

INTRODUCTION

TIGHTENING TORQUE

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

NOTE: When possible, always apply torque in the same direction.

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.

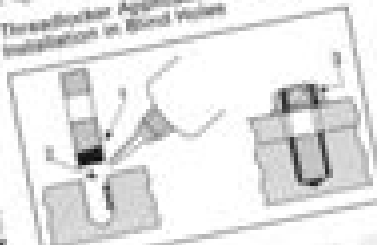
Fastener Size	Torque	
	Hex Head	Hex Nut
M4	1.5 - 2.0 Nm (1.5 - 2.0 lbf-in)	1.5 - 2.0 Nm (1.5 - 2.0 lbf-in)
M5	2.0 - 2.5 Nm (2.0 - 2.5 lbf-in)	2.0 - 2.5 Nm (2.0 - 2.5 lbf-in)
M6	2.5 - 3.0 Nm (2.5 - 3.0 lbf-in)	2.5 - 3.0 Nm (2.5 - 3.0 lbf-in)
M8	3.0 - 4.0 Nm (3.0 - 4.0 lbf-in)	3.0 - 4.0 Nm (3.0 - 4.0 lbf-in)
M10	4.0 - 5.0 Nm (4.0 - 5.0 lbf-in)	4.0 - 5.0 Nm (4.0 - 5.0 lbf-in)
M12	5.0 - 6.0 Nm (5.0 - 6.0 lbf-in)	5.0 - 6.0 Nm (5.0 - 6.0 lbf-in)
M14	6.0 - 7.0 Nm (6.0 - 7.0 lbf-in)	6.0 - 7.0 Nm (6.0 - 7.0 lbf-in)

Fastener Size	Torque	
	Hex Head	Hex Nut
M4	1.5 - 2.0 Nm (1.5 - 2.0 lbf-in)	1.5 - 2.0 Nm (1.5 - 2.0 lbf-in)
M5	2.0 - 2.5 Nm (2.0 - 2.5 lbf-in)	2.0 - 2.5 Nm (2.0 - 2.5 lbf-in)
M6	2.5 - 3.0 Nm (2.5 - 3.0 lbf-in)	2.5 - 3.0 Nm (2.5 - 3.0 lbf-in)
M8	3.0 - 4.0 Nm (3.0 - 4.0 lbf-in)	3.0 - 4.0 Nm (3.0 - 4.0 lbf-in)
M10	4.0 - 5.0 Nm (4.0 - 5.0 lbf-in)	4.0 - 5.0 Nm (4.0 - 5.0 lbf-in)
M12	5.0 - 6.0 Nm (5.0 - 6.0 lbf-in)	5.0 - 6.0 Nm (5.0 - 6.0 lbf-in)
M14	6.0 - 7.0 Nm (6.0 - 7.0 lbf-in)	6.0 - 7.0 Nm (6.0 - 7.0 lbf-in)

INTRODUCTION

1. Apply several drops along the threaded hole and at the bottom of the hole.
2. Apply several drops on both threads.
3. Tighten as required.

Threadlocker Application for Stud Installation in Blind Holes

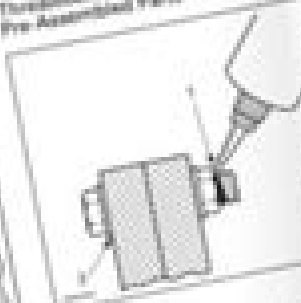


1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE Hysse (medium strength) Loctite on threads and allow to dry.
3. Put 2 or 3 drops of proper strength Loctite on threads (on female threads and a hole).

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

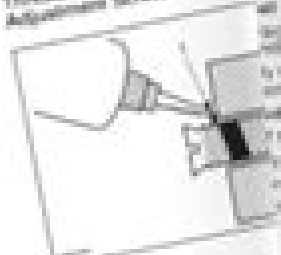
4. Apply several drops of proper strength Loctite on stud threads.
5. Install stud.
6. Install cover part, etc.
7. Apply a few drops of proper strength Loctite on cover stud threads.
8. Install and tighten retaining nut(s) as required.

Threadlocker Application for Pre-Assembled Parts



1. Clean both part and hole with solvent.
2. Assemble components.
3. Tighten nut.
4. Apply a few drops of proper strength Loctite on threads and allow to dry.
5. Apply Loctite Hysse (medium strength) Loctite on threads.

Threadlocker Application for Adjustment Screw



1. Adjust screw to proper value.
2. Apply a few drops of proper strength Loctite on threads.
3. Avoid touching metal with a finger.

If it is difficult to tighten, heat screws with heating coil (220°C (420°F)).

Threadlocker Application for Stripped Thread Repair



1. Clean both part and hole with solvent.
2. Assemble components.
3. Tighten nut.
4. Apply a few drops of proper strength Loctite on threads and allow to dry.
5. Apply Loctite Hysse (medium strength) Loctite on threads.

Thread Repair:
Loctite Hysse (medium strength) Loctite on threads and allow to dry.

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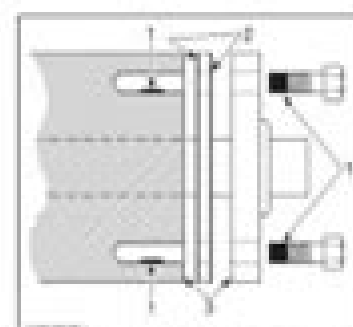
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INTRODUCTION

Gasket Compound Application



1. Clean both mating surfaces with solvent.
2. Apply Loctite Hysse (medium strength) Loctite on threads and allow to dry.
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On Linerepair Manual Atv

Scott C. Dulebohn



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