

TIGHTENING TORQUES

Designation		Loctite	Torque N.m	Assembly Specifications	
FRONT AXLE	SUB-FRA	SUBFRAME / BODY SHELL	243	100	FRONT SCREW ORIGINAL (95mm) AND REAR REVISED (45mm)
		FRONT WISHBONE / SUBFRAME		100	
	UPRIGHT	COMPRESSION STRUT / FRONT WISHBONE		100	
		STEERING BRACKET / UPRIGHT	243	15	SCREW M6x16
		STEERING BRACKET / UPRIGHT		60	NEW NUT M12 AFTER EVERY DISASSEMBLY
		WISHBONE CONNECTION EXTENSION / UPRIGHT	270	200	
		UPRIGHT / FRONT WISHBONE		100	
		NUT OF DRIVESHAFT		300	
		WHEEL STUD / UPRIGHT	270	100	
		WHEEL NUT		110	GREASE ON WHEEL STUD
		STUD / STEERING RACK	270	80	STUD 14x200
		STEERING ROD / STEERING RACK	243	55	
	STEERING	STEERING RACK / SUBFRAME		150	NEW NUT AFTER EVERY DISASSEMBLY
		STEERING COLUMN / STEERING RACK		20	
STEERING ROD / UPRIGHT		243	55	6 WASHERS BY SIDE	
ANTI-ROLL BAR / SUBFRAME		243	55		
ARB	ANTI-ROLL BAR / ARB ROD		38		
	ROD / FRONT WISHBONE	243	38		
REAR AXLE	CROSS MEMBER	REAR AXLE BRACKET / BODY SHELL	243	100	TIGHTEN ON REBOUND POSITION
		REAR AXLE SUPPORT / CROSSMEMBER		100	
		STUD / SPINDEL	270	85	
		SPINDEL / CROSS MEMBER		100	NEW NUT AFTER EVERY DISASSEMBLY
		SPINDEL / UPRIGHT		300	GREASE ON THE CONTACT SURFACE
		WHEEL STUD / HUB	270	100	
		WHEEL NUT		110	GREASE ON WHEEL STUD
		ANTI-ROLL BAR / SUBFRAME	243	45	
		ANTI-ROLL BAR / ARB ROD		32	
		ARB ROD / REAR AXLE	243	32	
SHOCK ABSORBERS	FR	DAMPER / STRUT	243	15	SCREW 6 X 100 L 25
		DAMPER / C POINT		55	
	CAMBER BRACKET / STRUT	243	32		
	UPRIGHT / STRUT		80	GREASE	
RR	DAMPER / BODY SHELL		80		
	DAMPER / REAR AXLE		80		
BRAKES	FR	STRUT / UPRIGHT		100	TIGHTEN WITH NEW SCREW AND CALIPER IN PLACE
		CALIPER / SUPPORT		55	BRAKE DURING THE TIGHTENING
		DISC BELL / DISC		15	
	DISC BELL / UPRIGHT		5	GREASE	
	RR	CALIPER / SUPPORT		55	BRAKE DURING THE TIGHTENING
DISC / HUB		5	GREASE		
FRONT BLOCK	RADIO	CROSS MEMBER RADIATOR / BODY SHELL	243	55	
		CROSS MEMBER TOP / BODY SHELL	243	22	
		RADIATOR MOUNTING / BODY SHELL	243	22	
	MOUNTING	ENGINE MOUNTING / ENGINE	243	55	
		GEAR BOX MOUNTING / GB (M10)	270	65	SCREW CHC 10x35 c12.9 + WASHER TH=3mm
		GEAR BOX MOUNTING / GB (M8)	270	35	SCREW CHC 8x35 c10.9 + WASHER TH=3mm
		INSERT / GEAR BOX MOUNTING	648	100	
		MOUNTINGS / BODY SHELL	243	100	
		ANTI-TORQUE ROD / ENGINE		100	
	ACCESSORIES	ANTI-TORQUE ROD / SUBFRAME	243	100	
		STEERING PUMP MOUNTING / ENGINE	243	22	
		STEERING PUMP / PUMP MOUNTING	243	22	
		ALTERNATOR / ENGINE	243	22	
		STARTER / GEAR BOX		22	
		SPARK PLUG		23	COPPER GREASE ON THREAD
		PULLEY / WATER PUMP	243	10	
		ACCESSORY BELT BEARING	243	45	TENSION 50 SEEM
		WATER PUMP BELT BEARING	243	10	TENSION 80 HERTZ
GBOX	ENGINE FLYWHEEL / ENGINE	270	30 + 75*	SCREW PN: 0A1226185B + GREASE UNDER THE SCREW HEADS	
	REVERSE SOLENOID COVER	270	20	+ PIPE CLAMP	
	GEAR BOX / ENGINE	243	55		
COCKPIT	SEAT	CLUTCH BEARING	243	22	
		CLUTCH / FLYWHEEL	243	38	
	SEAT MOUNTING / BODY SHELL	243	22		
	SEAT / SEAT MOUNTING	243	22		
	STEER.	STEERING RACK / STEERING SHAFT		20	
		STEER CLMN UPPER MOUNT / BODY SHELL	243	15	
STEER CLMN LOWER MOUNT / BODY SHELL	243	15			
STEERING WHEEL / COLUMN		35			