



## Torque tightening figures

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# Issue record sheet

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## Standard torque tightening figures

Tighten all setscrews, full nuts, and half nuts to the figures given in the tables, **except** those components listed in the **special torque tightening** section within each Chapter.

**Setscrews** should be tightened to the figures quoted for full or castellated nuts.

**Plated parts** should have all burrs and foreign matter (e.g. grit, grease, and paint) removed from the abutment faces of the nuts, setscrews, washers, and components to ensure that the correct torque tightening figures are obtained.

The threads and abutment faces of **non-plated parts** should be smeared with engine oil before being fitted.

All unified nuts having an identification groove on one end, are to be fitted with the groove end away from the mating face.

**Certain items should not be torque tightened and these are as follows.**

1. Nuts which are locked by riveting
2. Wood screws
3. Hub assembly retaining nuts (front and rear)
4. All threads less than 2 B.A. (except items listed in the special torque tightening sections)

Components used during manufacture of the vehicle have different thread formations (Metric, UNF, UNC, etc.). Therefore, when fitting nuts, bolts, and setscrews it is important to ensure that the correct type and size of thread formation is used.

### Half nut

Size	Nm	kgf m	lbf ft
2 B.A.	3-4	0,3-0,4	30-36 lbf in
1/4 in dia UNF	7-9	0,7-0,9	5-7
7/16 in A/F			
5/16 in dia UNF	18-20	1,8-2,0	13-15
1/2 in A/F			
3/8 in dia UNF	30-33	3,0-3,4	22-25
9/16 in A/F			
7/16 in dia UNF	45-48	4,6-4,9	33-36
5/8 in and			
1 1/16 in A/F			
1/2 in dia UNF	65-70	6,7-7,1	48-52
3/4 in A/F			
5/8 in dia UNF	99-105	10,1-10,7	73-78
7/8 in A/F			

### Metric - Full nut

Size	Nm	kgf m	lbf ft
M6	11-13	1,2-1,3	8-10
M8	28-29	2,8-3,0	20-22
M10	56-59	5,7-6,0	41-44
M12	95-98	9,7-10,0	70-73
M16	240-249	24,5-25,4	177-184

### Full nut

Size	Nm	kgf m	lbf ft
2 B.A.	6-6,5	0,6-0,7	48-60 lbf in
1/4 in dia UNF	11-13	1,2-1,4	8-10
7/16 in A/F			
5/16 in dia UNF	22-24	2,2-2,4	16-18
1/2 in A/F			
3/8 in dia UNF	39-43	4,0-4,4	29-32
9/16 in A/F			
7/16 in dia UNF	57-61	5,8-6,2	42-45
5/8 in and 1 1/16			
in A/F			
1/2 in dia UNF	82-88	8,3-8,9	60-65
3/4 in A/F			
5/8 in dia UNF	116-122	11,6-12,4	85-90
7/8 in A/F			