

Main Tightening Torques Guide

PEUGEOT
SPORT

208
Rally4

O P E L
MOTORSPORT

CORSA
RALLY4

LANCIA
CORSE

Upsilon
RALLY4

Tightening torques for standard screws

Visserie Acier noir ou Zinguée / Lubrification légère = Cdf. 015

Steel black or zinc plated screws / Light lubrication = Fc. 015

Acero tornillos negros o cincados / Lubricación ligera = Cdf. 015

		Couple de serrage en N.m Tightening torque in N.m Par de apriete en N.m		
		Cl. 8.8	Cl. 10.9	Cl. 12.9
4	0,7	2,78	4,09	4,79
5	0,8	5,5	8,1	9,5
6	1	9,5	14	16,4
8	1,25	23	34	40
10	1,5	46	67	79
12	1,75	79	116	136
14	2	127	187	219
16	2	198	291	341
18	2,5	283	402	471
20	2,5	402	570	667
22	2,5	552	783	917

Visserie Acier noir ou Zinguée / A SEC = Cdf. 020

Steel black or zinc plated screws / DRY = Fc. 020

Acero tornillos negros o cincados / SECO = Cdf. 020

		Couple de serrage en N.m Tightening torque in N.m Par de apriete en N.m		
		Cl. 8.8	Cl. 10.9	Cl. 12.9
4	0,7	3,22	4,74	5,5
5	0,8	6,4	9,4	11
6	1	11,1	16,3	19,1
8	1,25	27	39	46
10	1,5	53	78	92
12	1,75	92	136	159
14	2	148	218	255
16	2	232	341	399
18	2,5	330	46	549
20	2,5	471	667	781
22	2,5	648	920	1077

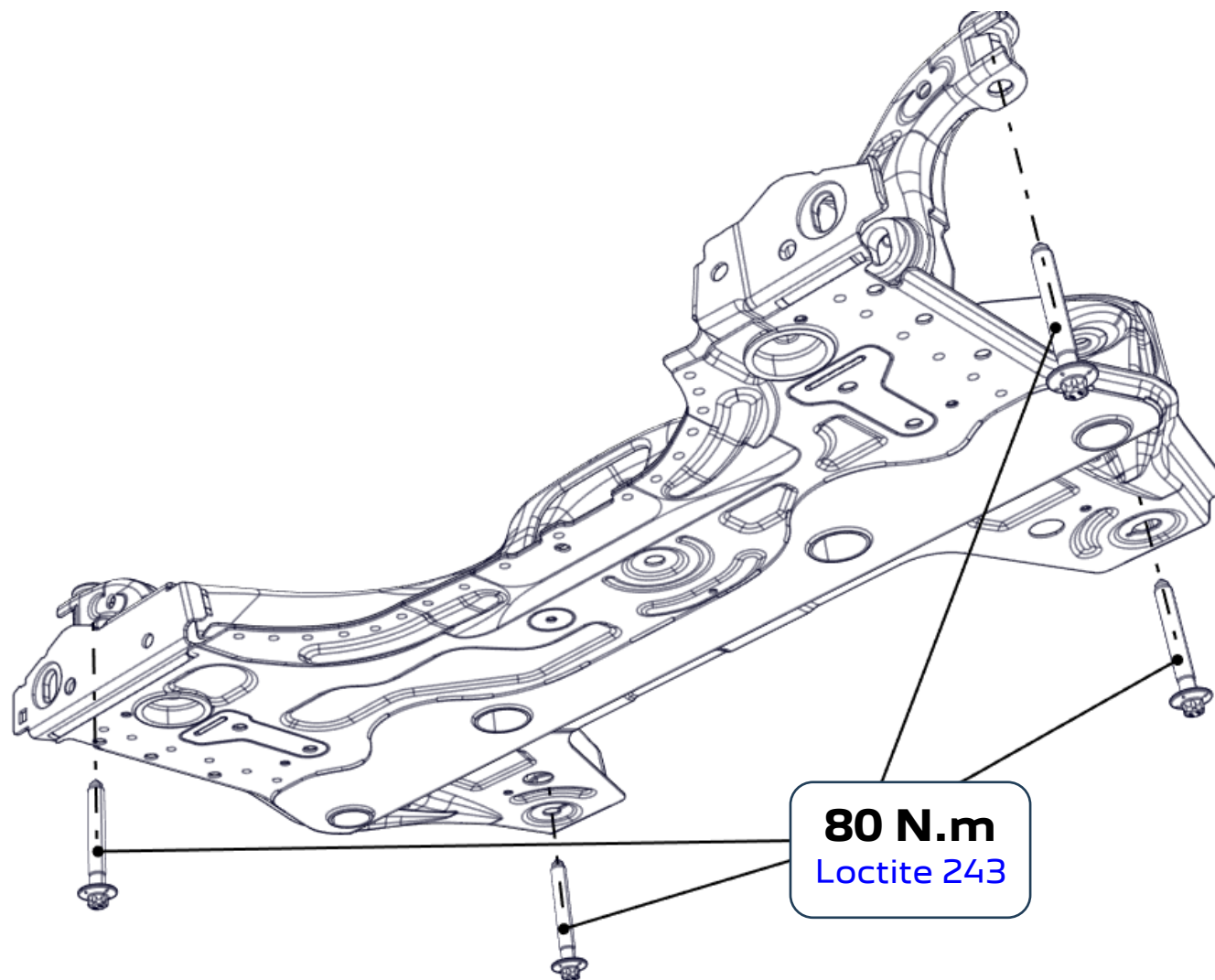
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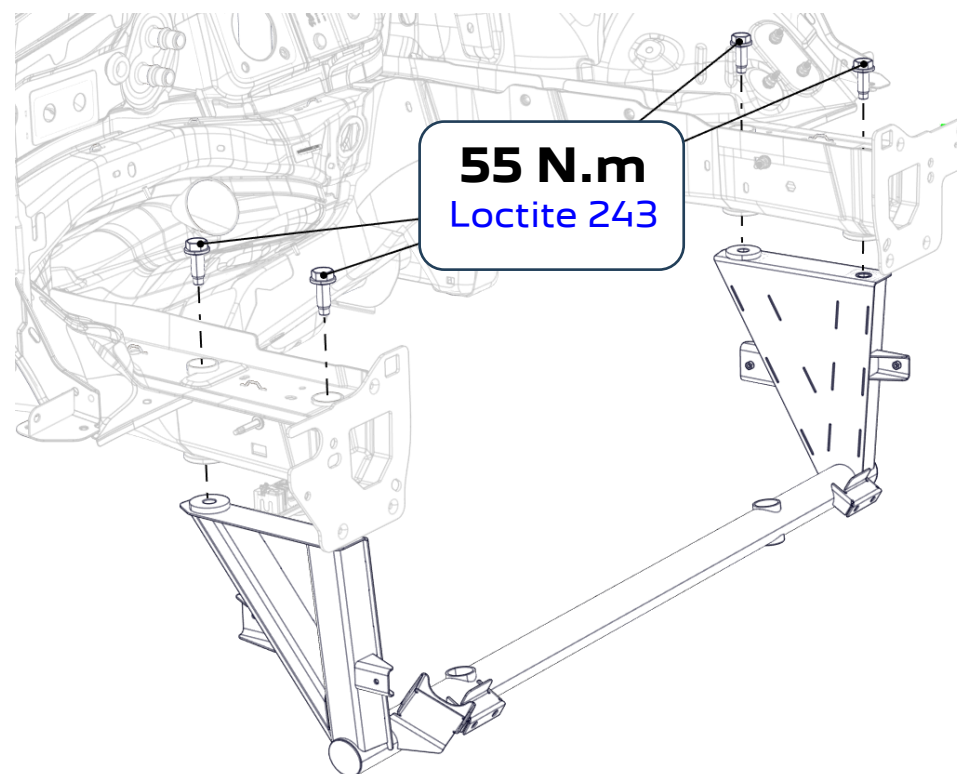
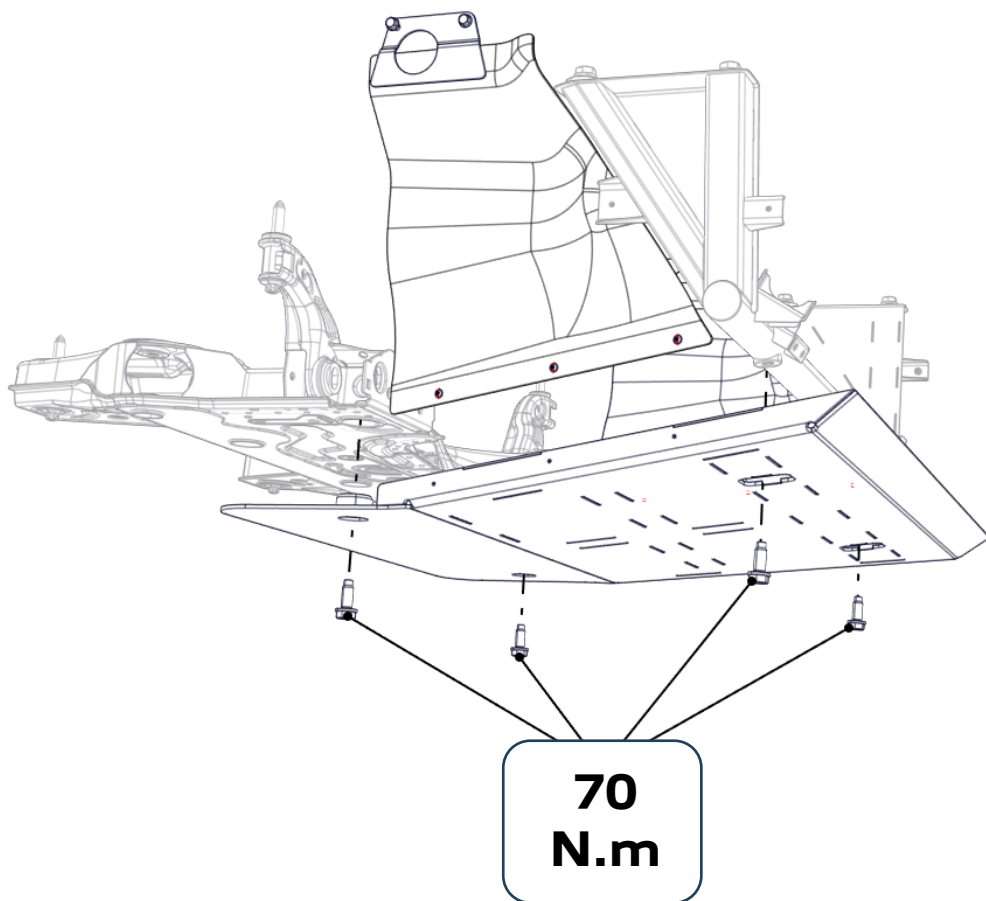
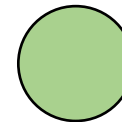
FRONT AXLE



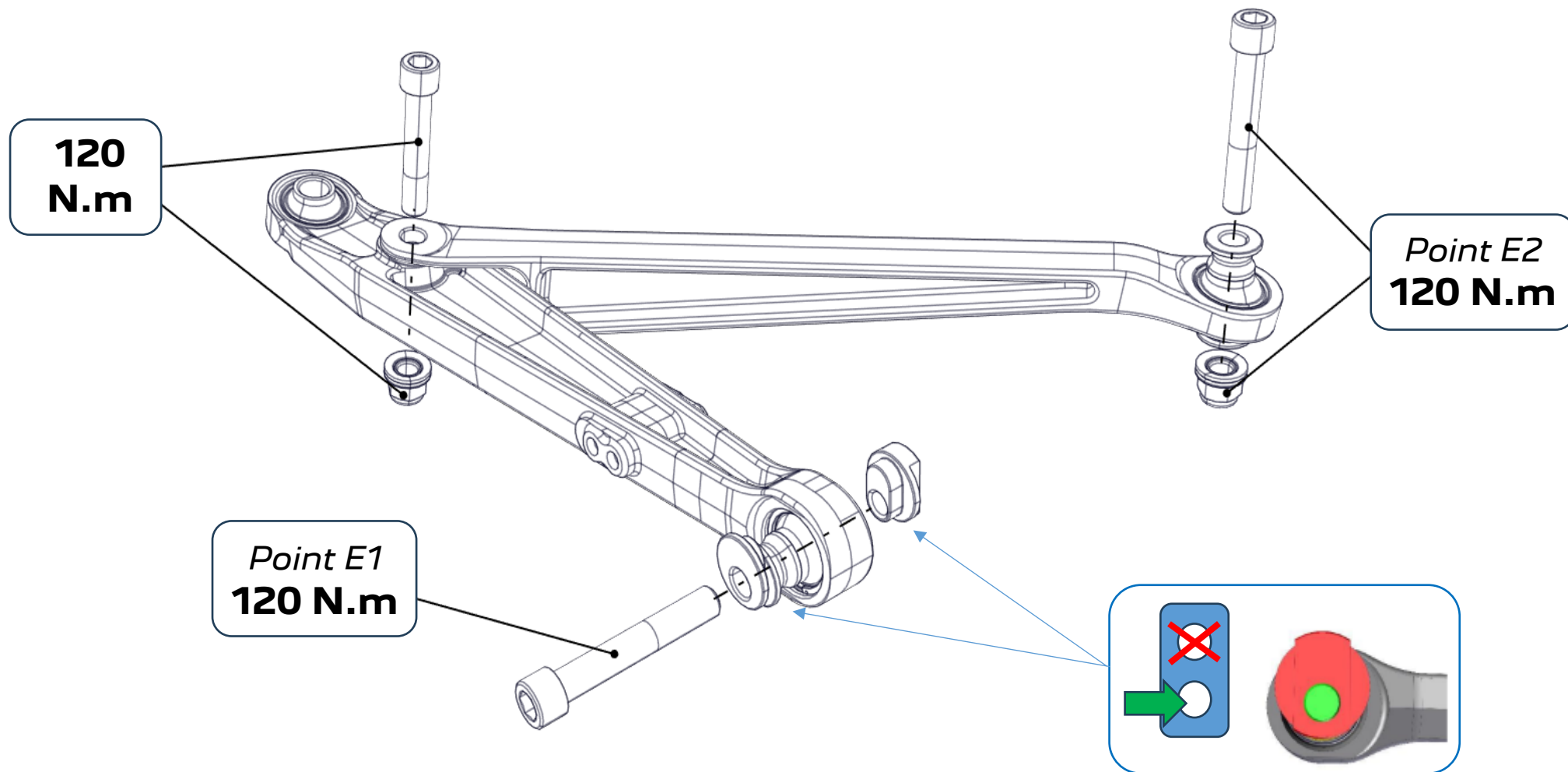
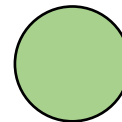
E11 FRONT SUBFRAME



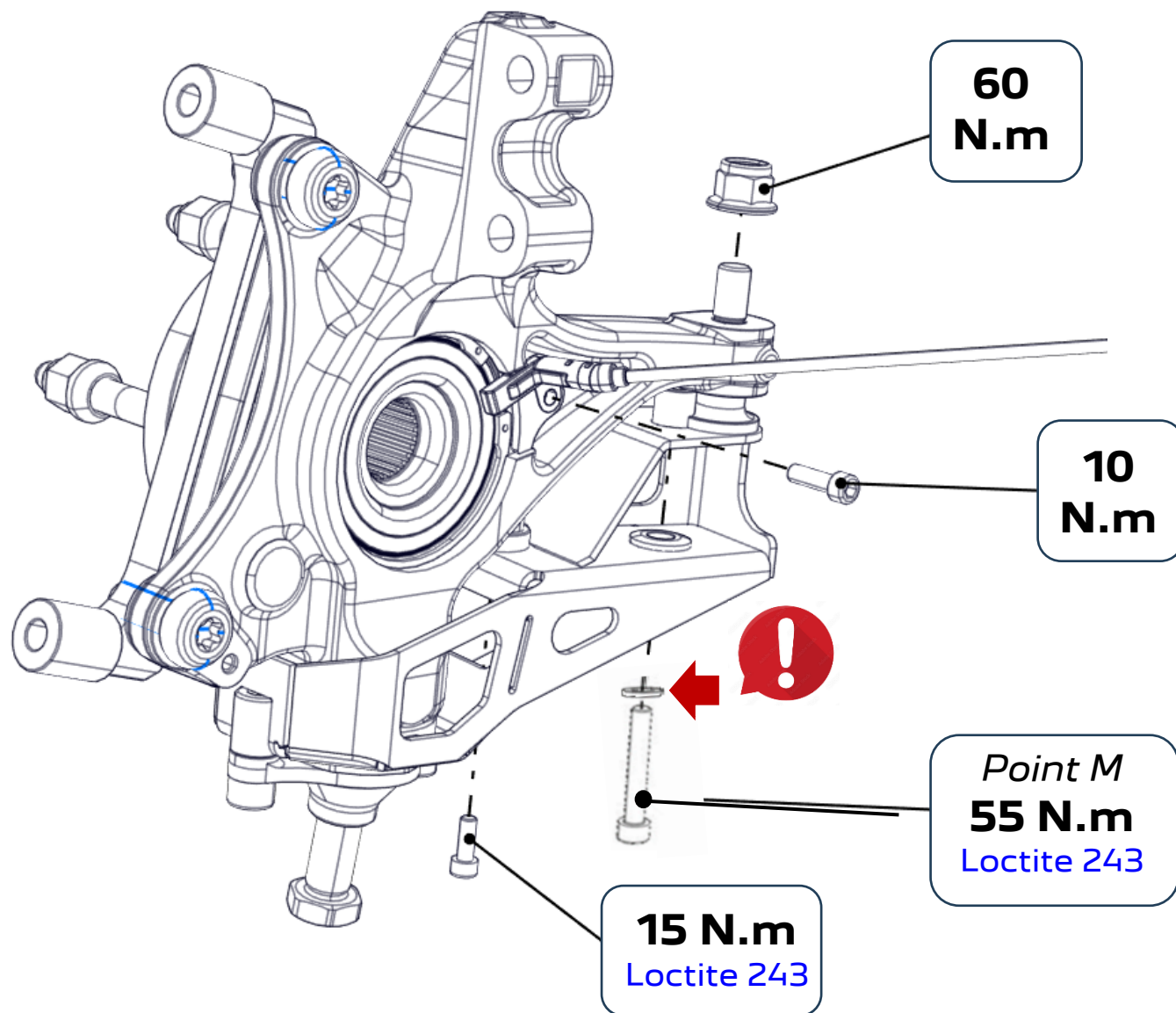
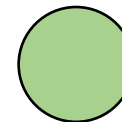
R6A FRONT SUMPGUARD

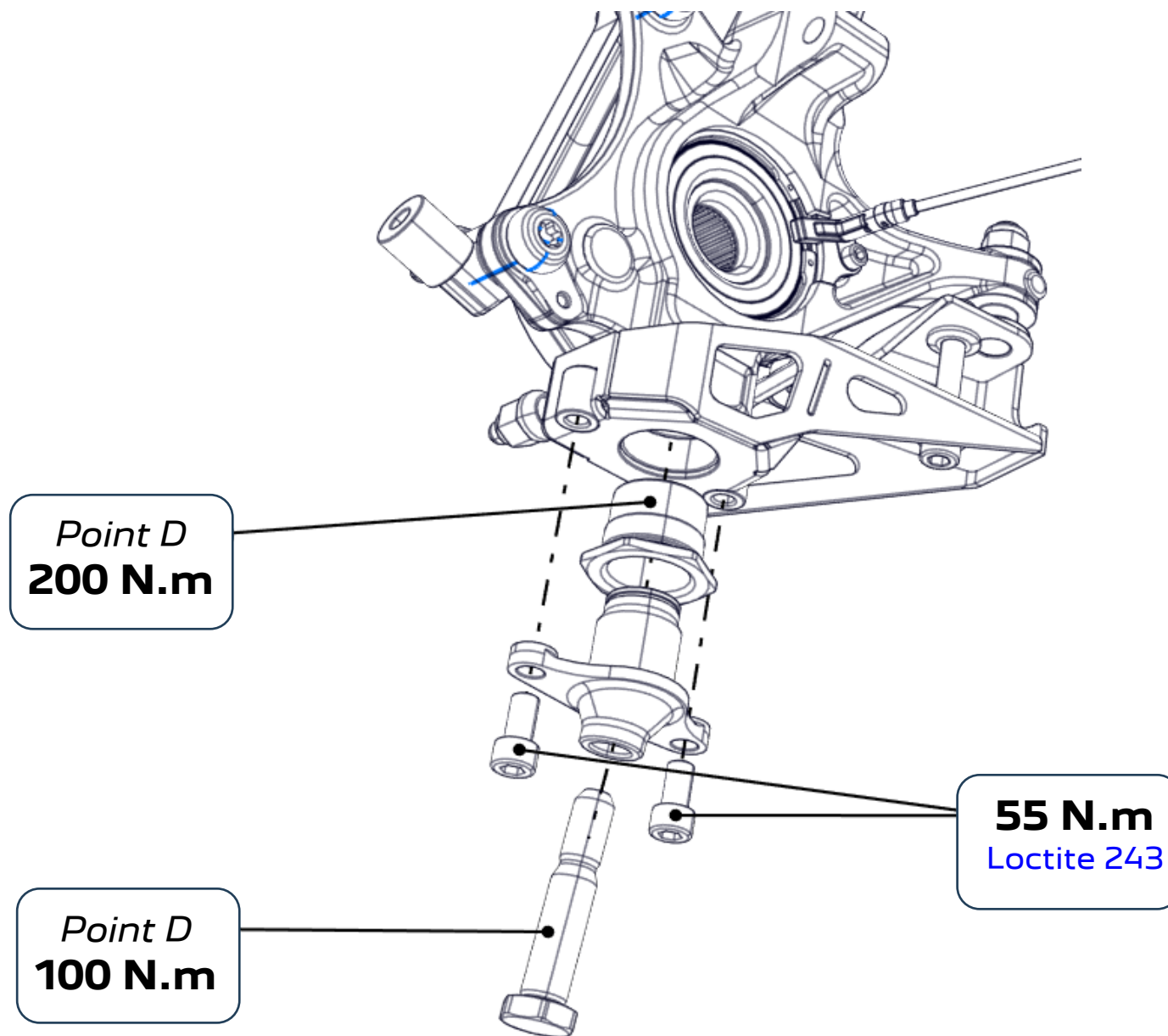
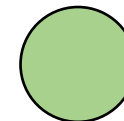


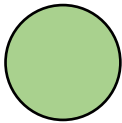
E12 FRONT WISHBONE



E13 FRONT UPRIGHT

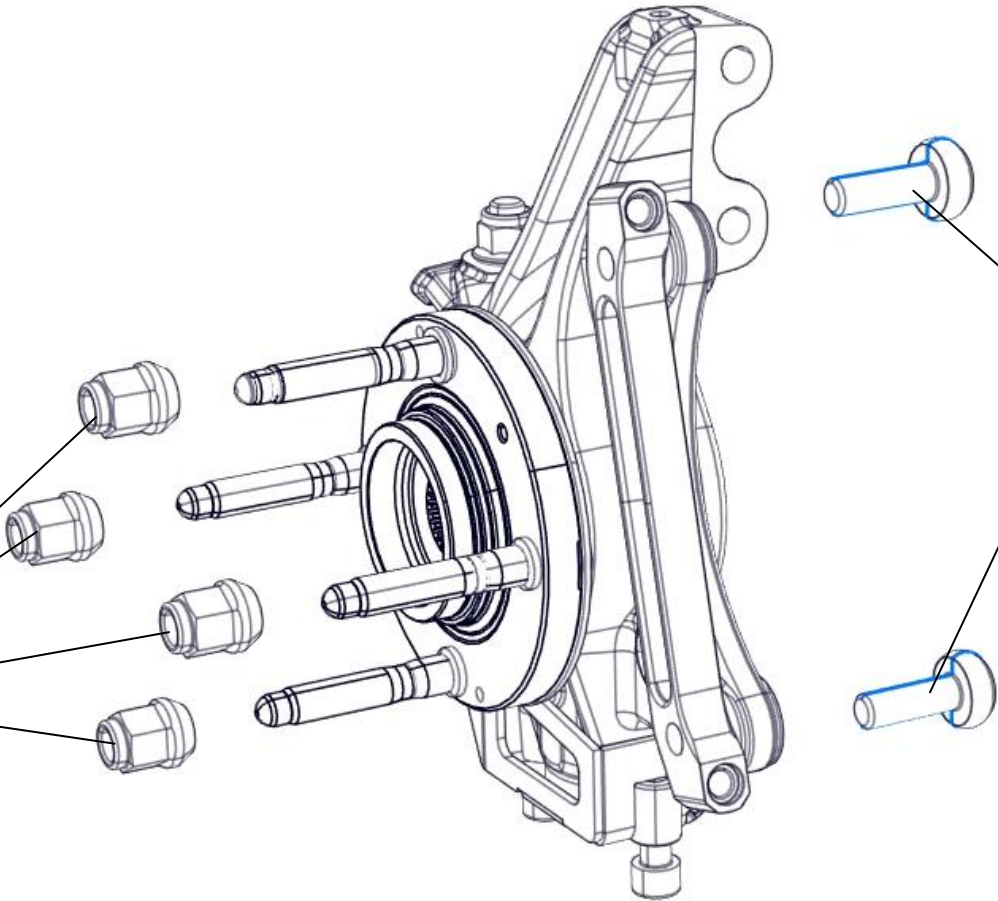




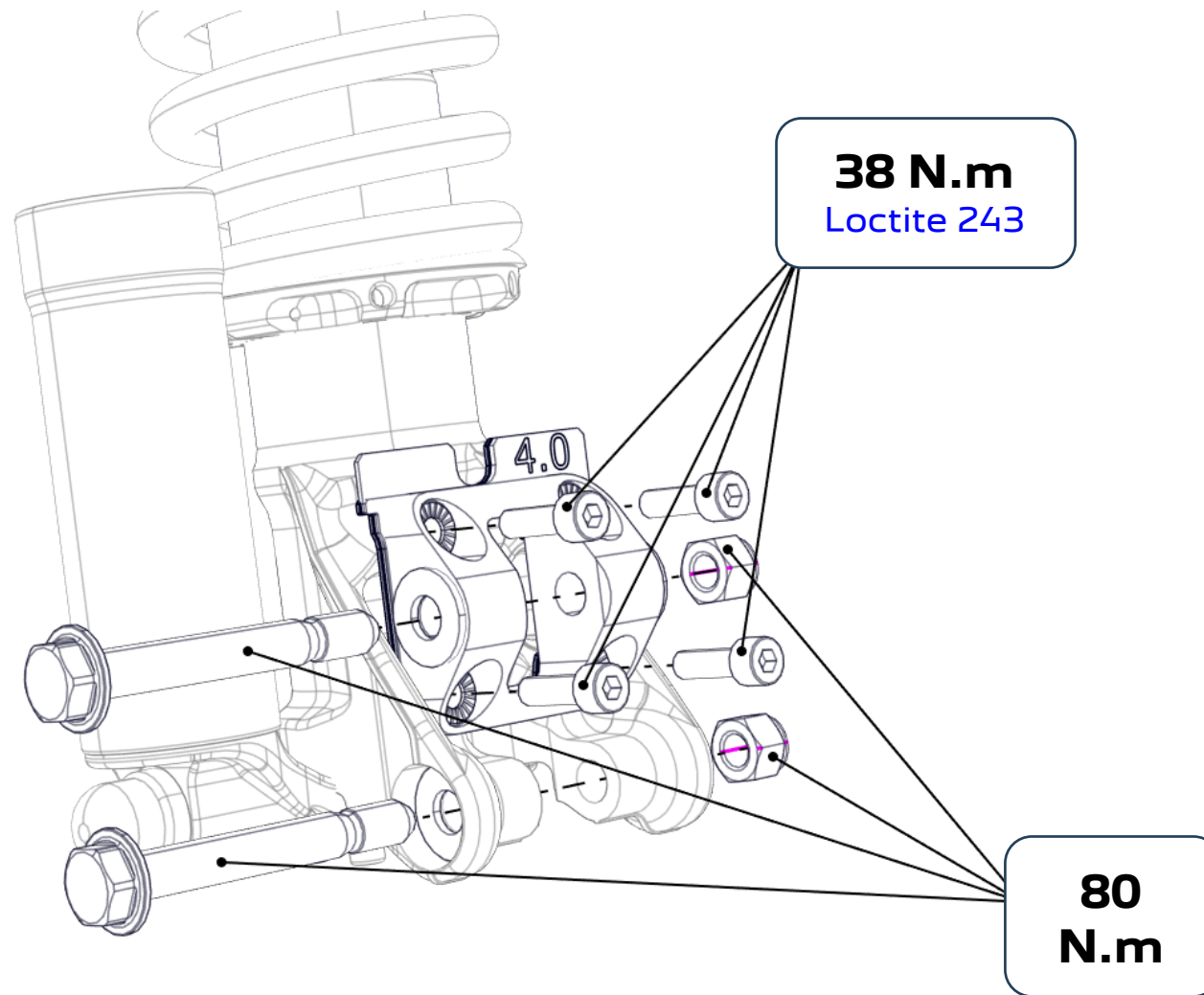
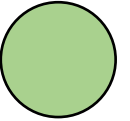


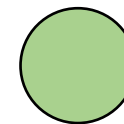
110 N.m
Copper grease

100 N.m

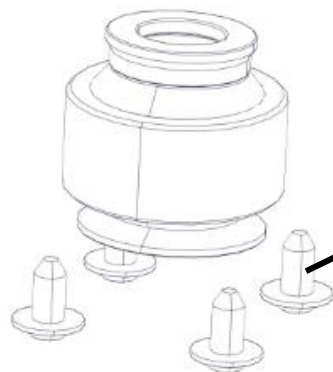


E14 FRONT SUSPENSION

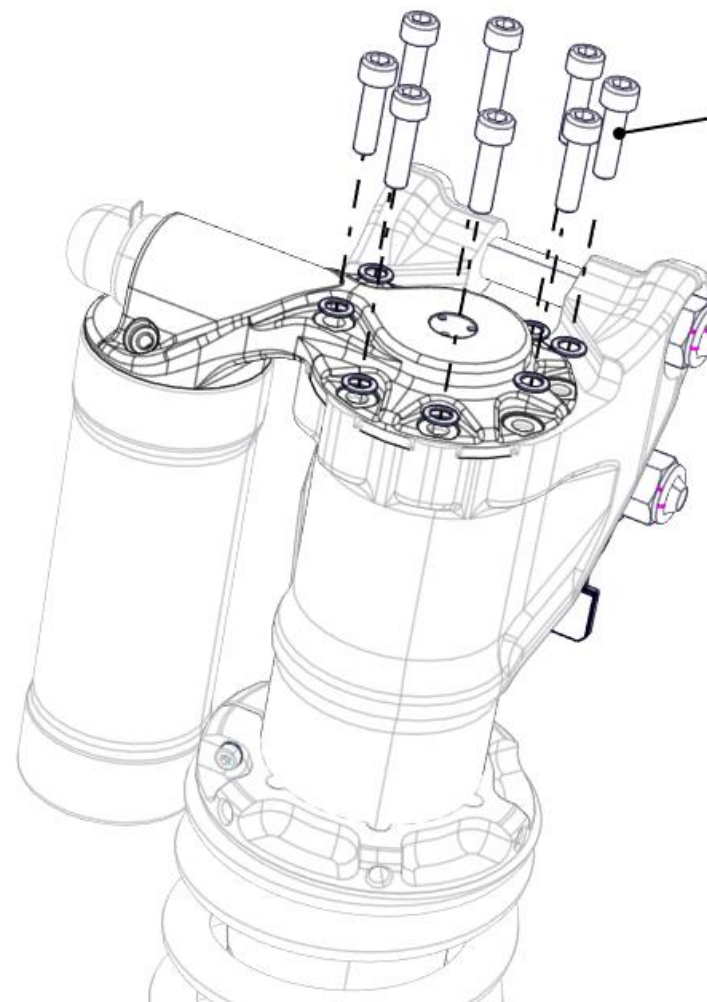
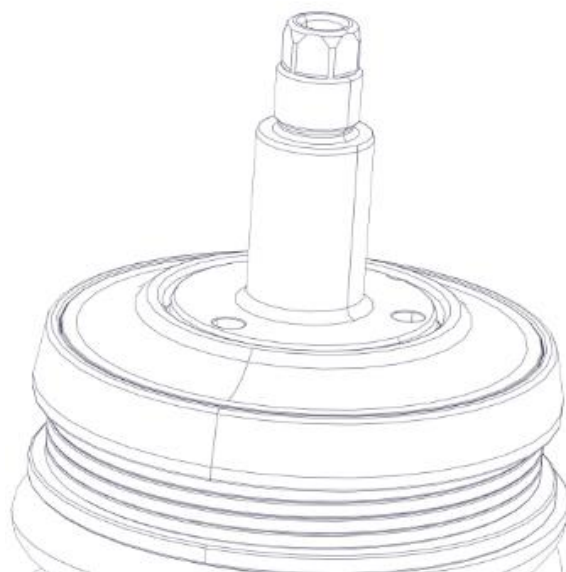




**55
N.m**

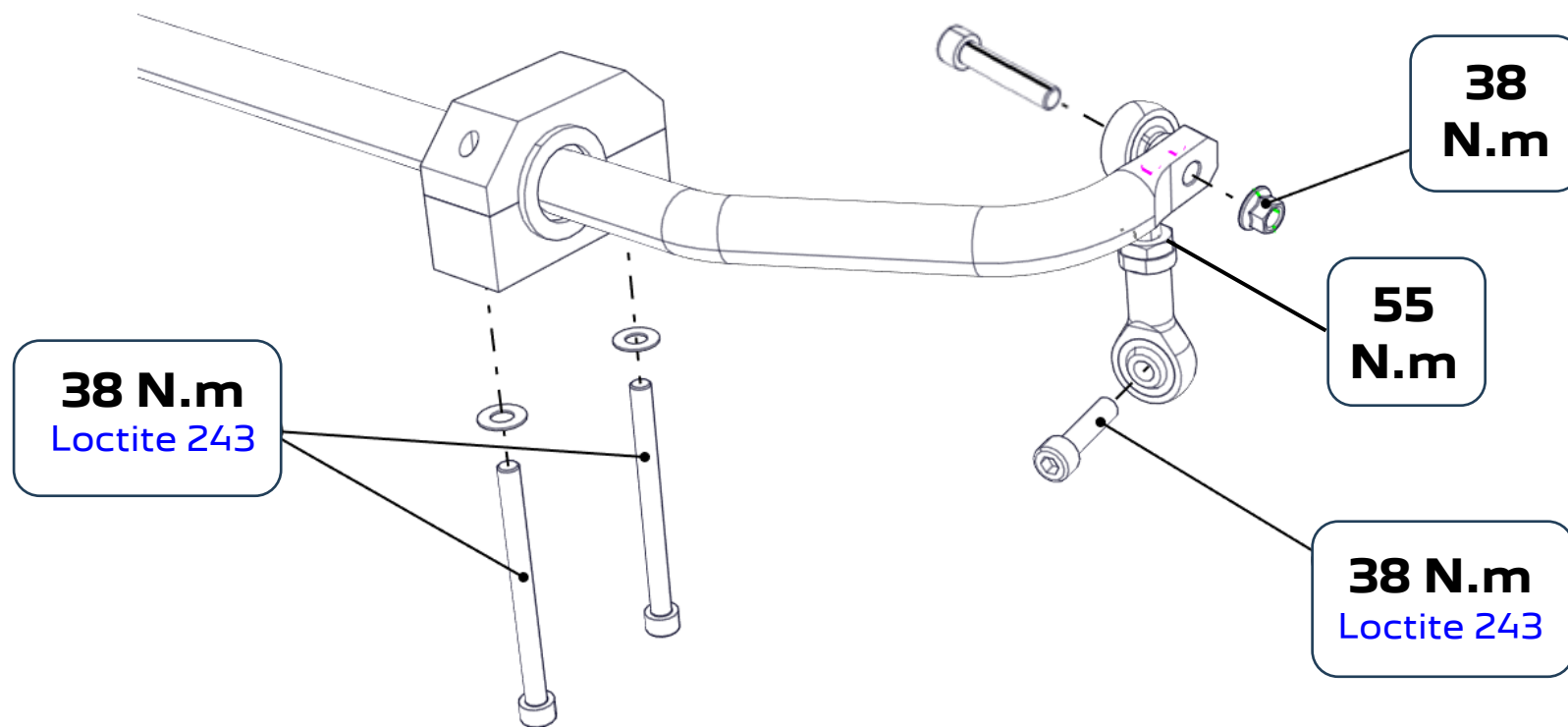
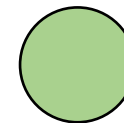


10 N.m
Loctite 222

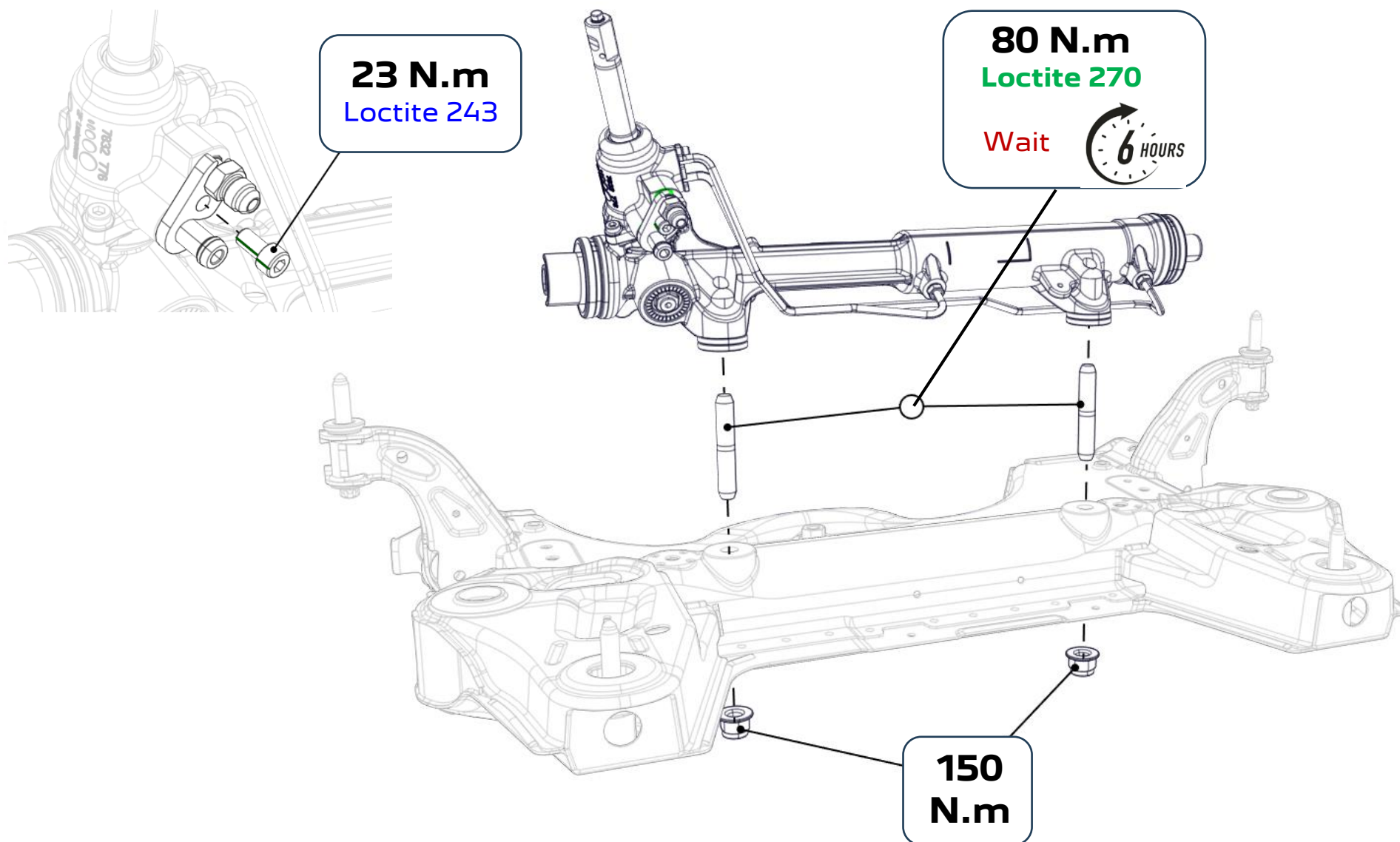
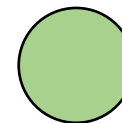


15 N.m
Loctite 243

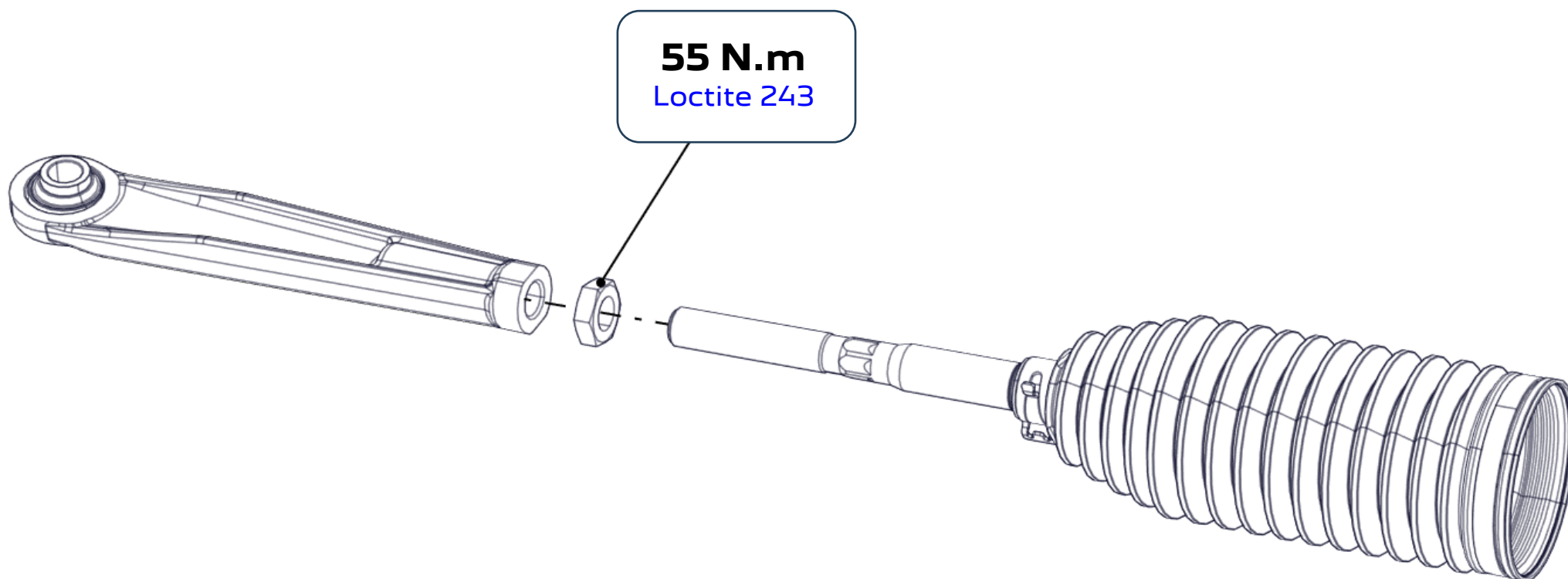
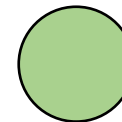
E15 FRONT ANTIROLL BAR

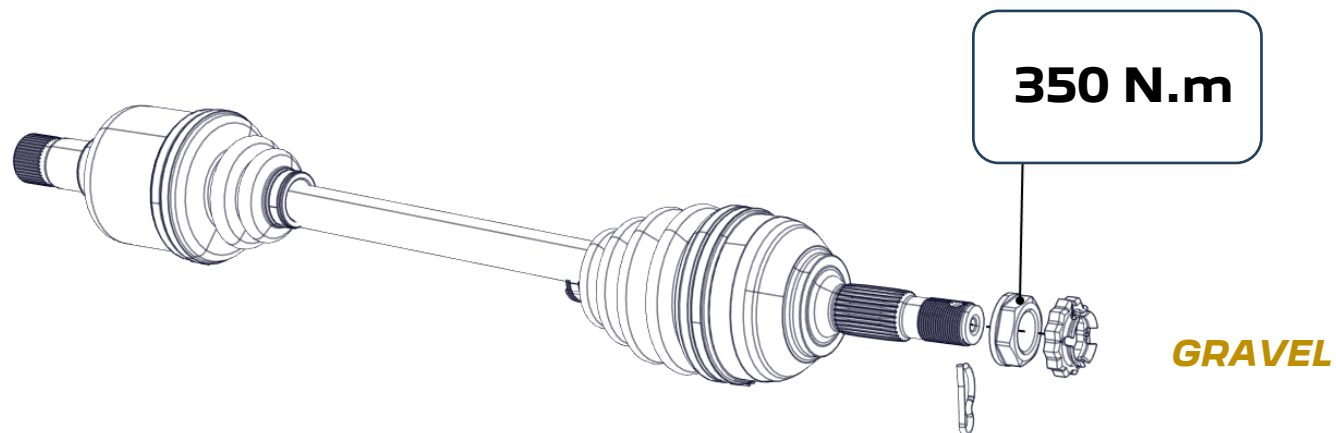
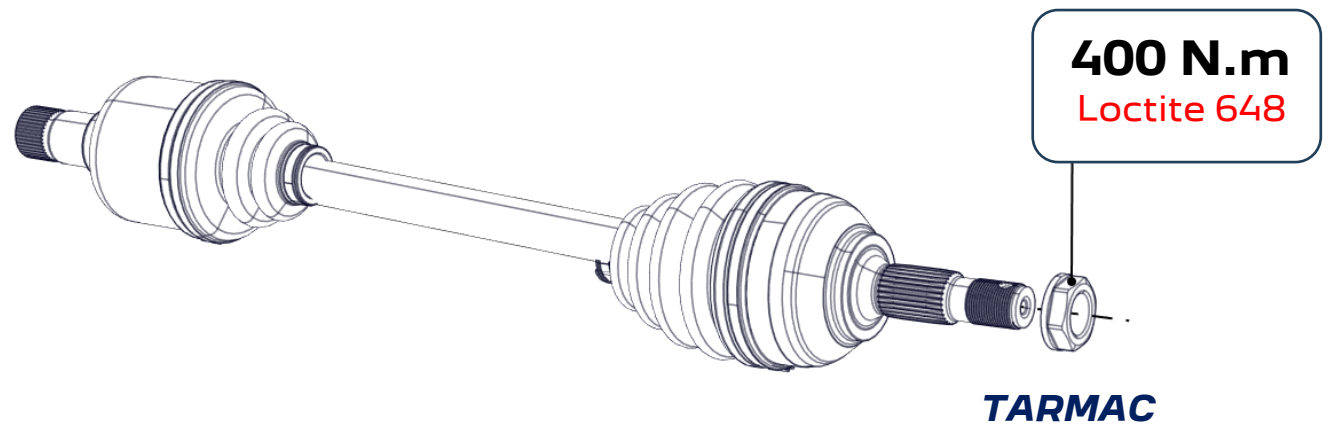
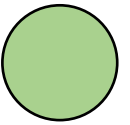


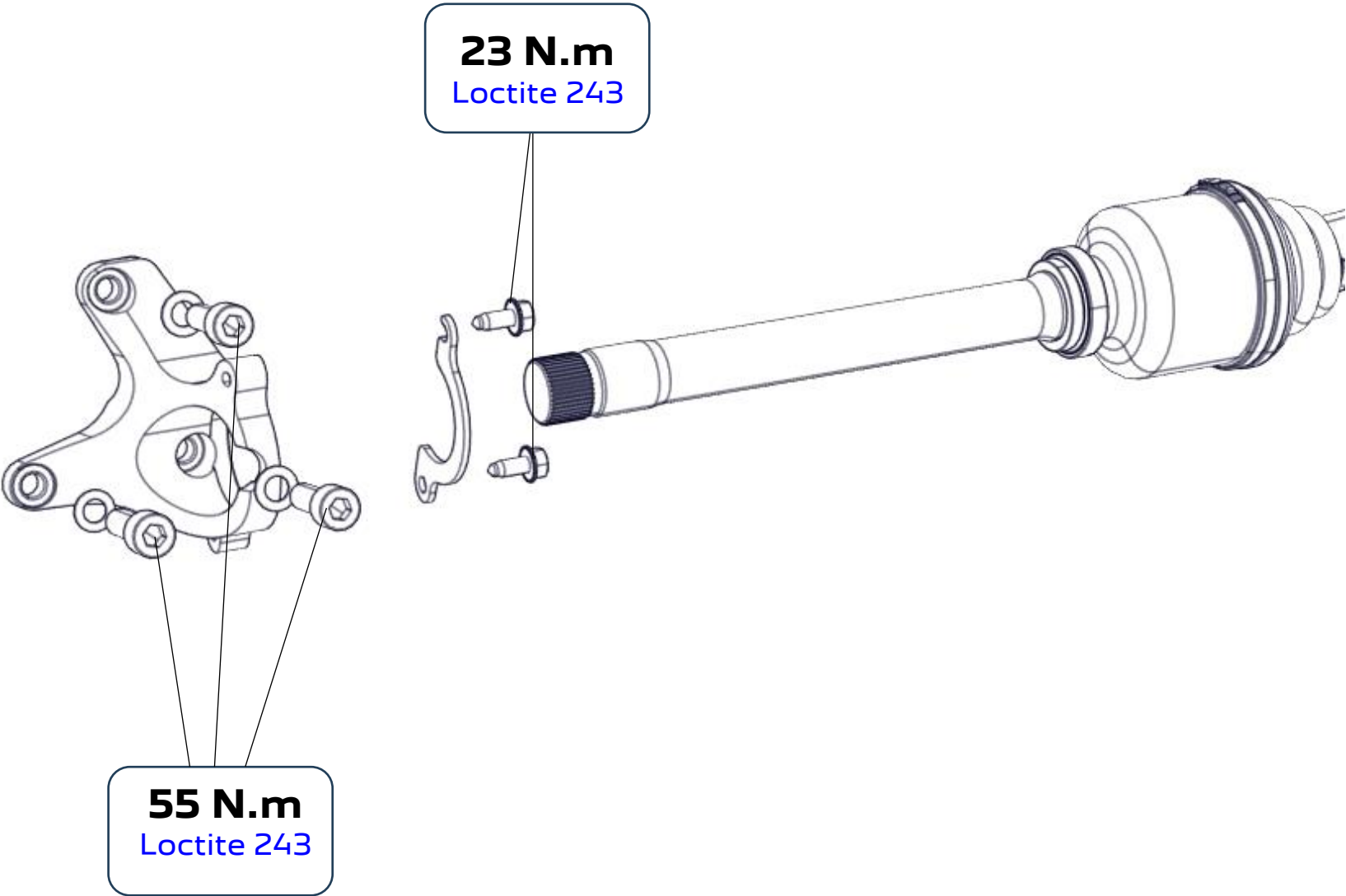
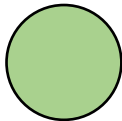
E41 STEERING RACK



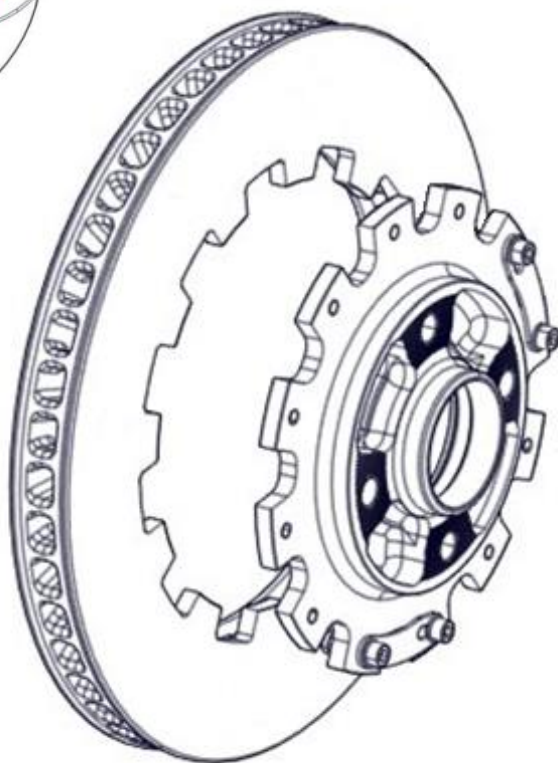
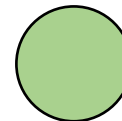
E44 TRACK ROD





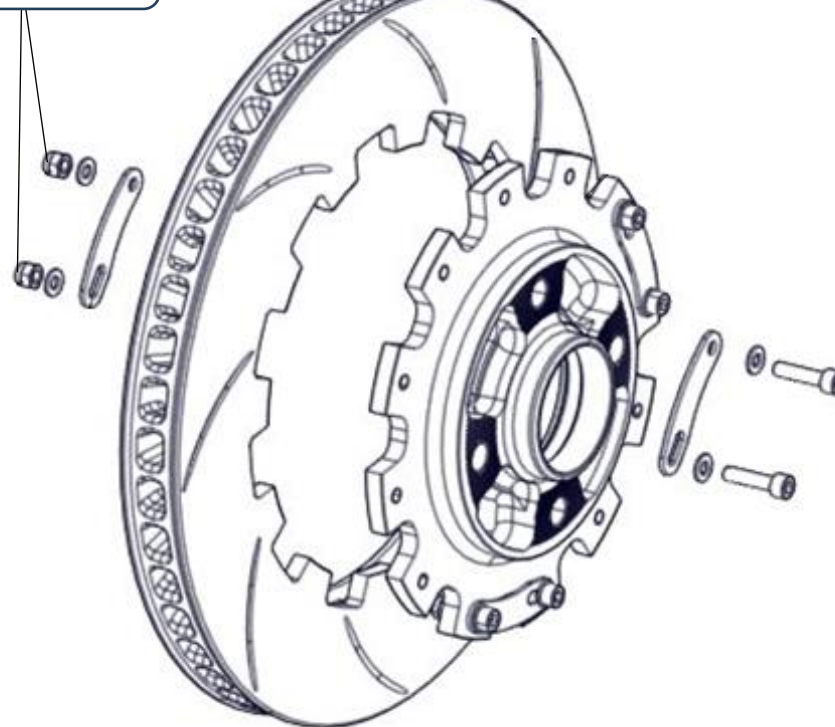


F11 FRONT BRAKE DISCS



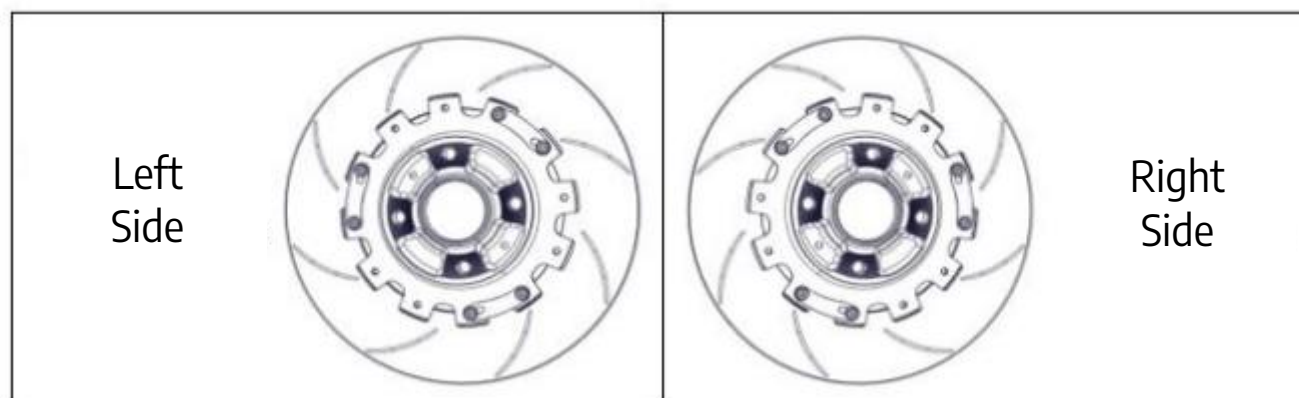
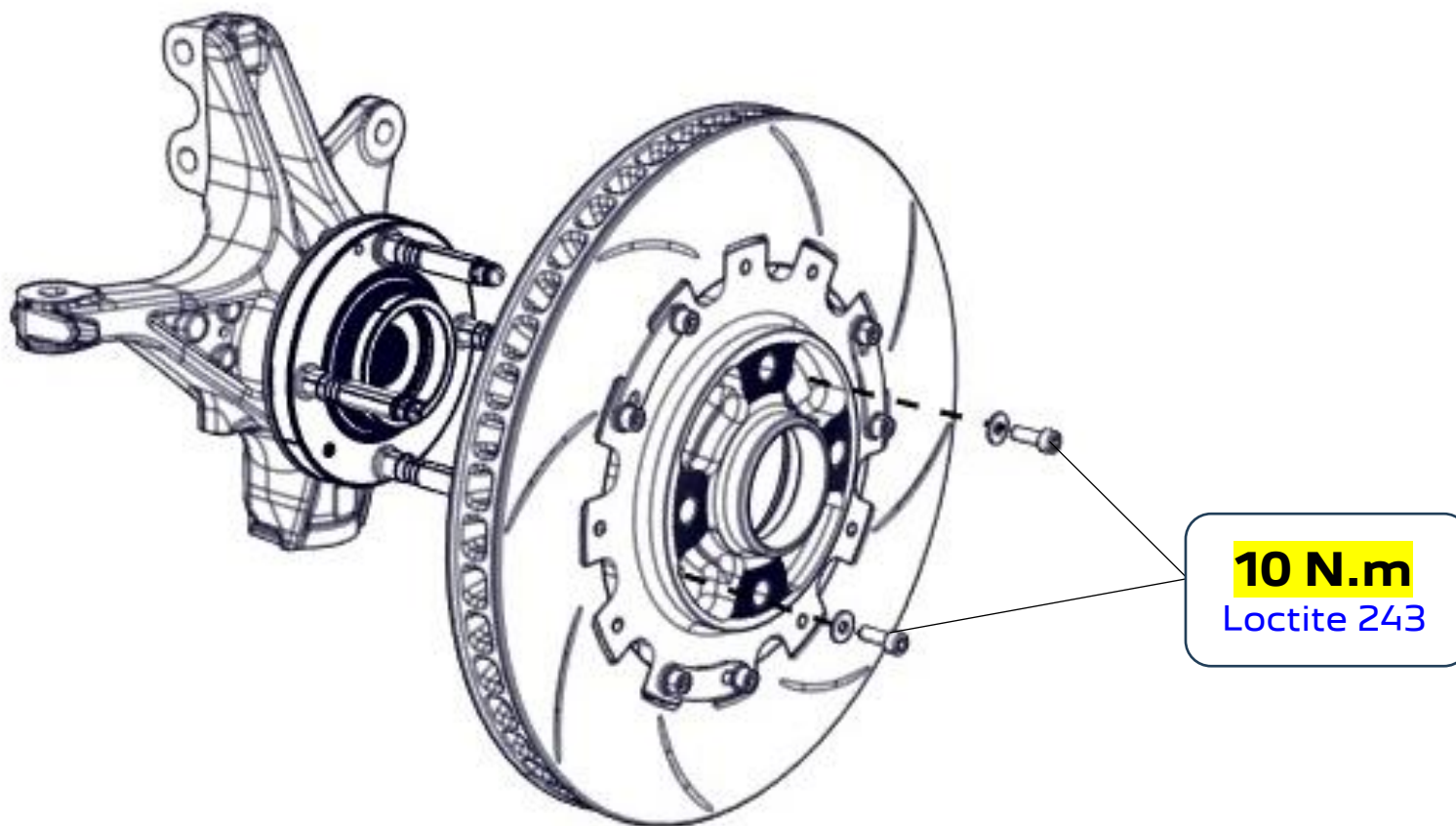
Gravel spec

15 N.m

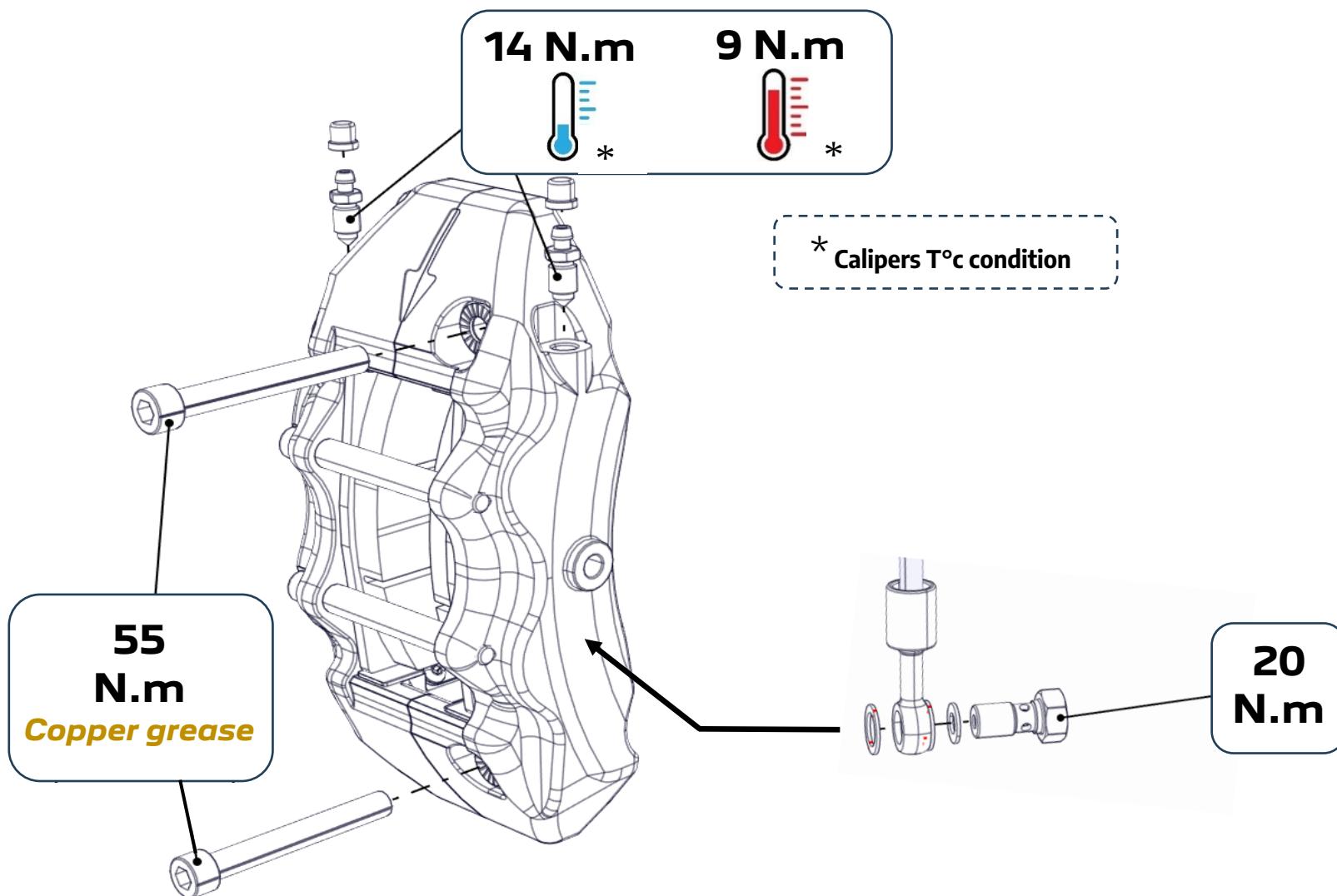
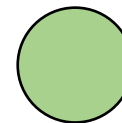


Tarmac spec

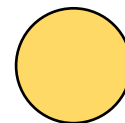


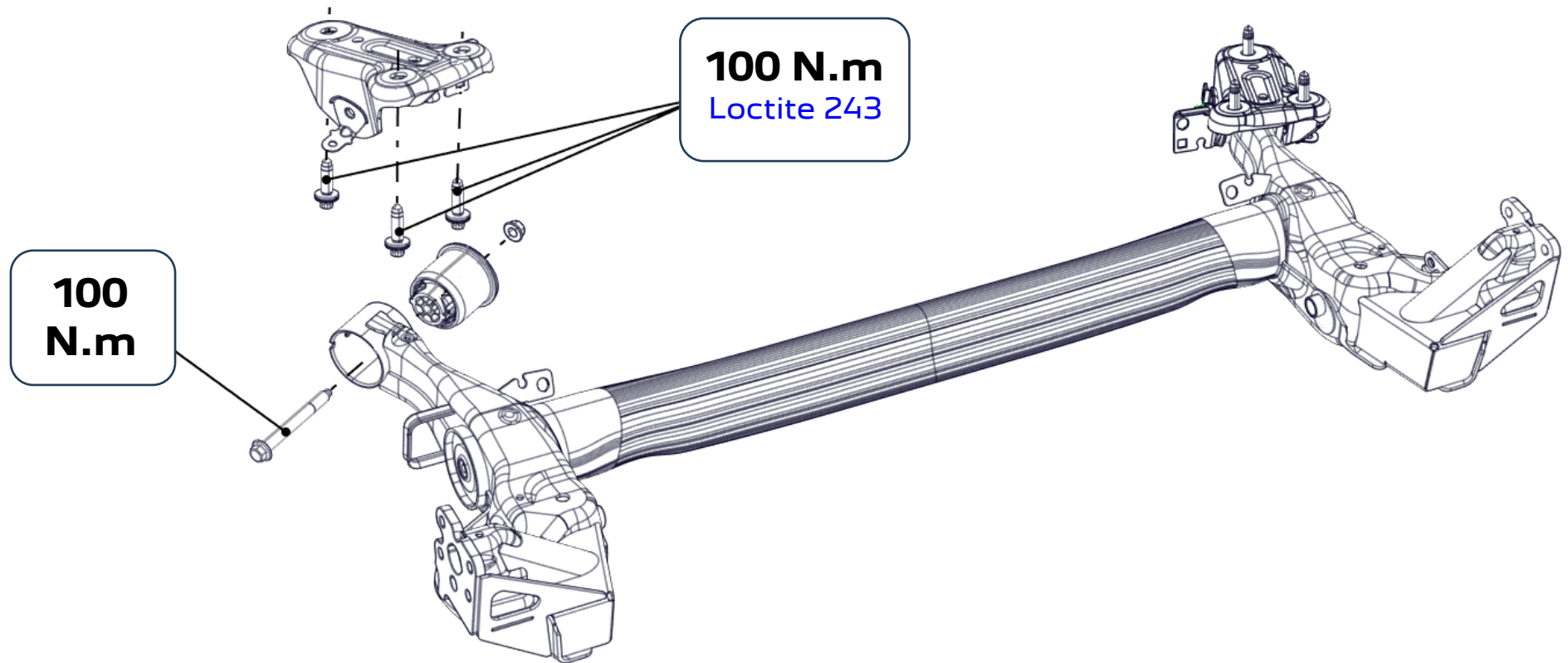
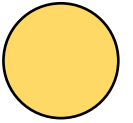


F21 FRONT BRAKE CALIPER

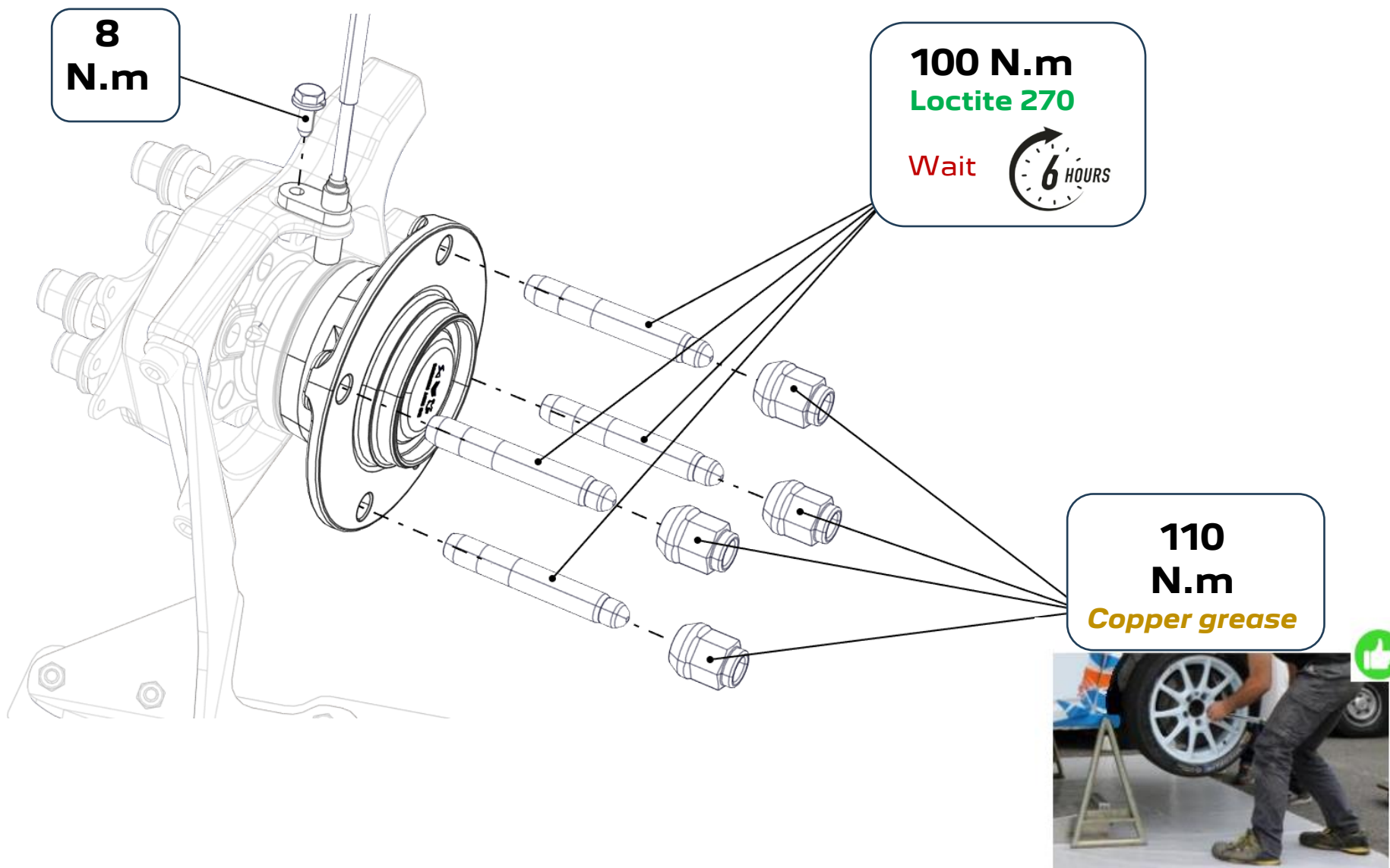
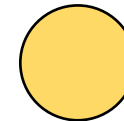


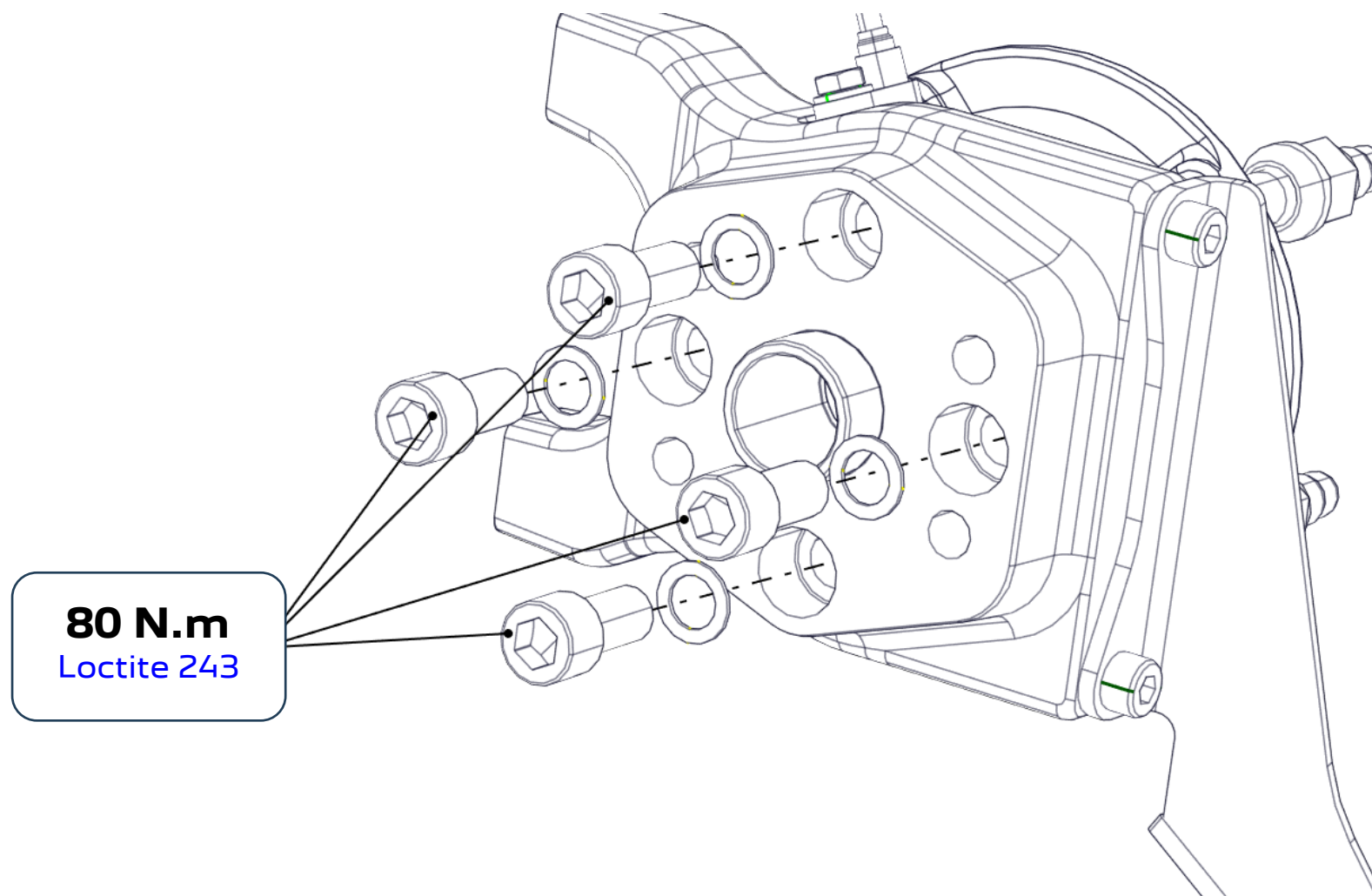
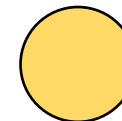
REAR AXLE

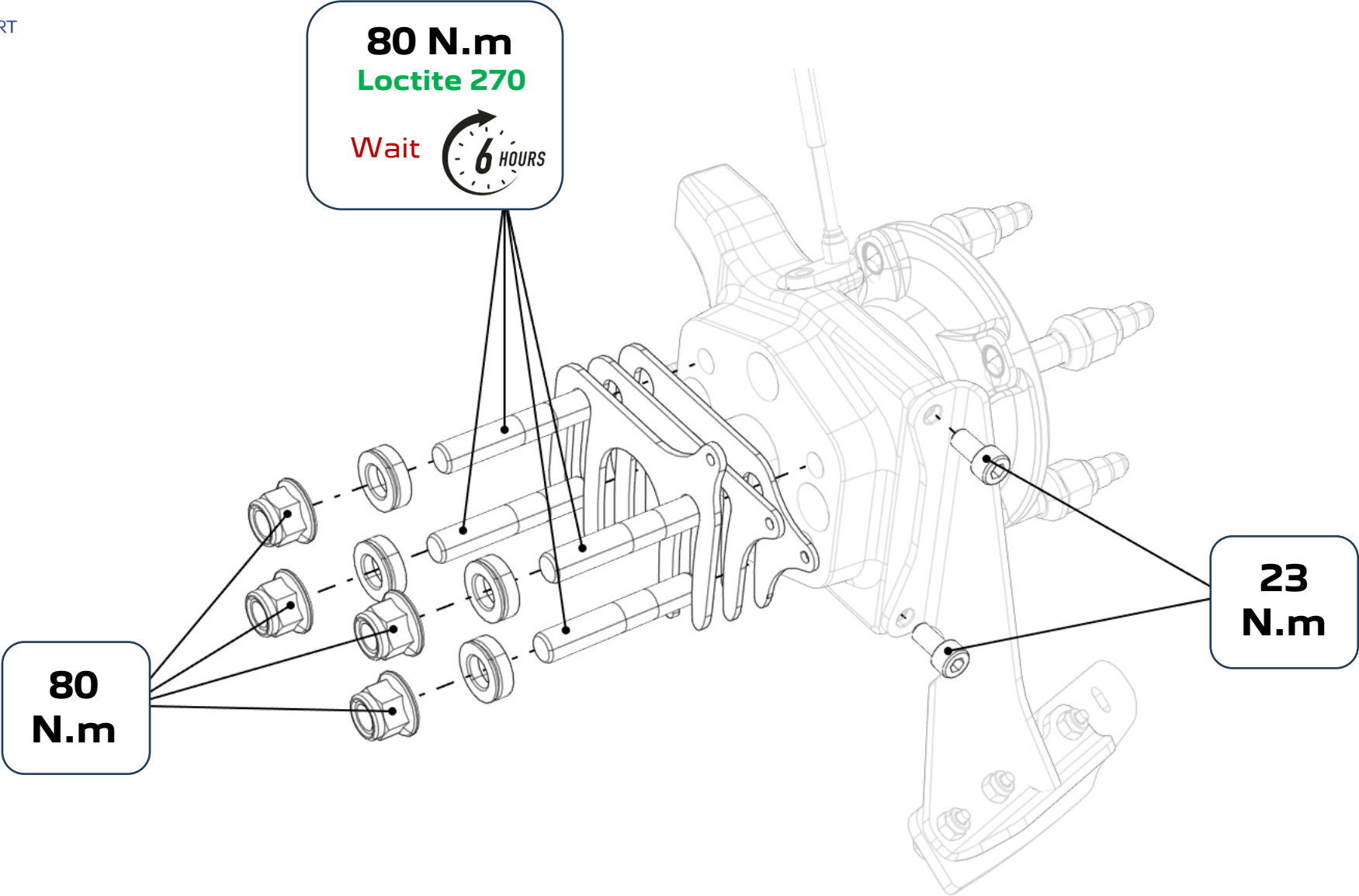
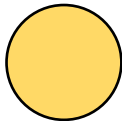




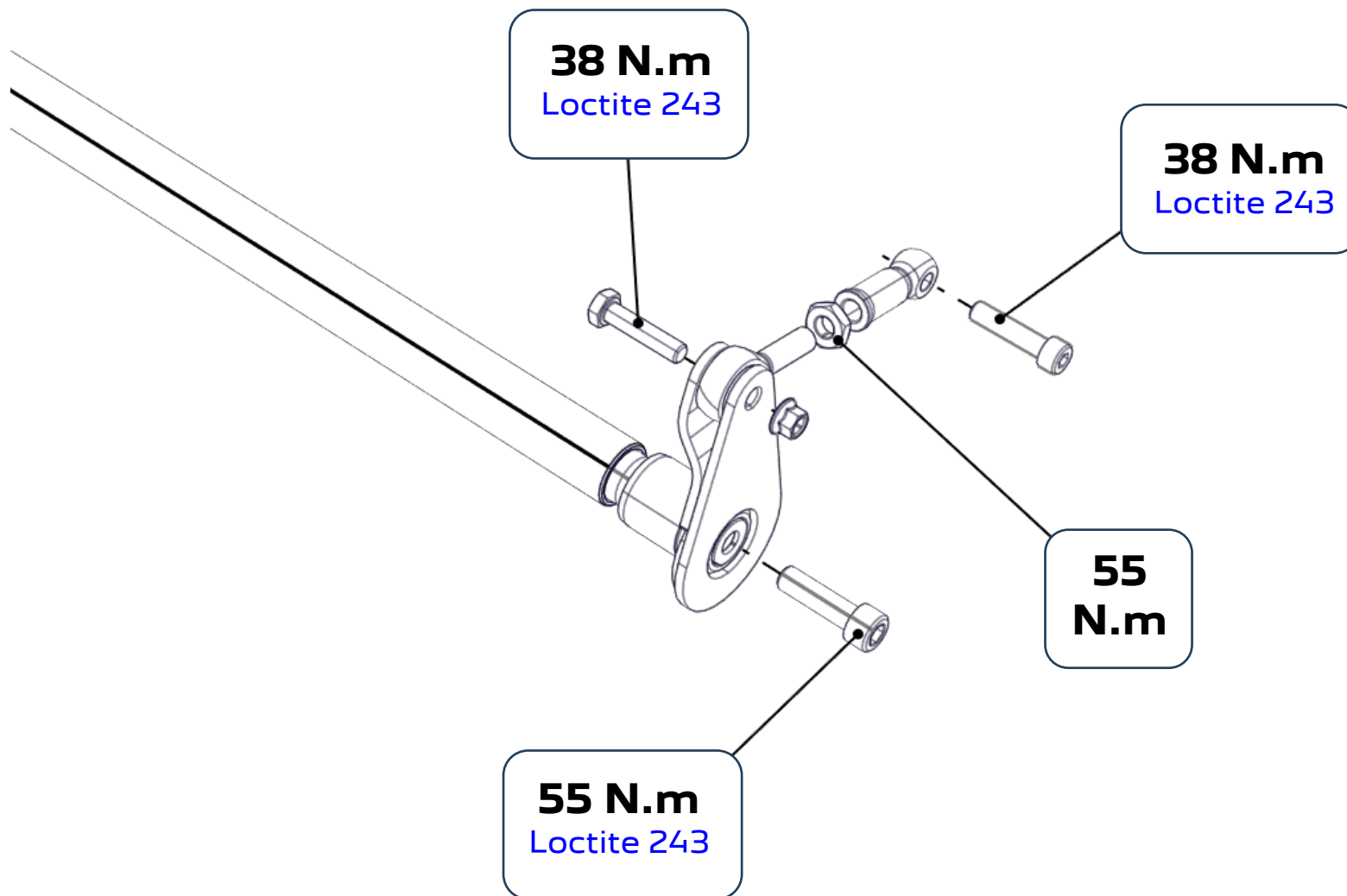
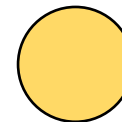
E24 REAR HUB CARRIER



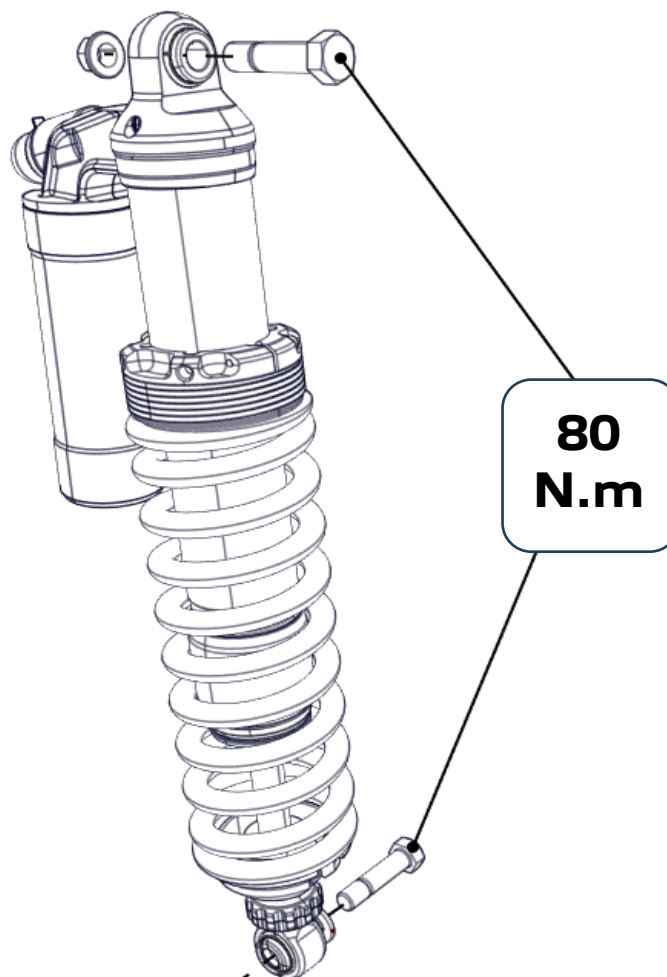
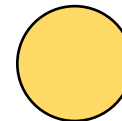




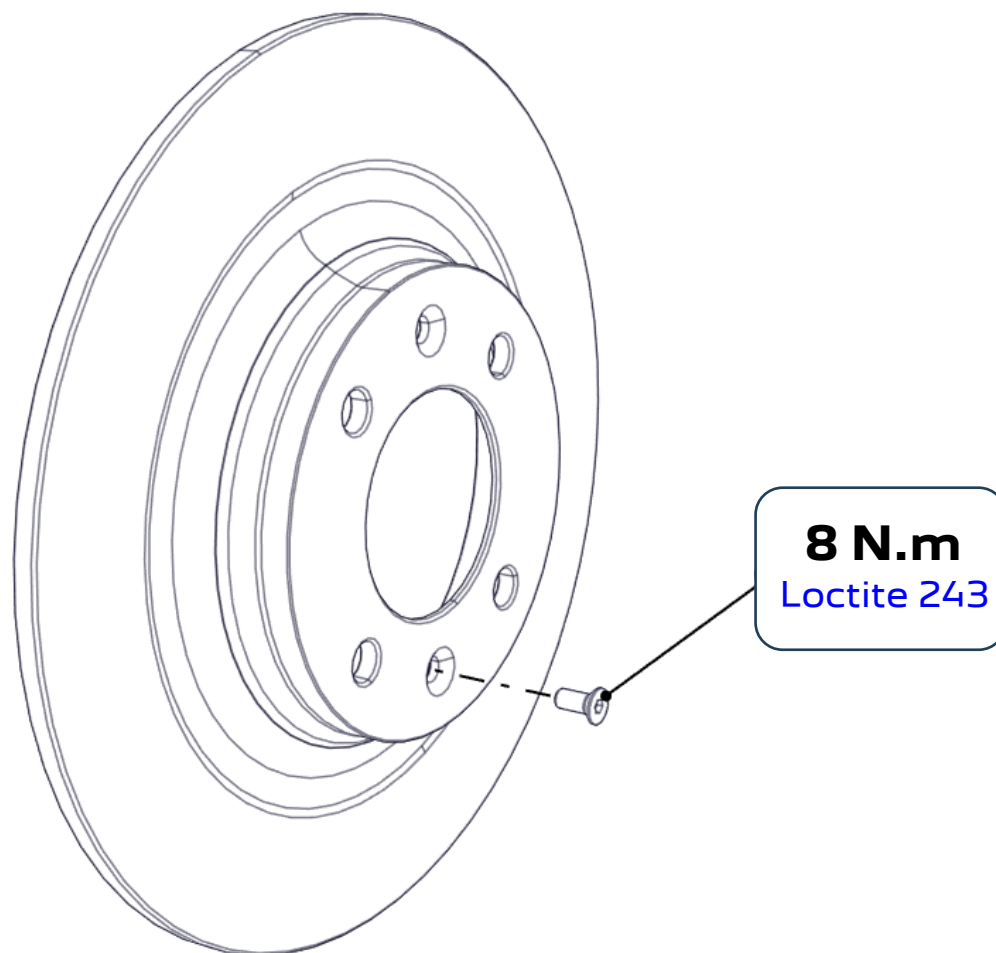
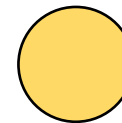
E26 REAR ANTI-ROLL BAR



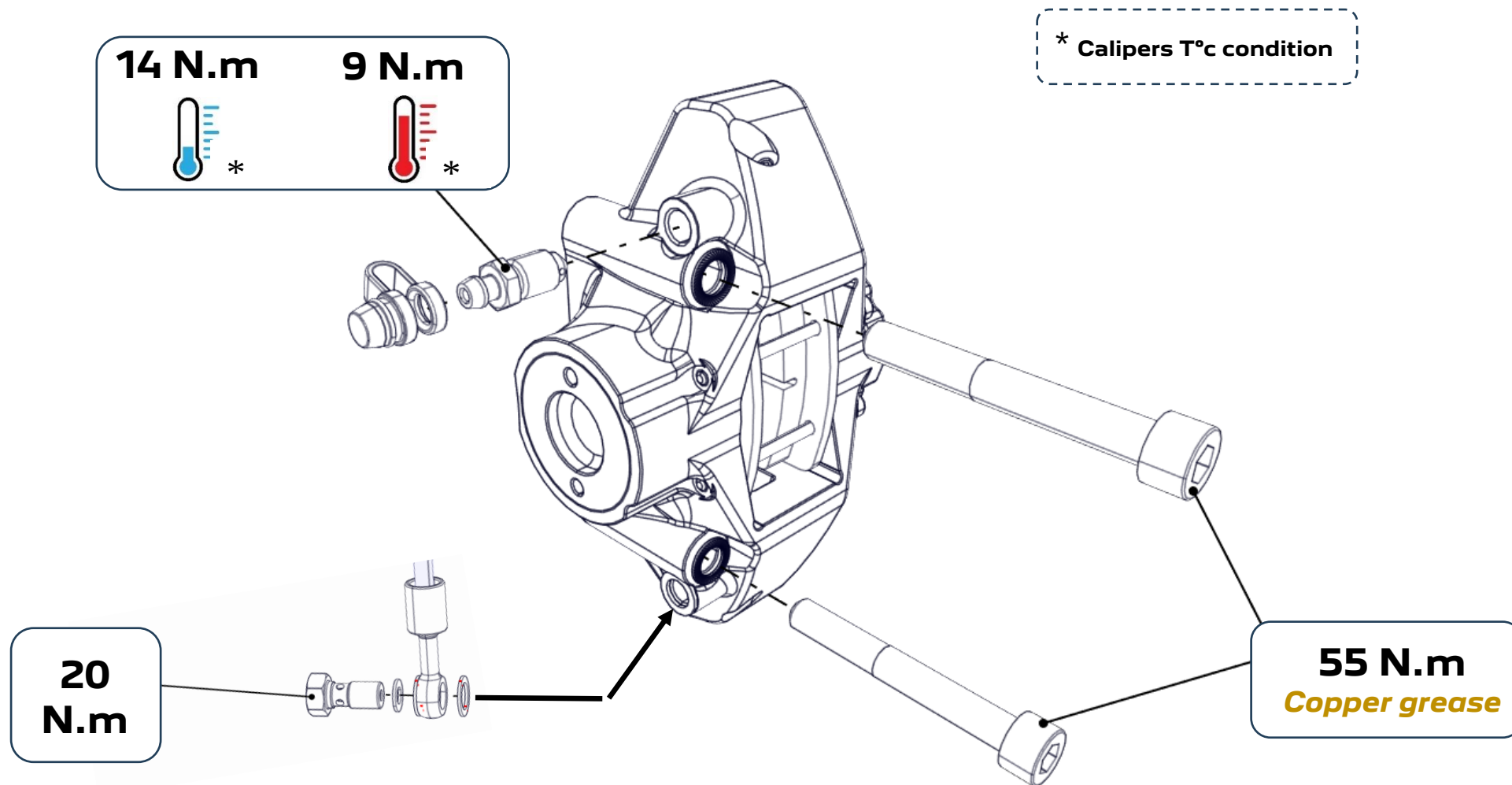
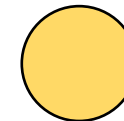
E25 *REAR SUSPENSION*



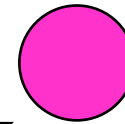
F31 REAR BRAKE DISCS

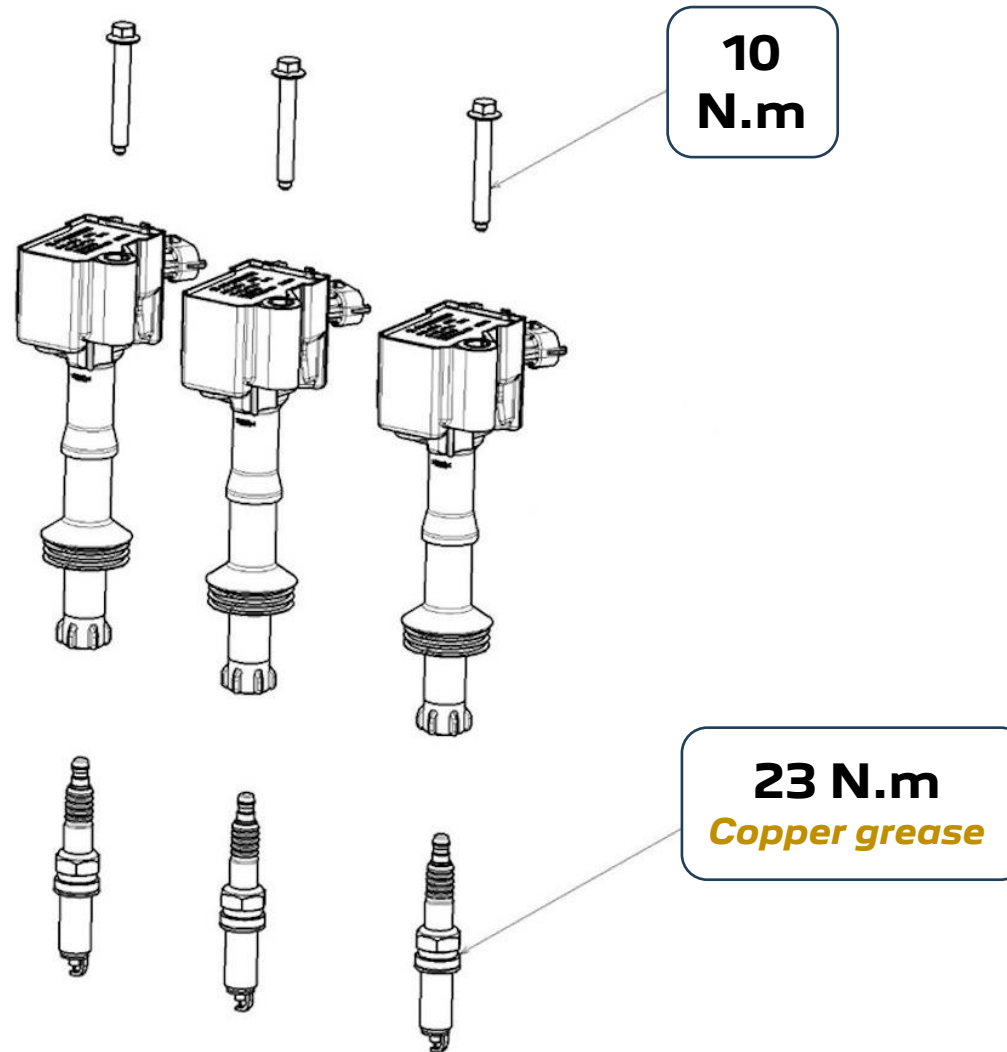
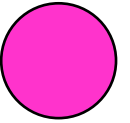


F41 REAR BRAKE CALIPER

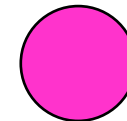


ENGINE BAY

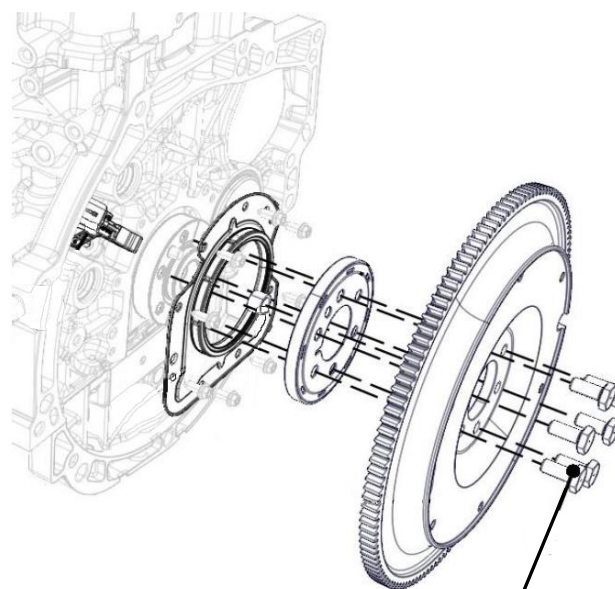
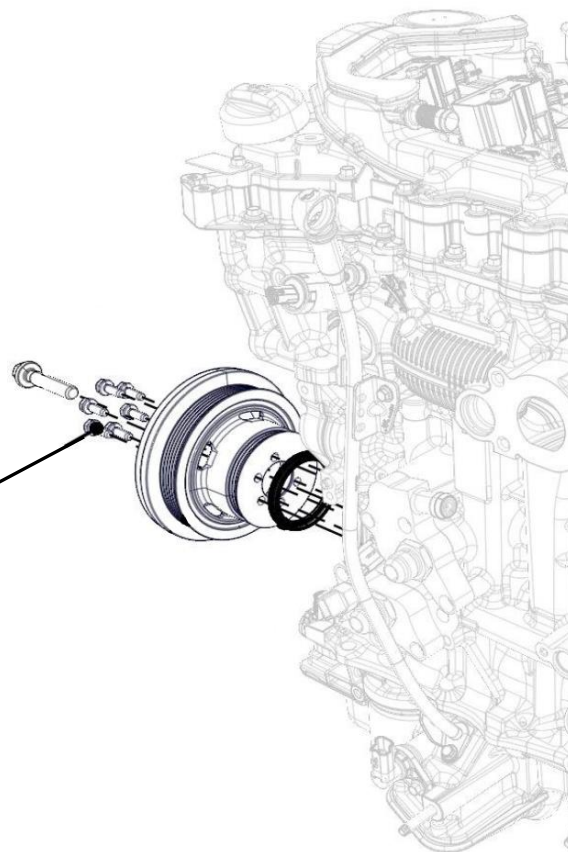




A12 MOBILE HITCH

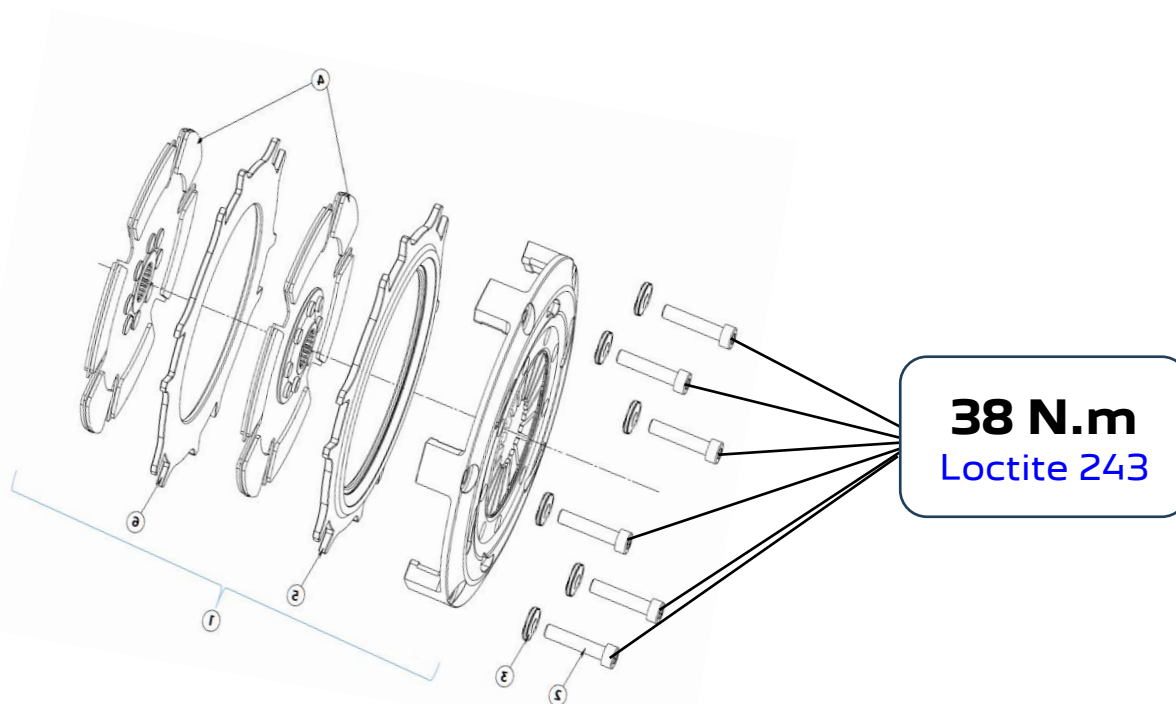
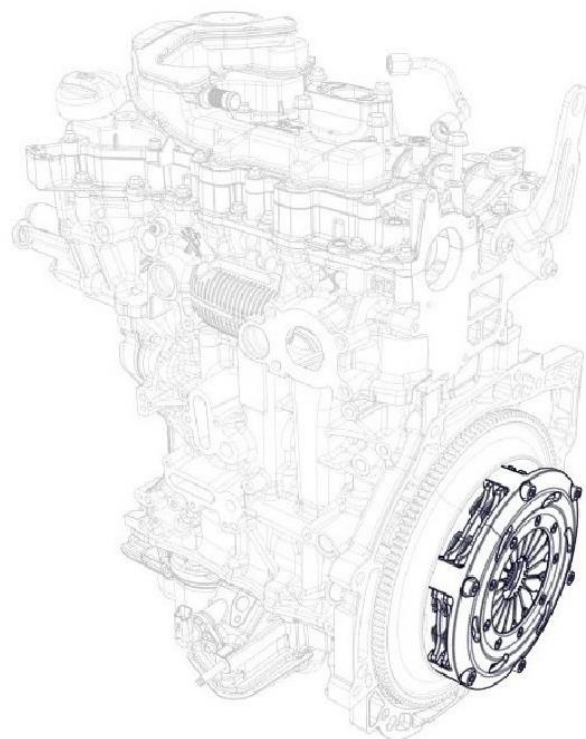
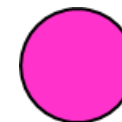


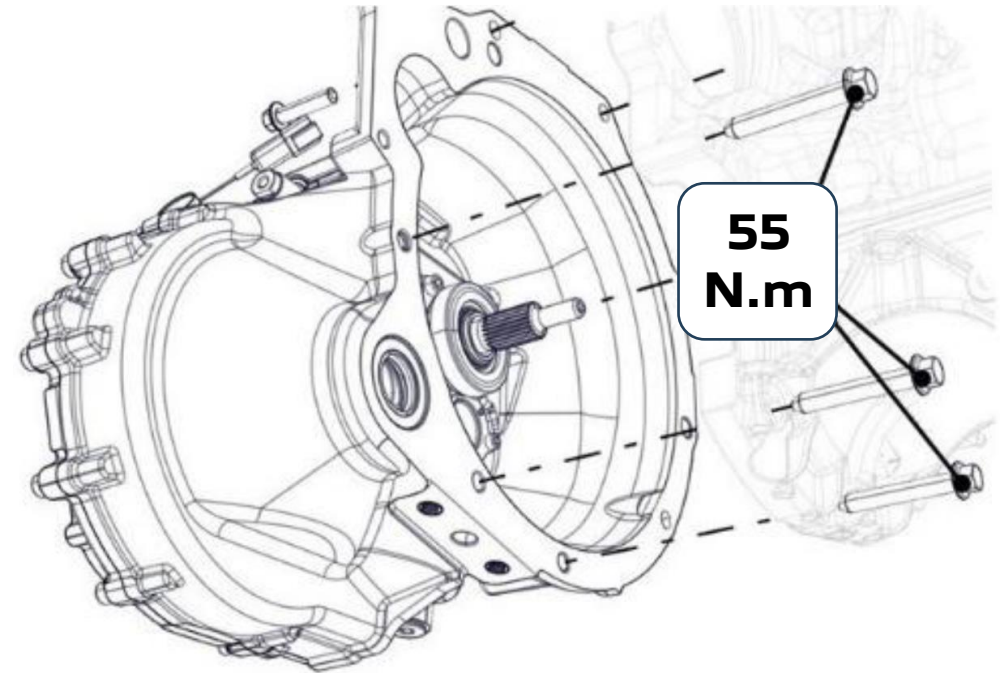
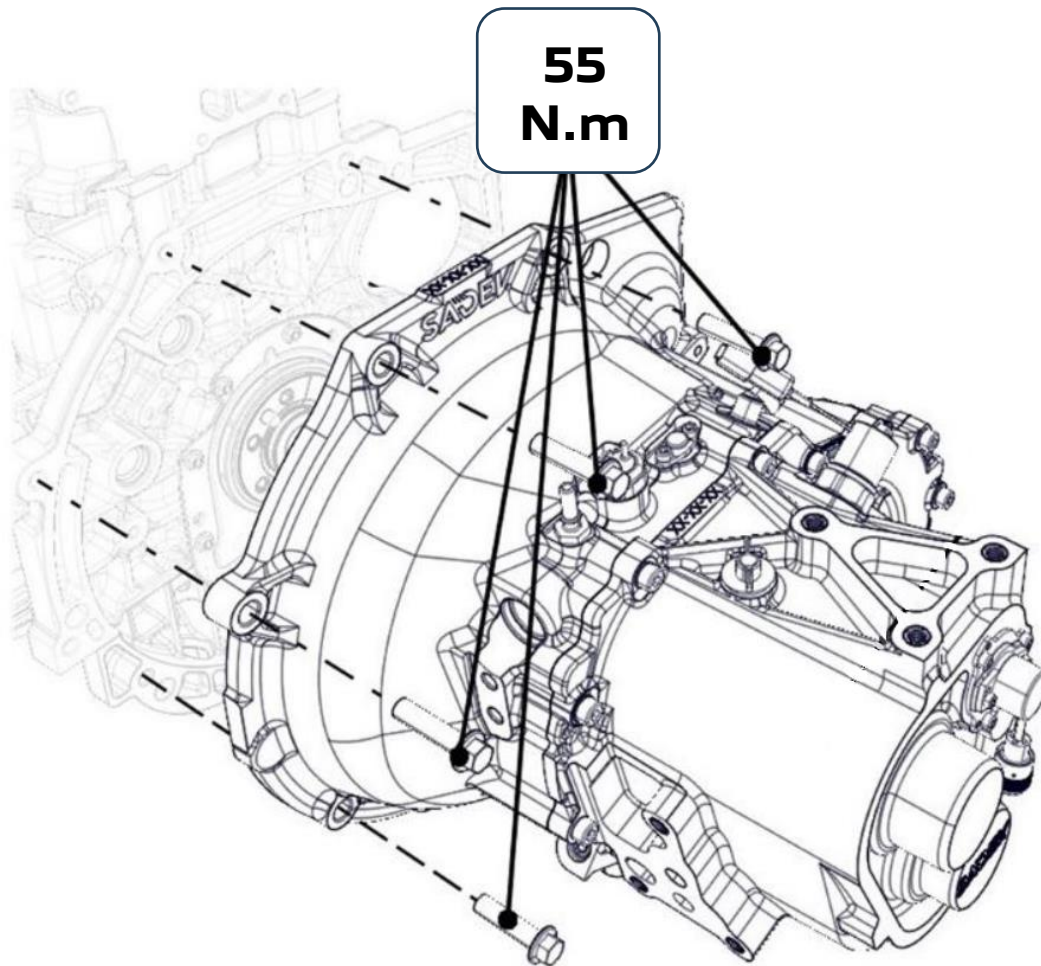
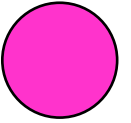
**25 N.m
+ 45°**
Loctite 243



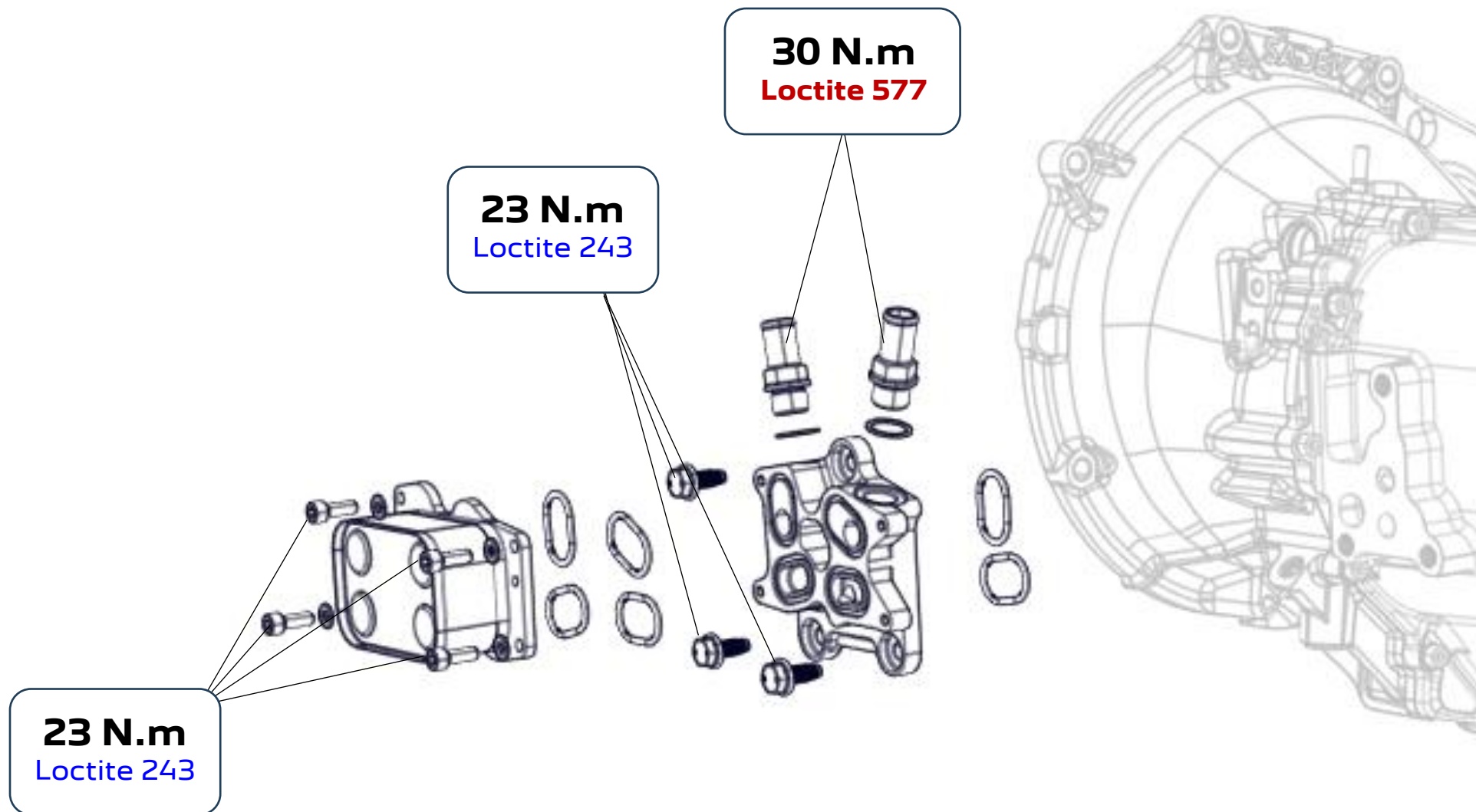
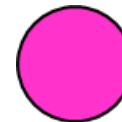
30 N.m + 90°
Single use screws

C11 CLUTCH

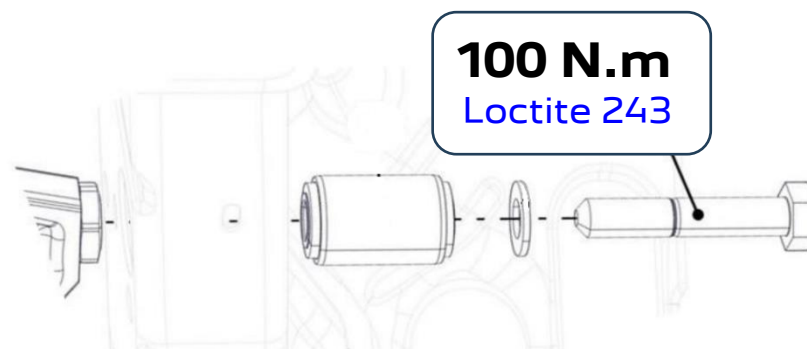
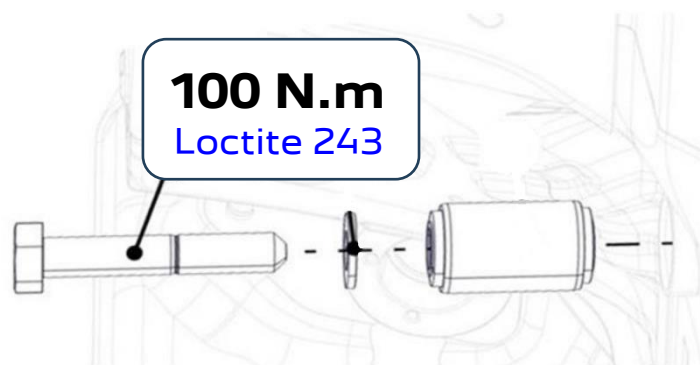
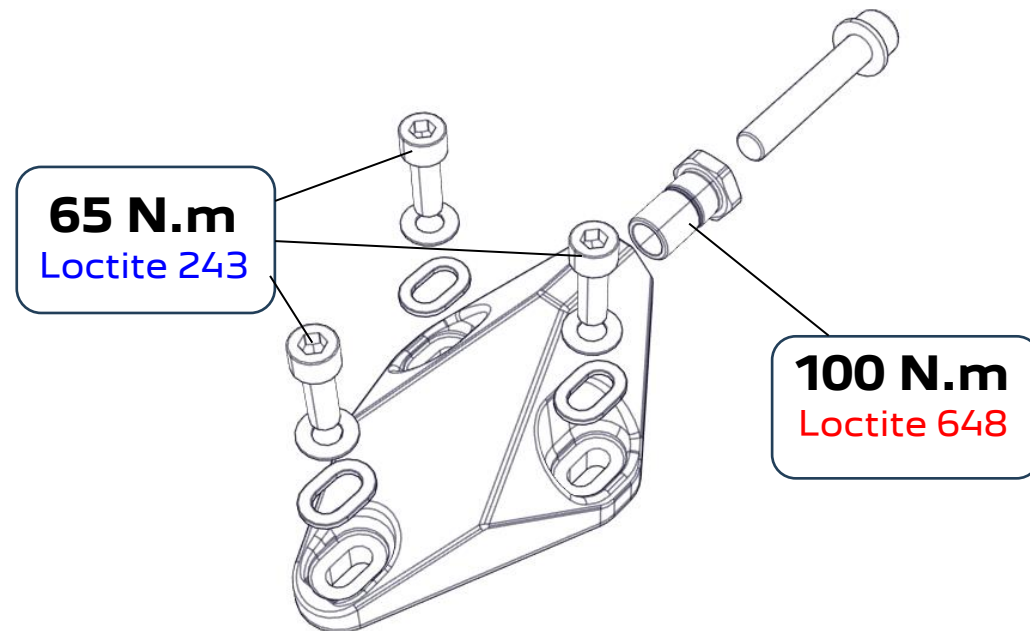
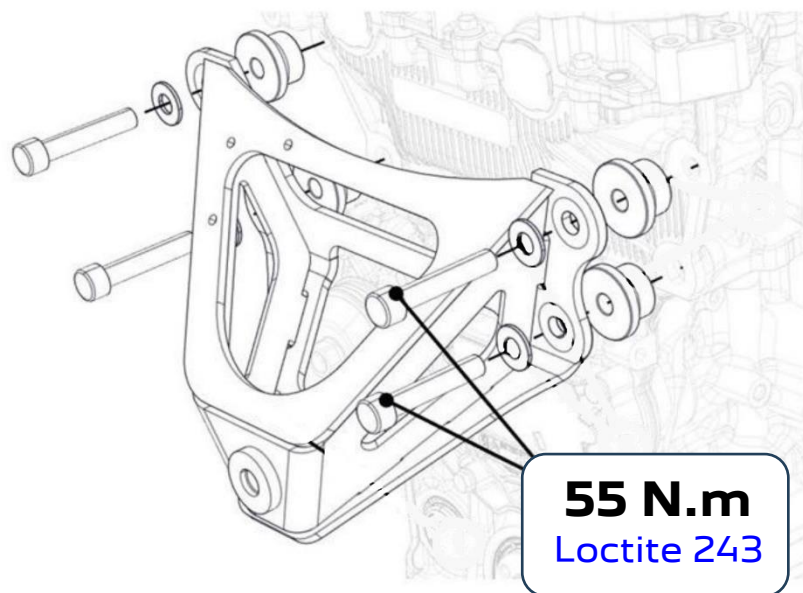
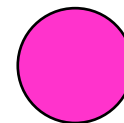




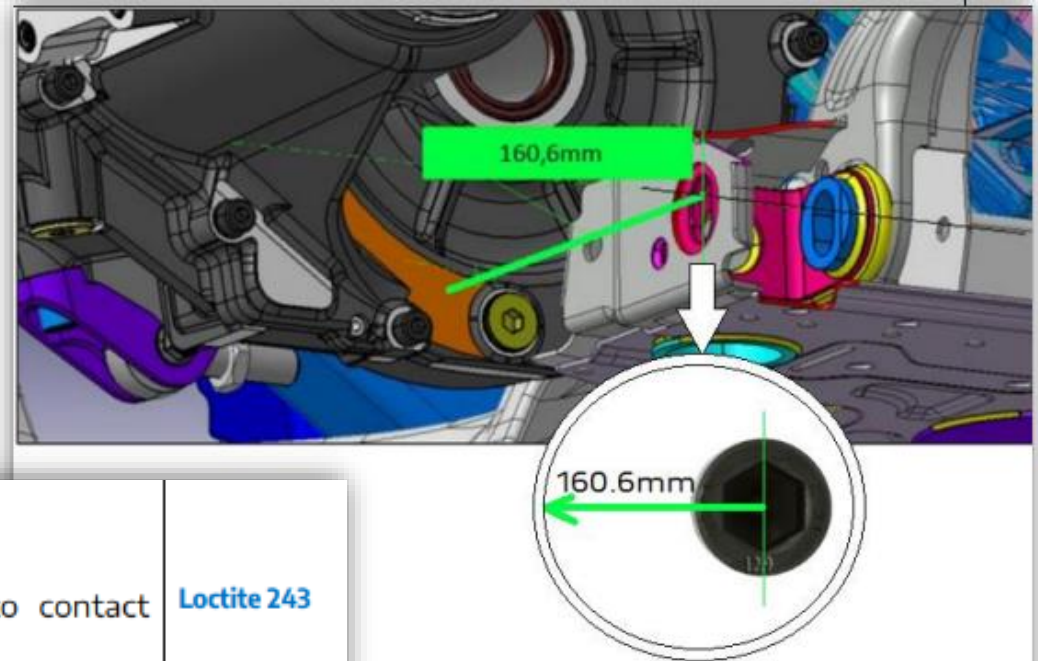
C80 GEARBOX HEAT EXCHANGER



D11 ENGINE & GEARBOX MOUNTS



POWERTRAIN CENTERING



Steps to follow :

- 1- Assemble the GB support and approach the 3x screws to contact without tightening.
- 2- Approach the longitudinal beam's screw on gearbox side
- 3- Approach the longitudinal beam's screw on engine side
- 4- Torque tighten the longitudinal beam's screw on gearbox side
- 5- **Adjust the powertrain position** to the dimension then:
 - Torque tighten the 3x GB support screws
 - Torque tighten the right side screw (Engine)
- 6- Connect the anti-torque link to the GB, tighten to torque

Loctite 243

Loctite 243

Loctite 243

100N.m

65N.m
100N.m

75N.m

