| Part to tightened      |        | Part<br>name | Thread<br>size | Q'ty | Tightening torque |         |       | Remarks     |
|------------------------|--------|--------------|----------------|------|-------------------|---------|-------|-------------|
|                        |        |              |                |      | Nm                | m•kg    | ft•lb | Remarks     |
| ENGINE:                | -1.255 |              | Q 500          |      | or ex             | Wante D |       |             |
| Engine unit            |        | Bolt         | M8             | 8    | 21                | 2.1     | 15    |             |
| Flywheel               |        | Nut          | M20            | 1    | 160               | 16      | 115   | <b>⊸</b> @  |
| Intake manifold        | 1st    | Bolt         | M6             | 8    | 4                 | 0.4     | 2.9   |             |
|                        | 2nd    |              |                |      | 8                 | 0.8     | 5.8   | 1           |
| Reed valve             |        | Bolt         | M3             | 18   | -1                | 0.1     | 0.7   |             |
| Spark plug             |        | Bolt         | M14            | 3    | 25                | 2.5     | 18    |             |
| Cylinder head          | 1st    | Bolt         | M8             | 14   | 15                | 1.5     | 31    | -@          |
|                        | 2nd    |              |                |      | 32                | 3.2     | 23    |             |
| Exhaust cover          | 1st    | Bolt         | М6             | 16   | 3                 | 0.3     | 2.2   | ⊸a          |
|                        | 2nd    |              |                |      | 8                 | 0.8     | 5.8   |             |
| Crank case             | 1st    | Bolt         | M8             | 6    | 10                | 1.0     | 7.2   | <b>⊸</b> ⊚  |
|                        | 2nd    |              |                |      | 20                | 2.0     | 14    |             |
|                        | 1st    |              | M10            | 8    | 20                | 2.0     | 14    | ⊸a          |
|                        | 2nd    |              |                |      | 40                | 4.0     | 29    |             |
| LOWER:                 |        | Nut          |                | FA.  |                   |         |       |             |
| Propeller              |        | Nut          | M16            | 1    | 30                | 3.0     | 22    |             |
| Lower unit             |        | Nut          | M10            | 4    | 40                | 4.0     | 29    |             |
| Ring nut               |        | Nut          | M101.5         | 1    | 145               | 14.5    | 105   |             |
| Pinion nut             |        | Nut          | M16            | 1    | 95                | 9.5     | 68    |             |
| BRACKET:               |        |              | SO 7           |      |                   |         |       |             |
| Main switch            |        | Nut          | M20            | 1    | 5                 | 0.5     | 3.6   |             |
| Engine stop switch     |        | Nut          | M16            | 1    | 4                 | 0.4     | 2.9   |             |
| Muffler mounting       |        | Bolt         | M8             | 4    | 21                | 2.1     | 15    |             |
| Exhaust manifold       |        | Bolt         | M8             | 3    | 21                | 2.1     | 15    | <b>-</b> €: |
| Exhaust guide mounting |        | Bolt         | M8             | 2    | 21                | 2.1     | 15    |             |
| Clamp bracket          |        | Nut          | M22            | 1    | 15                | 1.5     | 11    | ⊸o          |
| Spring hook            |        | Bolt         | M6             | 1    | 8                 | 0.8     | 5.8   |             |

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