SECTION 10 - AIDS FOR MAINTENANCE

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Torque Specifications (250/300)

DRIVE TRAIN COMPONENTS				
Part	Part Bolted To		que	
Front Driveshaft (Coupler)**	Flange	kg-m 4.2	ft-lb 30	
Engine	Sub-Frame (Front/Rear)	5.5	40	
Engine/Sub-Frame	Frame	5.5	40	
Frame*	Front Diff Bracket/Upper	4.2	30	
Front Differential*	Frame/Diff Bracket/Lower	5.5	40	
Diff Housing Cover***	Diff Housing	2.6	19	
Drive Bevel Gear Nut***	Shaft	11-13	79.5-94	
Differential Gear Case***	Hub	2.3-3	16.5-22	
Hub Nut	Front/Rear Shaft/Axle (max)	10.4	75	
Oil Drain Plug	Front Diff	0.5	3.5	
Oil Fill Plug	Front Diff	2.2	16	
Oil Drain Plug	Engine	2.2	16	
Oil Fittings*	Engine	1.1	8	
Shift Arm	Engine	1.4	10	
High/Low Shift Arm	Engine	1.1	8	
2W/4W Shift Arm	Front Diff	1.1	8	
Wheel	Hub	5.5	40	
EXHA	UST COMPONENT			
Part	Part Bolted To	kg-m	que ft-lb	
Header Pipe	Engine	1.1	8	
ELECTRICAL COMPONENTS				
Part	Part Bolted To	Tor kg-m	que ft-lb	
Ground Cable	Engine	1.1	8	
STEE	RING COMPONEN	TS		
Part	Part Bolted To	Tor kg-m	que ft-lb	
Handlebar Block	Steering Post	2.8	20	
Steering Post Bearing Housings	Frame	2.8	20	
Steering Post Bearing Flange	Frame	2.8	20	
Lower Steering Bearing Washer Cap Screw***	Steering Post	5.5	40	
Tie Rod End	Knuckle/Steering Post	4.2	30	
BRA	KE COMPONENTS			
Part	Part Bolted To	Tor kg-m	que ft-lb	
Brake Disc*	Hub	2.1	15	
Brake Hose	Caliper	4.2	30	
Brake Hose	Master Cylinder	0.8	6	
Auxiliary Brake Lever	Frame	9.7	70	
Master Cylinder Cover	Master Cylinder	.03	10 inlb	
Brake Pressure Switch	Front Brake Block	2.1	15	
Hydraulic Caliper	Knuckle	2.8	20	
Auxiliary Caliper	Knuckle	2.1	15	
Hydraulic Caliper	Knuckle	2.8	20	

CHASSIS COMPONENTS			
Torque			
Part	Part Bolted To	kg-m	ft-lb
Sub-Frame	Frame	5.5	40
Footrest	Frame (8 mm)	2.8	20
Footrest	Frame (10 mm)	5.5	40
Foot Shift Lever	Footrest	9.7	70
Gas Tank Valve	Gas Tank	0.1	1
Reverse Shift Lever *	Frame	2.8	20
SUSPENSION	ON COMPONENTS		
Part	Part Bolted To	Tor- kg-m	que ft-lb
A-Arm (All)	Frame	4.8	35
Ball Joint Cap Screw	Knuckle	4.8	35
Shock Absorber	Frame	4.8	35
Shock Absorber	Upper A-Arm	4.8	35
SUSPENSI	ON COMPONENTS	S (Rear)	
Part	Part Bolted To	Tor	
		kg-m	ft-lb
Rear Shock	Sub-Frame	4.8	35
Rear Shock	Lower A-Arm	2.8	20
A-Arms (All)	Sub-Frame	4.8	35
Rear Knuckles	A-Arms	4.8	35
ENGI	NE/TRANSMISSIC	Tor	ane
Part	Part Bolted To	kg-m	ft-lb
Air Cleaner Assy	Frame	1.1	8
Clutch Shoe	Crankshaft	11	79.5
Clutch Sleeve Hub	Countershaft	8	58
Crankcase Half (6 mm)	Crankcase Half	0.9-1.3	6.5-9.5
Crankcase Half (8 mm)	Crankcase Half	2-2.4	14.5-17
Cylinder Head Cap Nuts/Nut	Cylinder	2.5	18
Cylinder Head/Crankcase	Cylinder	1.1	8
Hi/Lo Shifter Arm	Shifter Arm Shaft	1.1	8
Left-Side Cover	Crankcase Half	0.9-1.3	6.5-9.5
Oil Pump*	Crankcase	1	7
Recoil Starter	Left-Side Cover	0.8	6
Reverse Gear Shaft	Reverse Shift Shaft	1.1	8
Right-Side Cover	Crankcase Half	0.9-1.3	6.5-9.5
Magneto Rotor Nut	Crankshaft	16	116
Shifter Arm	Shifter Arm Shaft	1.1	8
Cam Sprocket	Camshaft	1.15	8.5

Crankshaft

Cylinder

Engine

Starter Cup

Valve Cover

Spark Plug

25

7

12

3.5

1

1.7

^{*} w/Blue Loctite #243

^{**} w/Red Loctite #271

^{***} w/Green Loctite #609

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Torque Specifications (400/500 - Manual Transmission)

DRIVE TRAIN COMPONENTS			
Part	Part Bolted To	Torque	
Front Driveshaft (Coupler)**	Rubber Coupler	kg-m 5.5	ft-lb 40
Rubber Coupler**	Front Diff/Drive Flange	5.5	40
Engine (Lower Rear/Front)	Frame	5.5	40
Engine (Upper Front Inside Bracket/Topside)	Frame Bracket	2.8	20
Engine Mount (Left-Side Upper Rear)	Frame	1.7	12
Engine (Left-Side Upper Rear)	Mount	5.5	40
Front Differential*	Frame/Diff Bracket	5.5	40
Bearing Housing/Axle Assy	Axle Housing	5.5	40
Diff Housing Cover***	Diff Housing	2.6	19
Drive Bevel Gear Nut***	Shaft	11-13	79.5-94
Differential Gear Case***	Hub	2.3-3	16.5-22
Hub Nut	Front/Rear Shaft/Axle (max)	10.4	75
Oil Drain Plug	Front Diff/Rear Dr	0.5	3.5
Oil Fill Plug	Front Diff/Rear Dr	2.2	16
Oil Drain Plug	Engine	2.2	16
Inspection Plug	Rear Dr	0.5	3.5
2W/4W Shift Arm	Front Diff	1.1	8
Wheel	Hub	5.5	40
	UST COMPONENT		.0
			que
Part	Part Bolted To	kg-m	ft-lb
Exhaust Pipe	Engine/Frame	2.8	20
ELECT	RICAL COMPONE		
Part	Part Bolted To	Tor kg-m	que ft-lb
Coil*	Head Bracket	1.7	12
Ground Wire	Engine	1.1	8
	RING COMPONEN		
			que
Part	Part Bolted To	kg-m	ft-lb
Handlebar Block	Steering Post	2.8	20
Steering Post Bearing Housings	Frame	2.8	20
Steering Post Bearing Flange	Frame	2.8	20
Lower Steering Bearing Washer Cap Screw***	Steering Post	5.5	40
Tie Rod End	Knuckle/Steering Post	4.2	30
RD/			30
DN <i>F</i>	KE COMPONENTS	3	
Part		S Tor	que
Part	KE COMPONENTS Part Bolted To	Tor kg-m	que ft-lb
Part Brake Disc*	KE COMPONENTS Part Bolted To Hub	Tor kg-m 2.1	que ft-lb 15
Part Brake Disc* Brake Hose	KE COMPONENTS Part Bolted To Hub Caliper	Tor kg-m 2.1 4.2	que ft-lb 15 30
Brake Disc* Brake Hose Brake Hose	RE COMPONENTS Part Bolted To Hub Caliper Master Cylinder	Tor kg-m 2.1 4.2 0.8	que ft-lb 15 30 6
Part Brake Disc* Brake Hose Brake Hose Master Cylinder Cover	Part Bolted To Hub Caliper Master Cylinder Master Cylinder	Tor kg-m 2.1 4.2 0.8 .03	que ft-lb 15 30 6 10 inlb
Brake Disc* Brake Hose Brake Hose Master Cylinder Cover Brake Pressure Switch	Part Bolted To Hub Caliper Master Cylinder Master Cylinder Front Brake Block	Tor kg-m 2.1 4.2 0.8 .03 2.1	que ft-lb 15 30 6 10 inlb
Brake Disc* Brake Hose Brake Hose Master Cylinder Cover Brake Pressure Switch Auxiliary Brake Lever	Part Bolted To Hub Caliper Master Cylinder Master Cylinder Front Brake Block Footrest	Tor kg-m 2.1 4.2 0.8 .03 2.1 9.7	que ft-lb 15 30 6 10 inlb 15 70
Brake Disc* Brake Hose Brake Hose Master Cylinder Cover Brake Pressure Switch	Part Bolted To Hub Caliper Master Cylinder Master Cylinder Front Brake Block	Tor kg-m 2.1 4.2 0.8 .03 2.1	que ft-lb 15 30 6 10 inlb

СНА	SSIS COMPONENT	· c	
			que
Part	Part Bolted To	kg-m	ft-lb
Footrest	Frame (8 mm)	2.8	20
Footrest	Frame (10 mm)	5.5	40
Gas Tank Valve	Gas Tank	0.1	1
Reverse Shift Lever*	Frame	2.8	20
SUSPENSI	ON COMPONENTS	(Front)	
Part	Part Bolted To		que
A-Arm (All)	Frame	kg-m 4.8	ft-lb 35
Ball Joint Cap Screw	Knuckle	4.8	35
Shock Absorber	Frame	4.8	35
Shock Absorber	Upper A-Arm	4.8	35
	ON COMPONENTS		33
			que
Part	Part Bolted To	kg-m	ft-lb
Axle Retainer Assy	Axle Housing	5.5	40
Axle Housing/Hitch	Rear Gear Case	4.8	35
Axle Housing/Hitch	Rear Gear Case (New)	5.5	40
Shock Absorber	Axle Housing/Frame	4.8	35
Swing Arms	Axle Housing	4.8	35
Swing Arms **	Frame	4.8	35
ENG	NE/TRANSMISSIO	N	
Part	Part Bolted To		que
		kg-m	ft-lb
Clutch Shoe	Crankshaft	13	94
Clutch Sleeve Hub	Countershaft	10	72
Crankcase Half (6 mm)	Crankcase Half	0.9-1.3 2-2.4	6.5-9.5 14.5-17
Crankcase Half (8 mm)	Crankcase Half	2-2.4	14.5-17
Cylinder Head (Cap		0.0	
Screws)	Cylinder	3.8	27.5
Cylinder Head (6 mm Nuts)	Cylinder	1.1	27.5
Cylinder Head (6 mm	•	1.1	27.5
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover	Cylinder Cylinder Crankcase Half	1.1 2.5 0.9-1.3	27.5 8 18 6.5-9.5
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller	Cylinder Cylinder Crankcase Half	1.1	27.5 8 18
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft	1.1 2.5 0.9-1.3 1.05	27.5 8 18 6.5-9.5 7.5 58
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump*	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase	1.1 2.5 0.9-1.3 1.05 8	27.5 8 18 6.5-9.5 7.5 58
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft	1.1 2.5 0.9-1.3 1.05 8 1	27.5 8 18 6.5-9.5 7.5 58
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8	27.5 8 18 6.5-9.5 7.5 58
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft	1.1 2.5 0.9-1.3 1.05 8 1	27.5 8 18 6.5-9.5 7.5 58 7
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8	27.5 8 18 6.5-9.5 7.5 58 7 72 20
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft Recoil Starter Reverse Cam Stopper	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint Left-Side Cover	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8 0.8	27.5 8 18 6.5-9.5 7.5 58 7 72 20 6
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft Recoil Starter Reverse Cam Stopper Housing	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint Left-Side Cover Crankcase	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8 0.8 2.3	27.5 8 18 6.5-9.5 7.5 58 7 72 20 6 16.5
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft Recoil Starter Reverse Cam Stopper Housing Right-Side Cover	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint Left-Side Cover Crankcase Crankcase	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8 0.8 2.3	27.5 8 18 6.5-9.5 7.5 58 7 72 20 6 16.5 6.5-9.5
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft Recoil Starter Reverse Cam Stopper Housing Right-Side Cover Magneto Rotor Nut	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint Left-Side Cover Crankcase Crankcase Crankcase	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8 0.8 2.3 0.9-1.3	27.5 8 18 6.5-9.5 7.5 58 7 72 20 6 16.5 6.5-9.5 116
Cylinder Head (6 mm Nuts) Cylinder Head (8 mm Nut) Left-Side Cover Mechanical Water Pump Impeller Oil Pump Drive Gear Oil Pump* Output Shaft Gear Rear Output Shaft Recoil Starter Reverse Cam Stopper Housing Right-Side Cover Magneto Rotor Nut Shift Stop Housing	Cylinder Cylinder Crankcase Half Pump Shaft Crank Balancer Shaft Crankcase Output Shaft Output Joint Left-Side Cover Crankcase Crankcase Crankcase Crankcase Crankcase	1.1 2.5 0.9-1.3 1.05 8 1 10 2.8 0.8 2.3 0.9-1.3 16 2.3	27.5 8 18 6.5-9.5 7.5 58 7 72 20 6 16.5 6.5-9.5 116 16.5

^{*} w/Blue Loctite #243

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^{**} w/Red Loctite #271

^{***} w/Green Loctite #609

Torque Specifications (400/500 - Automatic Transmission)

DRIVE TRAIN COMPONENTS			
Part	Part Bolted To	Torque	
Front Driveshaft (Coupler)**	Rubber Coupler	kg-m 5.5	ft-lb 40
Rubber Coupler**	Front Diff/Drive Flange	5.5	40
Engine Mount (Front Upper)	Frame	2.8	20
Engine Bracket (Upper)	Engine	2.8	20
Engine Mounting Through-Bolts	Frame	5.5	40
Engine Mount (Upper Rear)	Frame	1.7	12
Front Differential*	Frame/Diff Bracket	5.5	40
Rear Output Joint Assy	Engine	2.8	20
Bearing Housing/Axle Assy	Axle Housing	5.5	40
Diff Housing Cover***	Diff Housing	2.6	19
Drive Bevel Gear Nut***	Shaft	11-13	79.5-94
Differential Gear Case***	Hub	2.3-3	16.5-22
Hub Nut	Front/Rear Shaft/Axle (max)	10.4	75
Oil Drain Plug	Front Diff/Rear Dr	0.5	3.5
Oil Fill Plug	Front Diff/Rear Dr	2.2	16
Oil Drain Plug	Engine	2.2	16
Inspection Plug	Rear Drive	0.5	3.5
2W/4W Shift Arm	Front Diff	1.1	8
Wheel	Hub	5.5	40
EXHA	UST COMPONENT	S	
Part	Part Bolted To		que ft-lb
Exhaust Pipe	Engine/Frame	kg-m 2.8	20
<u>'</u>	RICAL COMPONEN		20
			que
Part	Part Bolted To	kg-m	ft-lb
Coil*	Head Bracket	1.7	12
Ground Wire	Engine	1.1	8
STEE	RING COMPONENT		
Part	Part Bolted To	Tor- kg-m	que ft-lb
Handlebar Block	Steering Post	2.8	20
Steering Post Bearing Housings	Frame	2.8	20
Steering Post Bearing Flange	Frame	2.8	20
Lower Steering Bearing Washer Cap Screw***	Steering Post	5.5	40
Tie Rod End	Knuckle/Steering Post	4.2	30

BRAKE COMPONENTS			
Part	Part Bolted To	Tor kg-m	que ft-lb
Brake Disc*	Hub	2.1	15
Brake Hose	Caliper	4.2	30
Brake Hose	Master Cylinder	0.8	6
Master Cylinder Cover	Master Cylinder	.03	10 inlb
Brake Pressure Switch	Front Brake Block	2.1	15
Auxiliary Brake Lever	Footrest	9.7	70
Hydraulic Caliper	Axle Retainer Assy	2.8	20
Auxiliary Caliper	Axle Retainer Assy	2.1	15
CHASSIS COMPONENTS			
Part Part Bolted To Torque			que

CHA	SSIS COMPONENT	S	
Part	Part Bolted To	Tor kg-m	que ft-lb
Footrest	Frame (8 mm)	2.8	20
Footrest	Frame (10 mm)	5.5	40
Gas Tank Valve	Gas Tank	0.1	1
Reverse Shift Lever*	Frame	2.8	20
		<i>(</i>	

SUSPENSION COMPONENTS (Front)			
Part	Part Bolted To	Torque	
Fait	Fait Boiled To	kg-m	ft-lb
A-Arm (All)	Frame	4.8	35
Ball Joint Cap Screw	Knuckle	4.8	35
Shock Absorber	Frame	4.8	35
Shock Absorber	Upper A-Arm	4.8	35

SUSPENSION COMPONENTS (Rear)			
Part Part Bolted	Part Bolted To	Torque	
1 0.11		kg-m	ft-lb
Axle Retainer Assy	Axle Housing	5.5	40
Axle Housing/Hitch	Rear Gear Case	4.8	35
Axle Housing/Hitch	Rear Gear Case (New)	5.5	40
Swing Arms	Axle Housing	4.8	35
Swing Arms**	Frame	4.8	35
Shock Absorber	Axle Housing/Frame	4.8	35

SUSPENSION COMPONENTS (Rear) TBX Model			
Part	Part Bolted To	Tor kg-m	que ft-lb
Axle Retainer Assy	Axle Housing	5.5	40
Axle Housing	Rear Gear Case	4.8	35
Axle Housing	Rear Gear Case (New)	5.5	40
Swing Arm	Frame	5.5	40
Shock Absorber	Frame	4.8	35
Shock Absorber	Swing Arm	4.8	35
Cargo Box Frame	ATV Frame	4.8	35
Cargo Box (Plastic)	Cargo Box Frame	1.7	12
Axle Housing	Swing Arm	4.8	35
Side Box (Upper)	Frame	2.8	20
Side Box (Lower)	Frame	2.5	18
Rear Gear Case U-Joint**	Driveshaft	5.5	40

^{*} w/Blue Loctite #243

^{**} w/Red Loctite #271

^{***} w/Green Loctite #609

ENGINE/TRANSMISSION			
Part	Part Bolted To	Torque	
rait	Tart Boiled To	kg-m	ft-lb
Clutch Shoe	Crankshaft	13	94
Clutch Cover/ Housing Assy	Crankcase	1.1	8
Crankcase Half (6 mm)	Crankcase Half	0.9-1.3	6.5-9.5
Crankcase Half (8 mm)	Crankcase Half	2-2.4	14.5-17
Cylinder Head (Cap Screws)	Crankcase	3.8	27.5
Cylinder Head (6 mm)	Cylinder	1.1	8
Cylinder Head (8 mm)	Cylinder	2.5	18
Fixed Driven	Clutch Shaft	10.4-11.8	75-85
Ground Wire	Engine	1.1	8
Magneto Cover	Crankcase	1.1	8
Mechanical Water Pump Impeller	Pump Shaft	1.05	7.5
Movable Drive Face	Driveshaft	10.4-11.8	75-85
Oil Pump Drive Gear	Crank Balancer Shaft	5	36
Output Shaft Gear	Output Shaft	10	72
Recoil Starter	Left-Side Cover	8.0	6
Magneto Rotor Nut	Crankshaft	16	116
Cam Sprocket	Camshaft	1.5	11
Starter Cup	Crankshaft	3.5	25
V-Belt Cover	Crankcase	1.1	8
Plenum***	Engine	1.1	8
Spark Plug	Engine	1.7	12

^{*} w/Blue Loctite #243

^{**} w/Red Loctite #271

^{***} w/Green Loctite #609

Torque Conversions

ft-lb	kg-m								
1	0.1	21	2.9	41	5.7	61	8.4	81	11.2
2	0.3	22	3.0	42	5.8	62	8.6	82	11.3
3	0.4	23	3.2	43	5.8	63	8.7	83	11.5
4	0.6	24	3.3	44	6.1	64	8.9	84	11.6
5	0.7	25	3.5	45	6.2	65	9.0	85	11.8
6	0.8	26	3.6	46	6.4	66	9.1	86	11.9
7	1.0	27	3.7	47	6.5	67	9.3	87	12.0
8	1.1	28	3.9	48	6.6	68	9.4	88	12.2
9	1.2	29	4.0	49	6.8	69	9.5	89	12.3
10	1.4	30	4.2	50	6.9	70	9.7	90	12.5
11	1.5	31	4.3	51	7.1	71	9.8	91	12.6
12	1.7	32	4.4	52	7.2	72	10.0	92	12.8
13	1.8	33	4.6	53	7.3	73	10.1	93	12.9
14	1.9	34	4.7	54	7.5	74	10.2	94	13.0
15	2.1	35	4.8	55	7.6	75	10.4	95	13.1
16	2.2	36	5.0	56	7.7	76	10.5	96	13.3
17	2.4	37	5.1	57	7.9	77	10.7	97	13.4
18	2.5	38	5.3	58	8.0	78	10.8	98	13.6
19	2.6	39	5.4	59	8.2	79	10.9	99	13.7
20	2.8	40	5.5	60	8.3	80	11.1	100	13.8

Tightening Torque (General Bolts)

Turns of Dalk	Thread	Tightening Torque			
Type of Bolt	Diameter A (mm)	kg-m	ft-lb		
	5	0.2-0.4	1.5-3.0		
(Conventional or	6	0.4-0.7	3.0-5.0		
4 Marked Bolt)	8	1.0-1.6	7.0-11.5		
	10	2.2-3.5	16.0-25.5		
	5	0.3-0.6	2.0-4.5		
(7 Marked Bolt)	6	0.8-1.2	6.0-8.5		
(7 Marked Bolt)	8	1.8-2.8	13.0-20.0		
	10	4.0-6.0	29.0-43.5		

