

## TIGHTENING TORQUES

Tighten fasteners to torque mentioned in exploded views and text. When they are not specified refer to following table. Bold face size (e.g. **M4**) indicates nominal value (mean value).

| N-m | FASTENER SIZE<br>(S.S. GRADE) | Lbf-in |
|-----|-------------------------------|--------|
| 2   | <b>M4</b>                     | 18     |
| 3   | M4                            | 27     |
| 4   | <b>M5</b>                     | 35     |
| 8   | M6                            | 71     |
| 9   | M6                            | 80     |
| 10  | <b>M6</b>                     | 89     |
| 11  | M6                            | 97     |
| 12  | M6                            | 106    |

| N-m | FASTENER SIZE<br>(S.S. GRADE) | Lbf-ft |
|-----|-------------------------------|--------|
| 21  | M8                            | 15     |
| 22  | M8                            | 16     |
| 23  | <b>M8</b>                     | 17     |
| 24  | M8                            | 18     |
| 25  | M8                            | 19     |
| 43  | M10                           | 32     |
| 44  | M10                           | 32     |
| 45  | M10                           | 33     |
| 46  | M10                           | 34     |
| 47  | M10                           | 35     |
| 48  | <b>M10</b>                    | 35     |
| 49  | M10                           | 36     |
| 50  | M10                           | 37     |
| 51  | M10                           | 38     |
| 52  | M10                           | 38     |
| 53  | M10                           | 39     |
| 76  | M12                           | 55     |
| 77  | M12                           | 57     |
| 78  | M12                           | 58     |
| 79  | M12                           | 59     |

| N-m | FASTENER SIZE<br>(S.S. GRADE) | Lbf-ft |
|-----|-------------------------------|--------|
| 80  | <b>M12</b>                    | 59     |
| 81  | M12                           | 60     |
| 82  | M12                           | 60     |
| 83  | M12                           | 61     |
| 84  | M12                           | 62     |
| 121 | M14                           | 89     |
| 122 | M14                           | 90     |
| 123 | M14                           | 91     |
| 124 | M14                           | 91     |
| 125 | M14                           | 92     |
| 126 | M14                           | 93     |
| 127 | M14                           | 94     |
| 128 | M14                           | 94     |
| 129 | M14                           | 95     |
| 130 | M14                           | 96     |
| 131 | M14                           | 97     |
| 132 | M14                           | 97     |
| 133 | M14                           | 98     |
| 134 | M14                           | 99     |
| 135 | <b>M14</b>                    | 100    |
| 136 | M14                           | 100    |
| 137 | M14                           | 101    |
| 138 | M14                           | 102    |
| 139 | M14                           | 103    |
| 140 | M14                           | 103    |
| 141 | M14                           | 104    |
| 142 | M14                           | 105    |
| 143 | M14                           | 105    |
| 144 | M14                           | 106    |
| 145 | M14                           | 107    |
| 146 | M14                           | 108    |
| 147 | M14                           | 108    |
| 148 | M14                           | 109    |
| 149 | M14                           | 110    |
| 150 | M14                           | 111    |

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**Ying Liu**



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