

INTRODUCTION

TIGHTENING TORQUE

Tighten fasteners to the torque specified. If a torque is not specified, refer to the table.

Torque wrench tightening specification: Locking devices when removed (e.g., pins, etc.) must be replaced.

In order to avoid a poor assembly, tighten as follows:

1. Manually rotate all screws, bolts and nuts.
2. Apply half the recommended torque value.
3. Tighten fastener to the recommended torque.

CAUTION: Be sure to use the recommended

NOTE: When possible, always apply torque in

NOTE: Always torque screws, bolts and nuts used to secure a cast leg, a cast roller head, a bush and torque pin(s) as defined in the instructions.

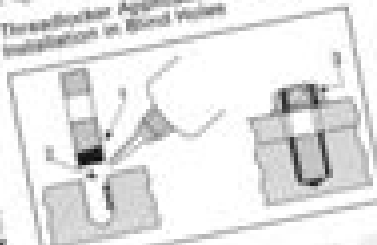
PROPERTY CLASS AND MARKINGS	S.S.	
	10.9	12.9
Property class and markings		
Property class and markings		

FASTENER SIZE	FASTENER	
	S.S. Grade	S.S. Grade
M4	1.5 – 2.0mm 17.5 – 22.5mm	2.5 – 3.0mm 22.5 – 27.5mm
M5	2.0mm – 2.5mm 22.5mm – 27.5mm	2.5mm – 3.0mm 22.5mm – 27.5mm
M6	2.5mm – 3.0mm 22.5mm – 27.5mm	3.0mm – 3.5mm 27.5mm – 32.5mm
M8	3.0mm – 3.5mm 27.5mm – 32.5mm	3.5mm – 4.0mm 32.5mm – 37.5mm
M10	3.5mm – 4.0mm 32.5mm – 37.5mm	4.0mm – 4.5mm 37.5mm – 42.5mm
M12	4.0mm – 4.5mm 37.5mm – 42.5mm	4.5mm – 5.0mm 42.5mm – 47.5mm
M16	5.0mm – 5.5mm 47.5mm – 52.5mm	5.5mm – 6.0mm 52.5mm – 57.5mm

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4. Apply several drops along the threaded hole and at the bottom of the hole.
5. Apply several drops on both threads.
6. Tighten as required.

Threadlocker Application for Stud Installation in Blind Holes

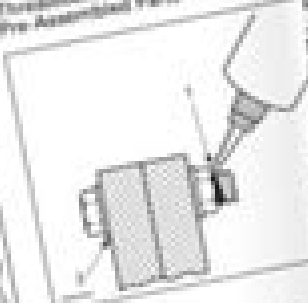


1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE Hysse (medium strength) Loctite on threads and allow to dry.
3. Put 2 or 3 drops of proper strength Loctite (Threadlocker or Hysse) on the hole.

NOTE: To avoid a hydro lock situation, do not use too much Loctite.

4. Apply several drops of proper strength Loctite on stud threads.
5. Install stud.
6. Install cover part, etc.
7. Apply a few drops of proper strength Loctite on cover part threads.
8. Install and tighten retaining nut(s) as required.

Threadlocker Application for Pre-Assembled Parts



1. Clean both part and hole with solvent.
2. Assemble components.
3. Tighten nuts.
4. Apply a few drops of proper strength Loctite on both contact surfaces.
5. Avoid loading metal with too little.

NOTE: For permanent installation (e.g., fasteners, retaining nuts and washers) Loctite on external contact surfaces.

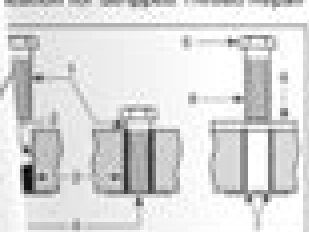
Threadlocker Application for Adjustment Screws



1. Adjust screw to proper value.
2. Apply a few drops of proper Threadlocker on screw threads.
3. Avoid loading metal with too

little is difficult to adjust. Heat screws with spring steel (220°C (400°F)).

Application for Stripped Thread Repair



1. Clean hole and hole with solvent.
2. Apply Loctite Hysse (medium strength) Loctite on hole.
3. Insert new screw.
4. Tighten screw.

Thread Repair: Loctite on Loctite (Hysse) A-1100 (40-50% strength) on mating surfaces.

Apply a few drops of proper strength Loctite on mating surfaces. Apply a few drops of proper strength Loctite on mating surfaces. Apply a few drops of proper strength Loctite on mating surfaces.

Thread Repair: Loctite on Loctite (Hysse) A-1100 (40-50% strength) on mating surfaces.

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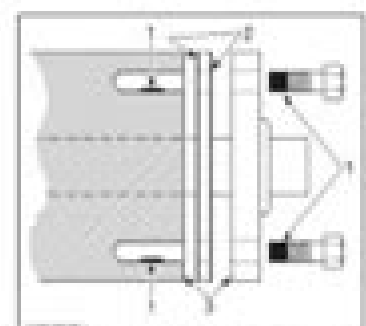
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Gasket Compound Application



1. Clean both mating surfaces with solvent.
2. Apply Loctite Hysse (medium strength) Loctite on both mating surfaces.
3. Assemble parts.

NOTE: If the cover is bolted to blind holes, apply proper strength Loctite in the hole and on threads. Tighten fasteners.

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