



## STANDARD TIGHTENING TORQUE

### 1. STANDARD TIGHTENING TORQUE OF BOLTS AND NUTS

The following charts give the standard tightening torques of bolts and nuts. Exceptions are given in sections of "Disassembly and Assembly".

Thread diameter of bolt (mm)	Width across flat (mm)	kgm	Nm
6	10	$1.35 \pm 0.15$	$13.2 \pm 1.4$
8	13	$3.2 \pm 0.3$	$31.4 \pm 2.9$
10	17	$6.7 \pm 0.7$	$65.7 \pm 6.8$
12	19	$11.5 \pm 1.0$	$112 \pm 9.8$
14	22	$18.0 \pm 2.0$	$177 \pm 19$
16	24	$28.5 \pm 3$	$279 \pm 29$
18	27	$39 \pm 4$	$383 \pm 39$
20	30	$56 \pm 6$	$549 \pm 58$
22	32	$76 \pm 8$	$745 \pm 78$
24	36	$94.5 \pm 10$	$927 \pm 98$
27	41	$135 \pm 15$	$1320 \pm 140$
30	46	$175 \pm 20$	$1720 \pm 190$
33	50	$225 \pm 25$	$2210 \pm 240$
36	55	$280 \pm 30$	$2750 \pm 290$
39	60	$335 \pm 35$	$3280 \pm 340$

This torque table does not apply to the bolts with which nylon packings or other non-ferrous metal washers are to be used, or which require tightening to otherwise specified torque.

★ Nm (newton meter):  $1\text{Nm} \approx 0.1\text{ kgm}$

### 2. TIGHTENING TORQUE OF SPLIT FLANGE BOLTS

Use these torques for split flange bolts.

Thread diameter of bolt (mm)	Width across flats (mm)	Tightening torque	
		kgm	Nm
10	14	$6.7 \pm 0.7$	$65.7 \pm 6.8$
12	17	$11.5 \pm 1$	$112 \pm 9.8$
16	22	$28.5 \pm 3$	$279 \pm 29$

# Komatsu Excavator Pc03 2 Pc 03 Service Repair Shop Manual

**SA Adler**



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