

1.5 TORQUE SPECIFICATIONS

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 the proper sequence and at the proper torque.

1.5.1 Torque Specifications For Special Use Screws, Bolts and Nuts

In removing and applying the screws, bolts and nuts marked with "*", a pneumatic wrench or similar tool, if employed, must be used with care. Failure to do so may result in stripped or seized screws, bolts and nuts.

When replacing "*" marked screws, bolt and nuts, apply engine oil to their threads and seats before reassembly.

The letter "M" in size and pitch means that the screw, bolt or nut dimension is 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 Bolt | M6 x 1.0 | 6.9 to 11.3 | 0.7 to 1.15 | 5.1 to 8.32 |
| *Cylinder Head Bolt | M11 x 1.25 | 93.1 to 96.0 | 9.5 to 10.0 | 68.7 to 72.3 |
| *Main Bearing Case Bolt 1 | M9 x 1.25 | 46.1 to 50.9 | 4.7 to 5.2 | 34.0 to 37.6 |
| *Main Bearing Case Bolt 2 | M10 x 1.25 | 68.6 to 73.5 | 7.0 to 7.5 | 50.6 to 54.2 |
| *Flywheel Bolt | M12 x 1.25 | 98.09 to 107.8 | 10.0 to 11.0 | 72.3 to 79.5 |
| *Connecting Rod Bolt | M8 x 1.0 | 44.1 to 49.0 | 4.5 to 5.0 | 32.5 to 36.2 |
| *Rocker Arm Bracket Bolt | M8 x 1.25 | 23.5 to 27.5 | 2.4 to 2.8 | 17.4 to 20.3 |
| *Idle Gear Shaft Bolt | M8 x 1.25 | 23.5 to 27.5 | 2.4 to 2.8 | 17.4 to 20.3 |
| Crank Pulley Mounting Nut | - | 137.3 to 156.9 | 14.0 to 16.0 | 101.3 to 115.7 |
| *Bearing Case Cover Bolt | 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 Clamp Bolt | - | 25.5 to 29.4 | 2.6 to 3.0 | 18.8 to 21.7 |
| Oil Switch Taper Bolt | PT1/8 | 14.7 to 19.6 | 1.5 to 2.0 | 10.8 to 14.5 |
| Injection Pipe Retaining Nut | M12 x 1.5 | 14.7 to 24.5 | 1.5 to 2.5 | 10.8 to 18.1 |
| Overflow Pipe Assembly Retaining Bolt | - | 9.8 to 11.3 | 1.0 to 1.15 | 7.2 to 8.3 |
| Camshaft Retaining Bolt | M8 x 1.25 | 23.5 to 27.5 | 2.4 to 2.8 | 17.4 to 20.3 |
| Hi-idling Body | - | 44.1 to 49.0 | 4.5 to 5.0 | 32.6 to 36.3 |

1.5.2 Torque Specifications For General Use Screws, Bolts and Nuts

| | Standard Screw and Bolt Grade 4 | | | Special Screw and Bolt Grade 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 |

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 S5400, S20C |
| 7 | Special Screw And Bolt S43C, S48C (Refined) |

Kubota Diesel Engine Torque Specs

Didier Musso



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Table of Contents Kubota Diesel Engine Torque Specs

1. Understanding the eBook Kubota Diesel Engine Torque Specs
 - The Rise of Digital Reading Kubota Diesel Engine Torque Specs
 - Advantages of eBooks Over Traditional Books
2. Identifying Kubota Diesel Engine Torque Specs
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Kubota Diesel Engine Torque Specs
 - User-Friendly Interface
4. Exploring eBook Recommendations from Kubota Diesel Engine Torque Specs
 - Personalized Recommendations
 - Kubota Diesel Engine Torque Specs User Reviews and Ratings
 - Kubota Diesel Engine Torque Specs and Bestseller Lists
5. Accessing Kubota Diesel Engine Torque Specs Free and Paid eBooks
 - Kubota Diesel Engine Torque Specs Public Domain eBooks
 - Kubota Diesel Engine Torque Specs eBook Subscription Services

- Kubota Diesel Engine Torque Specs Budget-Friendly Options
- 6. Navigating Kubota Diesel Engine Torque Specs eBook Formats
 - ePub, PDF, MOBI, and More
 - Kubota Diesel Engine Torque Specs Compatibility with Devices
 - Kubota Diesel Engine Torque Specs Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Kubota Diesel Engine Torque Specs
 - Highlighting and Note-Taking Kubota Diesel Engine Torque Specs
 - Interactive Elements Kubota Diesel Engine Torque Specs
- 8. Staying Engaged with Kubota Diesel Engine Torque Specs
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Kubota Diesel Engine Torque Specs
- 9. Balancing eBooks and Physical Books Kubota Diesel Engine Torque Specs
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Kubota Diesel Engine Torque Specs
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Kubota Diesel Engine Torque Specs
 - Setting Reading Goals Kubota Diesel Engine Torque Specs
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Kubota Diesel Engine Torque Specs
 - Fact-Checking eBook Content of Kubota Diesel Engine Torque Specs
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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