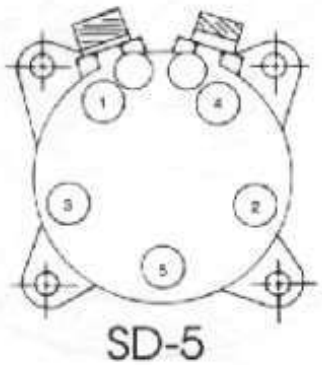
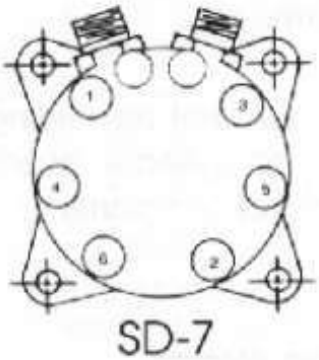
6.4 Assembly Torques

Item	ft - lb	N - m	kgf - cm
Armature retaining nut, 1/2" - 20	22.4 ± 2.9	30.4 ± 3.9	310 ± 40
Armature retaining nut, M8	13.0 ± 2.2	17.7 ± 2.9	180 ± 30
Cylinder head bolts, M6	10 ± 2.2	13.7 ± 2.9	140 ± 30
Cylinder head bolts, M8	25.3 ± 3.6	34.3 ± 4.9	350 ± 50
Oil filler plug	14.5 ± 3.6	19.6 ± 4.9	200 ± 50
Hose fitting 1" - 14 rotolock	26.7 ± 2.9	36.3 ± 3.9	370 ± 40
7/8" Tube-O	23.9 ± 2.9	32.4 ± 3.9	330 ± 40
1-1/16" Tub-O	30 ± 3	40 ± 4	414 ± 41
7/8" Flare	54.9 ± 2.5	74.6 ± 3.4	760 ± 35
3/4" Tube - O	17.3 ± 2.5	23.5 ± 3.4	240 ± 35
3/4" Flare	37.6 ± 1.4	51.0 ± 2.0	520 ± 20
Pad fitting bolt, M10	28.9 ± 2.9	39.2 ± 3.9	440 ± 40
Pad fitting bolt 3/8" -24	28.9 ± 2.9	39.2 ± 3.9	440 ± 40
Pad fitting bolt, M8	26.3 ± 2.9	34.3 ± 3.9	350 ± 40
Clutch lead wire clamp screw	11 ± 3 in•lb	1.3 ± 0.3	13 ± 3
High pressure relief valve	7.2 ± 1.4	9.8 ± 2.0	100 ± 20
Thermal protector switch clamp bolt	7.2 ± 2.2 - 1.4	9.8 ± 2.9 - 2.0	100 ± 30 - 20
Clutch dust cover screws (6 - M5)	6.5 ± 1.4	9 ± 2	90 ± 20
Clutch dust cover screws (3 - 1/4" - 20)	2.7 ± 0.9	3.6 ± 1.2	37 ± 12

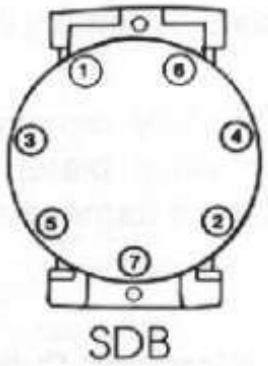
8. Install cylinder head bolts and tighten in a star pattern. Torque first to approximately 14 ft•lbf (19.6 N•m, 200 kgf•cm), then finish by torquing to 24-27 ft•lbf (32.4-36.3 N•m, 330-370kgf•cm).



SD-5



SD-7



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