

## 4 - ENGINE

(CONTINUES FROM POINT 55)

56. Fit:

- The front timing chain roller (81).
- The cylinder head gasket (82) (new gasket).
- The coolant pipe (83).



**N.B.**

REMEMBER TO FIT THE FRONT CHAIN ROLLER BEFORE FITTING THE CYLINDER HEAD.



57. Fit:

- The cylinder head (84).



**N.B.**

TIE A PIECE OF WIRE TO THE TIMING CHAIN TO PREVENT IT FROM DROPPING INTO THE ENGINE.



**CAUTION**

APPLY OIL TO THE WASHERS OF THE 4 BOLTS JOINING THE CYLINDER HEAD TO THE CRANKCASE.

58. Fit:

- The washers (85) impregnated with engine oil onto the M8 bolts (86).
- The 4 M8 bolts (86) securing the cylinder head to the crankcase.
- The 2 M6 bolts (87) securing the cylinder head to the crankcase.

**Bolts securing the cylinder head to the crankcase.**

Bolts M8 - 2,7 kgf.m + 90° (27 N.m + 90°)

Bolts M6 - 1,1-1,3 kgf.m (11-13 N.m)



**CAUTION**

TIGHTEN THE M8 BOLTS FIRST.

TIGHTEN THE CYLINDER HEAD BOLTS IN SUCCESSION CROSSWISE, GOING FROM ONE TO THE OTHER TWO OR THREE TIMES.



**N.B.**

AFTER TIGHTENING THE M8 BOLTS TO THEIR INDICATED TORQUE, THEY SHOULD BE TURNED ANOTHER 90° (1/4 OF A TURN).

# Derbi Gpr 125 Workshop Manual

**Christian Drosten**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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