

Special torques for setscrews and nuts

Description	Thread size	Torque		
		Nm	lbf ft	kgf m
Cylinder head assembly				
Setscrews, cylinder head	1/2 UNF	see Operation 3-13		
Setscrews, cylinder head (Engine types AR and AS)	M10 1/2 UNF	see Operation 3-14		
Fasteners, rocker shaft brackets:				
- Aluminium brackets	M12	40	30	4,1
- Cast iron and sintered steel brackets	M12	75	55	7,6
Cap nuts, composite plastic rocker cover	M12	20	15	2,1
Cap nuts, aluminium rocker cover	M12	30	22	3,0
Setscrews, inlet manifold to cylinder head	M10	44	33	4,5
Setscrews, inlet manifold to cylinder head	M8	22	16	2,2
Setscrews, exhaust manifold to cylinder head	M10	33	24	3,4
Setscrews, engine lift bracket	M10	44	33	4,5
Piston and connecting rod assemblies				
Nuts, connecting rods	1/2 UNF	125	92	12,7
Setscrews, connecting rods	1/2 UNF	152	114	15,8
Banjo bolts, piston cooling jets	3/8 UNF	27	21	2,7
Crankshaft assembly				
Setscrews, main bearings	5/8 UNF	265	196	27,0
Setscrews, crankshaft pulley	7/16 UNF	115	85	11,8
Setscrews, viscous damper to crankshaft pulley	M12	75	55	7,6
Cap screws, viscous damper to crankshaft pulley	M8	35	26	3,6
Cap screws, crankshaft bonded damper to crankshaft pulley	M8	35	26	3,6
Setscrews, rear oil seal housing to cylinder block	M8	22	16	2,2
Cap screws, bridge piece to cylinder block	M6	16	12	1,6
Cap screws, rear oil seal housing to bridge piece	M6	13	10	1,3
Torxscrew, rear oil seal housing to bridge piece	M8	22	16	2,2
Setscrew, idler gear hub of balancer unit	M12	93	68	9,5
Nut, drive gear of balance weight	1/2 UNF	82	60	8,4
Setscrews, rear cover of balancer frame	M10	54	40	5,5
Setscrews, oil transfer plate (balancer unit)	M10	30	22	3,1
Setscrews, oil pump to balancer frame	M8	27	20	2,8
Setscrews, balancer to cylinder block	M10	54	40	5,5
Timing case and drive assembly				
Setscrews, timing case to cylinder block	M8	22	16	2,2
Setscrews, timing case to cylinder block	M10	44	33	4,5
Setscrews, hub of idler gear	M10	44	33	4,5
Setscrew, camshaft gear	M12	95	74	9,5
Setscrews, timing case cover to timing case	M8	22	16	2,2
Nuts, timing case cover to timing case	M8	22	16	2,2



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