INTRODUCTION

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 (8.8 GRADE)	Lbf-in
2	N64	18
3	M4	27
4	MS	35
8	M6	71
9	.M6	80
10	M6	89
11	M6	97
12	M6	106

M-m	FASTENER SIZE (8.8 GRADE)	Lbr-n
21	MS	1.5
22	Me	16
23	MB	17
24	MB	3.83
25	MB	18
43	M10	32
44	MID	32
45	M10	33
46	MIO	34
47	MIO	35
48	M10	35
49	MID	36
50	M10	37
51	MIO	38
62	MID	38
5.3	M10	39
76	M12	56
77	M12	57
78	M12	58
79	M12	58

N-m	(8.8 GRADE)	Lbf-ff
80	M12	5.9
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	544
128	M34	94
129	M14	96
130	M14	96
131	M14	97
132	M14	97
133	M14	96
134	M14	99
135	M14	100
136	M14	100
137	M14	1.01
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	109
148	M14	109
149	M14	110
150	M14	111

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Robert R. Redfield

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