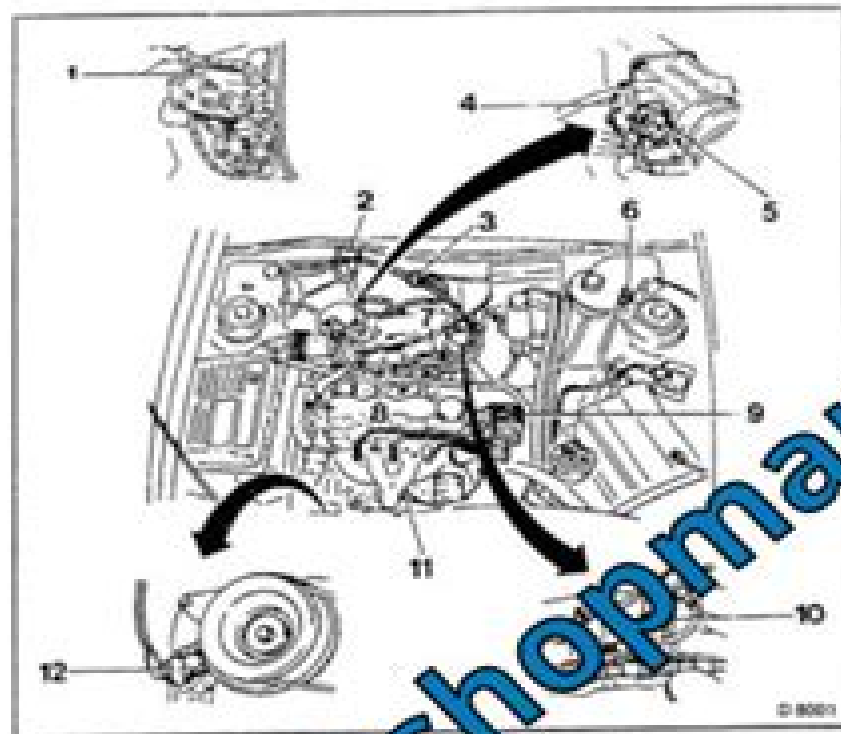


# Opel Astra 1992-1998 Workshop Manual



## Motronic M 1.5.4

1. Control unit.
2. Intake manifold pressure sensor.
3. Tank vent valve.
4. Throttle valve.
5. Idle speed control motor.

6. Octane number plug.
7. Fuel pressure regulator.
8. Injection valves.
9. Dual spark ignition distributor.
10. Intake air temperature sensor.
11. C.O. Potentiometer.
12. Inductive pulse pick-up.

### CLEAN

1. All sealing surfaces.
2. Bore holes in cylinder head bolts.
3. Check cylinder block and cylinder head for plane surfaces.

### INSTALL, CONNECT

1. Cylinder head sealing — marking "OBSH/TOP" facing upwards — steering side of the engine.

### INSTALL, CONNECT

1. Mount cylinder head on cylinder block.
2. Adjust hydraulic valve lash adjuster, measure parts and rocker arm — MoS, check.
3. Insert camshaft housing — Sealing Compound Loctite 242.

### NOTE:

1. Use new cylinder head bolts.
2. Screw in bolts until they rest on cones.

### TORQUE — ANGLE METHOD

1. Cylinder head to cylinder block.
2. Tighten cylinder head bolts from inside outwards, in four stages in a spiral pattern — torque wrench and KM-470-B.

| Engine                   | Torque | Further turn angle |
|--------------------------|--------|--------------------|
| 1.4 / 1.6 L <sub>4</sub> | 22 Nm  | 90° + 90° + 90°    |
| 1.8 / 2.0 L <sub>4</sub> | 25 Nm  | 90° + 90° + 90°    |

\*After test run, turn a further 30° + 15°



Fig. 80

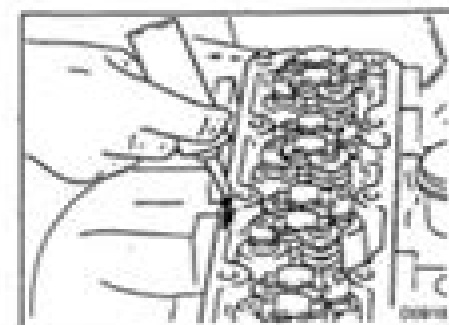


Fig. 81



Fig. 82

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**Yan Bai**

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