

INTRODUCTION

TIGHTENING TORQUE

Tighten fasteners to the torque specified. If a torque is not specified, refer to the table.

Torque wrench tightening specification: Torque wrenches when removed or repaired, etc.) must be replaced.

In order to avoid a poor assembly, tighten as follows:

1. Manually rotate all screws, bolts and nuts.
2. Apply half the recommended torque value.
3. Tighten fastener to the recommended torque.

CAUTION: Be sure to use the recommended torque.

NOTE: When possible, always apply torque in the same direction.

NOTE: Always torque screws, bolts and nuts used to secure a cast leg, a cast roller head, a bush and torque pin on a fastener in the same direction.

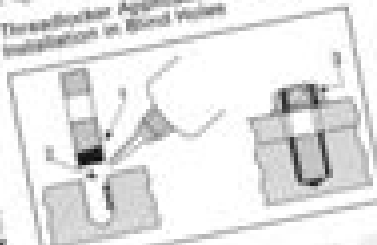
Fastener Size	Torque (N·m)	
	Hex Head Bolt	Hex Head Nut
M4	1.5 - 2.0	1.5 - 2.0
M5	2.0 - 2.5	2.0 - 2.5
M6	2.5 - 3.0	2.5 - 3.0
M8	4.0 - 5.0	4.0 - 5.0
M10	6.0 - 8.0	6.0 - 8.0
M12	10.0 - 12.0	10.0 - 12.0
M14	15.0 - 20.0	15.0 - 20.0
M16	20.0 - 25.0	20.0 - 25.0
M18	25.0 - 30.0	25.0 - 30.0
M20	30.0 - 35.0	30.0 - 35.0
M22	35.0 - 40.0	35.0 - 40.0
M24	40.0 - 45.0	40.0 - 45.0

Fastener Size	Torque (N·m)	
	Hex Head Bolt	Hex Head Nut
M4	1.5 - 2.0	1.5 - 2.0
M5	2.0 - 2.5	2.0 - 2.5
M6	2.5 - 3.0	2.5 - 3.0
M8	4.0 - 5.0	4.0 - 5.0
M10	6.0 - 8.0	6.0 - 8.0
M12	10.0 - 12.0	10.0 - 12.0
M14	15.0 - 20.0	15.0 - 20.0
M16	20.0 - 25.0	20.0 - 25.0
M18	25.0 - 30.0	25.0 - 30.0
M20	30.0 - 35.0	30.0 - 35.0
M22	35.0 - 40.0	35.0 - 40.0
M24	40.0 - 45.0	40.0 - 45.0

INTRODUCTION

1. Apply several drops along the threaded hole and at the bottom of the hole.
2. Apply several drops on both threads.
3. Tighten as required.

Threadlocker Application for Stud Installation in Blind Holes

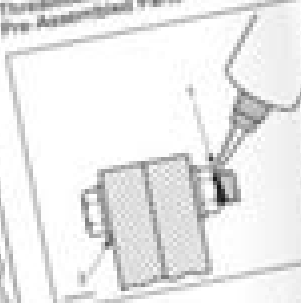


1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE 242 (medium strength) to the threads of the stud and the bottom of the hole.
3. Put 2 or 3 drops of proper strength Loctite on threads of the stud and in the hole.

NOTE: To avoid a hydro lock situation, do not use too much Loctite.

4. Apply several drops of proper strength Loctite on stud threads.
5. Install stud.
6. Install cover part, etc.
7. Apply a few drops of proper strength Loctite on cover part threads.
8. Install and tighten retaining nut as required.

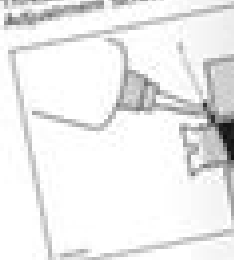
Threadlocker Application for Pre-Assembled Parts



1. Clean both part and hole with solvent.
2. Assemble components.
3. Tighten nut.
4. Apply a few drops of proper strength Loctite on threads of the nut.
5. Apply Loctite on threads of the part.

NOTE: For permanent installation, use Loctite 262 (permanent strength) Loctite on external threads.

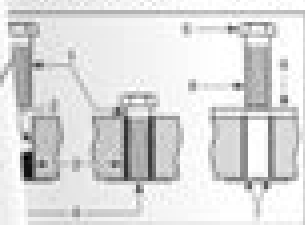
Threadlocker Application for Adjustment Screw



1. Adjust screw to proper value.
2. Apply a few drops of proper strength Loctite on threads of the screw.
3. Avoid touching metal with a finger.

If it is difficult to tighten, heat screw with heating coil (220°C (420°F)).

Application for Stripped Thread Repair



1. Clean both part and hole with solvent.
2. Assemble components.
3. Tighten nut.
4. Apply a few drops of proper strength Loctite on threads of the nut.
5. Apply Loctite on threads of the part.

Thread Repair: Loctite 242 (medium strength) Loctite on threads of the part.

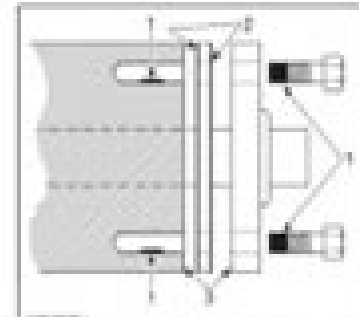
NOTE: For permanent installation, use Loctite 262 (permanent strength) Loctite on external threads.

Threadlocker Application for Adjustment Screw

Adjust screw to proper value. Apply a few drops of proper strength Loctite on threads of the screw. Avoid touching metal with a finger.

INTRODUCTION

Gasket Compound Application



1. Clean both mating surfaces with solvent.
2. Apply Loctite Primer 11 on both mating surfaces and on both sides of gasket and allow to dry 1 or 2 minutes.
3. Apply Loctite 242 (medium strength) Loctite on both sides of gasket, using a clean applicator.
4. Place gasket on mating surfaces and assemble parts immediately.
5. Tighten as usual.

NOTE: If the cover is bolted to blind holes, apply proper strength Loctite in the hole and on threads. Tighten fastener.

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