

[3] TIGHTENING TORQUES

Screws, bolts and nuts must be tightened to the specified torque using a torque wrench, several screws, bolts and nuts such as those used on the cylinder head must be tightened in proper sequence and the proper torque.

(1) Tightening Torques for Special Use Screws, Bolts and Nuts

■ NOTE

- For "" marked screws, bolts and nuts on the table, apply engine oil to their threads and seats before tightening.
- The letter "M" in Size x Pitch means that the screw, bolt or nut dimension stands for metric. The size is the nominal outside diameter in mm of the threads. The pitch is the nominal distance in mm between two threads.

Item	Size x Pitch	N·m	kgf·m	ft-lbs
Cylinder head cover screw	M6 x 1.0	6.9 to 11.3	0.7 to 1.15	5.1 to 8.32
* Cylinder head screw	M11 x 1.25	93.2 to 98.1	9.5 to 10.0	68.7 to 72.3
* Main bearing case screw 1	M9 x 1.25	46.1 to 51.0	4.7 to 5.2	34.0 to 37.6
* Main bearing case screw 2	M10 x 1.25	68.6 to 73.5	7.0 to 7.5	50.6 to 54.2
* Flywheel screw	M12 x 1.25	98.1 to 107.9	10.0 to 11.0	72.3 to 79.6
* Connecting rod screw	M8 x 1.0	44.1 to 49.0	4.5 to 5.0	32.5 to 36.2
* Rocker arm bracket screw	M8 x 1.25	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3
* Idle gear shaft screw	M8 x 1.25	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3
* Fan drive pulley mounting nut	M30 x 1.5	137.3 to 156.9	14.0 to 16.0	101.3 to 115.7
* Bearing case cover screw	M8 x 1.25	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3
Glow plug	M10 x 1.25	19.6 to 24.5	2.0 to 2.5	14.5 to 18.1
Nozzle holder assembly	M20 x 1.5	49.0 to 68.6	5.0 to 7.0	36.2 to 50.6
Oil switch taper screw	P1 1/8	14.7 to 19.6	1.5 to 2.0	10.8 to 14.5
Injection pipe retaining nut	M12 x 1.5	24.5 to 34.3	2.5 to 3.5	18.1 to 25.3
Overflow pipe assembly retaining nut	—	19.6 to 24.5	2.0 to 2.5	14.5 to 18.1
Camshaft set screw	M8 x 1.25	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3
Idle body	M14 x 1.0	44.1 to 49.0	4.5 to 5.0	32.5 to 36.2
Balancer shaft set bolt	M8 x 1.25	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3

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(2) Tightening Torques for General Use Screws, Bolts and Nuts

Grade Nominal Unit Diameter	Standard Screw and Bolt ④			Special Screw and Bolt ⑦		
	N·m	kgf·m	ft-lbs	N·m	kgf·m	ft-lbs
M6	7.9 to 9.3	0.80 to 0.95	5.8 to 6.9	9.8 to 11.3	1.00 to 1.15	7.23 to 8.32
M8	17.7 to 20.6	1.8 to 2.1	13.0 to 15.2	23.5 to 27.5	2.4 to 2.8	17.4 to 20.3
M10	39.2 to 45.1	4.0 to 4.6	28.9 to 33.3	48.1 to 55.9	4.9 to 5.7	35.4 to 41.2
M12	62.8 to 72.6	6.4 to 7.4	46.3 to 53.5	77.5 to 90.2	7.9 to 9.2	57.1 to 66.5

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Screw and bolt material grades are shown by numbers punched on the screw and bolt heads. Prior to tightening, be sure to check out the numbers as shown below.

Punched number	Screw and bolt material grade
None or 4	Standard screw and bolt S400, S20C
7	Special screw and bolt S43C, S48C (Refined)

W161 2706

Kubota 3 Series Diesel Engine Workshop Manual

S Marginson



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