

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.

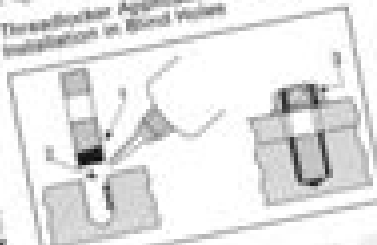
Fastener Size	ASTM A307	
	Grade 2	Grade 5
1/4"	11.0 - 17.0 Nm (8.0 - 12.5 lbf-ft)	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)
5/16"	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)
3/8"	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)	40.0 - 60.0 Nm (30.0 - 45.0 lbf-ft)
1/2"	40.0 - 60.0 Nm (30.0 - 45.0 lbf-ft)	60.0 - 90.0 Nm (45.0 - 65.0 lbf-ft)
5/8"	60.0 - 90.0 Nm (45.0 - 65.0 lbf-ft)	90.0 - 135.0 Nm (65.0 - 100.0 lbf-ft)
3/4"	90.0 - 135.0 Nm (65.0 - 100.0 lbf-ft)	135.0 - 200.0 Nm (100.0 - 150.0 lbf-ft)
1 1/4"	135.0 - 200.0 Nm (100.0 - 150.0 lbf-ft)	200.0 - 300.0 Nm (150.0 - 225.0 lbf-ft)

Fastener Size	ASTM A307	
	Grade 2	Grade 5
1/4"	11.0 - 17.0 Nm (8.0 - 12.5 lbf-ft)	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)
5/16"	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)
3/8"	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)	40.0 - 60.0 Nm (30.0 - 45.0 lbf-ft)
1/2"	40.0 - 60.0 Nm (30.0 - 45.0 lbf-ft)	60.0 - 90.0 Nm (45.0 - 65.0 lbf-ft)
5/8"	60.0 - 90.0 Nm (45.0 - 65.0 lbf-ft)	90.0 - 135.0 Nm (65.0 - 100.0 lbf-ft)
3/4"	90.0 - 135.0 Nm (65.0 - 100.0 lbf-ft)	135.0 - 200.0 Nm (100.0 - 150.0 lbf-ft)
1 1/4"	135.0 - 200.0 Nm (100.0 - 150.0 lbf-ft)	200.0 - 300.0 Nm (150.0 - 225.0 lbf-ft)

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



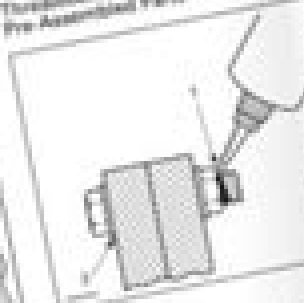
1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE Heavy (Grade 3) to the threads of the stud and the bottom of the hole.
3. Insert the stud and tighten to the required torque.

NOTE: For permanent installation, use Loctite Heavy (Grade 3) on both threads and a hole in the stud.

1. Apply several drops of proper strength Loctite on stud threads.
2. Insert stud.
3. Insert cover, etc.

1. Apply a few drops of proper strength Loctite on underside stud threads.
2. 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.

NOTE: For permanent installation, use Loctite Heavy (Grade 3) on both threads and a hole in the stud.

Threadlocker Application for Adjustment Screws



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

Loctite is difficult to remove. Heat screws with temperature 220°C (400°F).

Application for Stripped Thread Repair



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.

NOTE: For permanent installation, use Loctite Heavy (Grade 3) on both threads and a hole in the stud.

Thread Repair: Loctite Heavy (Grade 3) is used for thread repair. It is applied on mating surfaces. It is applied on mating surfaces. It is applied on mating surfaces.

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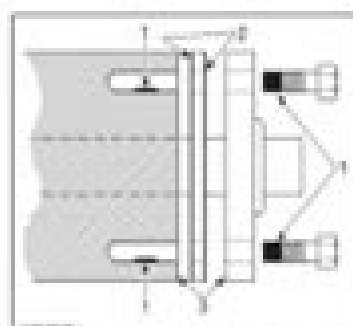
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Gasket Compound Application



1. Clean both mating surfaces with solvent.
2. Apply Loctite Primer II on both mating surfaces and on both sides of gasket and allow to dry 1 or 2 minutes.
3. Apply Loctite Primer II on both mating surfaces and on both sides of gasket and allow to dry 1 or 2 minutes.

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

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