between 500 and 1000 Km.

Para Torque en Kgm. Repetir ultima etapa de apriete. For torque in Kgm. Repeat the last stage of the tightening

Para Torque Angular. Adicionar 30°. For angular Torque. Add 30°.

EJEMPLOS DE AJUSTE EN GRADOS - Example of tightening in grades




IMPORTANTE
IMPORTANT

Evalúe el riesgo que corre al reutilizar los viejos tornillos, ya que estos están estirados y la estructura del material ha sufrido fatiga. El bajo costo de los tornillos no justifican los riesgos y el trabajo de reapriete con la consiguiente pérdida de tiempo de su cliente.















Evaluate the risk of reusing the old screws since these are stretched and the material structure has been worn. The low cost of screws are not worth the risks and work of retightening with the subsequent waste of time for your customer.

TARANTO no se responsabiliza por el montaje y ajuste incorrecto de sus juntas y tornillos de culata.















Se recomienda seguir los pasos indicados en dicha instrucción. TARANTO is not responsible for the wrong assembly and tightening of head gaskets bolts. It is suggested to follow the stages stated in the instructions.

 Atención al consumidor: (011) 4135-9023 - (0221) 473-0440

INSTRUCCIONES DE AJUSTE - Assembly Instructions

| REF. TARANTO Taranto reference | APLICACION Application | Cm ³ | SECUENCIA DE APRIETE Torque Sequence | | | | | | | | | | | | | | |
|---|---|--|---|----|----|----|---|----|----|----|----|---|---|---|---|---|----|
|  | Falcon - Fairlane - F100 Pinto - Sprint - Torino Falcon SP - Econoline Motor 187/188/221-7B 221 Sprint 7B Motor 144/170/200/250 4100cc. | 2300cc. 2800cc. 3100cc. 3300cc. 3618cc. 4100cc. | <table border="1"> <tr><td>14</td><td>10</td><td>6</td><td>2</td><td>3</td><td>7</td><td>11</td></tr> <tr><td>13</td><td>9</td><td>5</td><td>1</td><td>4</td><td>8</td><td>12</td></tr> </table> <p>1ª - Torque Inicial 7.2 Kgm. 2ª - Torque Hasta Alcanzar 8.6 Kgm. 3ª - Torque Final 11 Kgm.</p> | 14 | 10 | 6 | 2 | 3 | 7 | 11 | 13 | 9 | 5 | 1 | 4 | 8 | 12 |
| 14 | 10 | 6 | 2 | 3 | 7 | 11 | | | | | | | | | | | |
| 13 | 9 | 5 | 1 | 4 | 8 | 12 | | | | | | | | | | | |
|  300005 - 300007 | Kit de Bulones Taranto: B300000 | | | | | | | | | | | | | | | | |
|  | F100 - 350 - 600 Fairlane 1961/70 Motor 272 V8 FI 292 V8 FI | 4458cc. 4785cc. | <table border="1"> <tr><td>10</td><td>6</td><td>2</td><td>3</td><td>7</td></tr> <tr><td>9</td><td>5</td><td>1</td><td>4</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 5 Kgm. 2ª - Torque Final 11 Kgm.</p> | 10 | 6 | 2 | 3 | 7 | 9 | 5 | 1 | 4 | 8 | | | | |
| 10 | 6 | 2 | 3 | 7 | | | | | | | | | | | | | |
| 9 | 5 | 1 | 4 | 8 | | | | | | | | | | | | | |
|  300205 | Kit de Bulones Taranto: | | | | | | | | | | | | | | | | |
|  | Taurus L - GXL Ghia 1974/... Motor OHC | 1990cc. | <table border="1"> <tr><td>7</td><td>6</td><td>1</td><td>3</td><td>9</td></tr> <tr><td>10</td><td>4</td><td>2</td><td>5</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 7.5 Kgm. 2ª - Torque Final 12.5 Kgm.</p> | 7 | 6 | 1 | 3 | 9 | 10 | 4 | 2 | 5 | 8 | | | | |
| 7 | 6 | 1 | 3 | 9 | | | | | | | | | | | | | |
| 10 | 4 | 2 | 5 | 8 | | | | | | | | | | | | | |
|  300305 | Kit de Bulones Taranto: B300300 | | | | | | | | | | | | | | | | |
|  | Taurus - Sierra - XR4 Falcon - Ranger Maverich 1974/... Mustang 1980/... Motor OHC - 122 | 2299cc. | <table border="1"> <tr><td>7</td><td>6</td><td>1</td><td>3</td><td>9</td></tr> <tr><td>10</td><td>4</td><td>2</td><td>5</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 7.5 Kgm. 2ª - Torque Final 12.5 Kgm.</p> | 7 | 6 | 1 | 3 | 9 | 10 | 4 | 2 | 5 | 8 | | | | |
| 7 | 6 | 1 | 3 | 9 | | | | | | | | | | | | | |
| 10 | 4 | 2 | 5 | 8 | | | | | | | | | | | | | |
|  300405 | Kit de Bulones Taranto: B300300 | | | | | | | | | | | | | | | | |
|  | F100 - 350 - 600 Fairlane - LTD500 Fase II 1969/76 Motor V8 F2 | 4785cc. | <table border="1"> <tr><td>10</td><td>6</td><td>2</td><td>3</td><td>7</td></tr> <tr><td>9</td><td>5</td><td>1</td><td>4</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 5 Kgm. 2ª - Torque Final 11 Kgm.</p> | 10 | 6 | 2 | 3 | 7 | 9 | 5 | 1 | 4 | 8 | | | | |
| 10 | 6 | 2 | 3 | 7 | | | | | | | | | | | | | |
| 9 | 5 | 1 | 4 | 8 | | | | | | | | | | | | | |
|  300505 | Kit de Bulones Taranto: | | | | | | | | | | | | | | | | |
|  | Sierra 1984/... Escort - Americano Motor OHC | 1597cc. | <table border="1"> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> </table> <p>1ª - Torque Inicial 3 Kgm. 2ª - Torque Hasta Alcanzar 6 Kgm. 3ª - Torque Hasta Alcanzar 9 Kgm. 4ª - Torque Hasta Alcanzar 11 Kgm. 5ª - Aflojar - 90 y volver a ajustar a 11 Kgm. 6ª - Dejar reposar el motor 30 minutos. 7ª - Aflojar - 90 y volver a ajustar a 11 Kgm.</p> | 10 | 4 | 2 | 6 | 8 | 7 | 5 | 1 | 3 | 9 | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
|  300605 | Kit de Bulones Taranto: B300600 | | | | | | | | | | | | | | | | |
|  | Escort - Saveiro Senda - Gol - Scala Corcel - Belina Pampa 1989/... Motor CHT/AE | 1555cc. | <table border="1"> <tr><td>7</td><td>5</td><td>2</td><td>4</td><td>10</td></tr> <tr><td>9</td><td>3</td><td>1</td><td>6</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 5 Kgm. 2ª - Torque Hasta Alcanzar 6.5 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 7 Kgm.</p> | 7 | 5 | 2 | 4 | 10 | 9 | 3 | 1 | 6 | 8 | | | | |
| 7 | 5 | 2 | 4 | 10 | | | | | | | | | | | | | |
| 9 | 3 | 1 | 6 | 8 | | | | | | | | | | | | | |
|  300705 - 300707 | Kit de Bulones Taranto: B300700 | | | | | | | | | | | | | | | | |

INSTRUCCIONES DE AJUSTE - Assembly Instructions

| REF. TARANTO Taranto reference | APLICACION Application | Cm ³ | SECUENCIA DE APRIETE Torque Sequence | | | | | | | | | | | | | | |
|---|---|------------------------------|---|----|----|----|---|---|----|----|----|---|---|---|---|---|----|
|  | Falcon 4B - STD De Luxe - Futura Rural 1962/68 Motor 170/187 4B | 2780cc. 3052cc. | <table border="1"> <tr><td>14</td><td>10</td><td>6</td><td>2</td><td>3</td><td>7</td><td>11</td></tr> <tr><td>13</td><td>9</td><td>5</td><td>1</td><td>4</td><td>8</td><td>12</td></tr> </table> <p>1ª - Torque Inicial 7.2 Kgm. 2ª - Torque Hasta Alcanzar 8.6 Kgm. 3ª - Torque Final 11 Kgm.</p> | 14 | 10 | 6 | 2 | 3 | 7 | 11 | 13 | 9 | 5 | 1 | 4 | 8 | 12 |
| 14 | 10 | 6 | 2 | 3 | 7 | 11 | | | | | | | | | | | |
| 13 | 9 | 5 | 1 | 4 | 8 | 12 | | | | | | | | | | | |
|  300905 | Kit de Bulones Taranto: B300000 | | | | | | | | | | | | | | | | |
|  | Escort 1986/98 Orion 1986/94 Motor HL 14G CFI - EFI | 1392cc. | <table border="1"> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> </table> <p>1ª - Torque Inicial 2.5 Kgm. 2ª - Torque Hasta Alcanzar 5.5 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 5.5 Kgm. 4ª - Apriete Angular a + 90°. 5ª - Apriete Angular a + 90°.</p> | 10 | 4 | 2 | 6 | 8 | 7 | 5 | 1 | 3 | 9 | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
|  301007 | Kit de Bulones Taranto: B301000 | | | | | | | | | | | | | | | | |
|  | Fiesta - Escort Orion - Orion EFI Fiesta XR2 - EFI Motor CVH (HL16CFI- H16G/MFI-HL16H//EFI) | 1597cc. | <table border="1"> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> </table> <p>1ª - Torque Inicial 2.5 Kgm. 2ª - Torque Hasta Alcanzar 5.5 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 5.5 Kgm. 4ª - Apriete Angular a + 90°. 5ª - Apriete Angular a + 90°.</p> | 10 | 4 | 2 | 6 | 8 | 7 | 5 | 1 | 3 | 9 | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
|  301107 | Kit de Bulones Taranto: B301000 | | | | | | | | | | | | | | | | |
|  | Mondeo 1993/... Escort - Orion 1992/... Fiesta 1994/95 Motor Zetec 16V | 1597cc. | <table border="1"> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> </table> <p>1ª - Torque Inicial 2.5 Kgm. 2ª - Torque Hasta Alcanzar 4.5 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 4.5 Kgm. 4ª - Apriete Angular a + 105°.</p> | 10 | 4 | 2 | 6 | 8 | 7 | 5 | 1 | 3 | 9 | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
|  301207 | Kit de Bulones Taranto: B320300 | | | | | | | | | | | | | | | | |
|  | Fiesta 1976/88 Escort - Orion - Fiesta Escort - 1982/88 Motor OHV (HCS) OHV BL13H | 957cc. 1118cc. 1297cc. | <table border="1"> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> </table> <p>1ª - Torque Inicial 3 Kgm. 2ª - Torque Hasta Alcanzar 6 Kgm. 3ª - Torque Hasta Alcanzar 9 Kgm. 4ª - Torque Hasta Alcanzar 11 Kgm. 5ª - Aflojar - 90 y volver a ajustar a 11 Kgm. 6ª - Dejar reposar el motor 30 minutos. 7ª - Aflojar - 90 y volver a ajustar a 11 Kgm.</p> | 10 | 4 | 2 | 6 | 8 | 7 | 5 | 1 | 3 | 9 | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
|  301307 | Kit de Bulones Taranto: | | | | | | | | | | | | | | | | |
|  | Focus 1998/... Motor ZETEC E 16V | 1796cc. | <table border="1"> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 2 Kgm. 2ª - Torque Hasta Alcanzar 4 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 4 Kgm. 4ª - Apriete Angular a + 90°.</p> | 7 | 5 | 1 | 3 | 9 | 10 | 4 | 2 | 6 | 8 | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
|  301507 - 301508 | Kit de Bulones Taranto: B320300 | | | | | | | | | | | | | | | | |
|  | Focus 1998/... Motor ZETEC E 16V | 1989cc. | <table border="1"> <tr><td>7</td><td>5</td><td>1</td><td>3</td><td>9</td></tr> <tr><td>10</td><td>4</td><td>2</td><td>6</td><td>8</td></tr> </table> <p>1ª - Torque Inicial 2 Kgm. 2ª - Torque Hasta Alcanzar 4 Kgm. 3ª - Aflojar - 90 y volver a ajustar a 4 Kgm. 4ª - Apriete Angular a + 90°.</p> | 7 | 5 | 1 | 3 | 9 | 10 | 4 | 2 | 6 | 8 | | | | |
| 7 | 5 | 1 | 3 | 9 | | | | | | | | | | | | | |
| 10 | 4 | 2 | 6 | 8 | | | | | | | | | | | | | |
|  301607 - 301608 | Kit de Bulones Taranto: B320300 | | | | | | | | | | | | | | | | |

