

## INTRODUCTION

### TIGHTENING TORQUE

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

**Torque wrench tightening specifications:** 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 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.

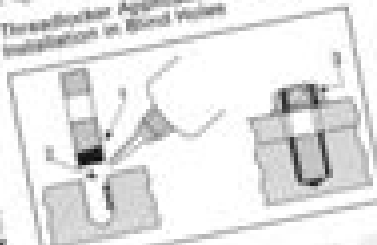
Fastener Size	ASTM A307	
	Grade 2	Grade 5
1/4"	11.0 - 17.0 Nm (8.0 - 12.5 lbf-ft)	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)
5/16"	17.0 - 27.0 Nm (12.5 - 20.0 lbf-ft)	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)
3/8"	27.0 - 40.0 Nm (20.0 - 30.0 lbf-ft)	40.0 - 60.0 Nm (30.0 - 45.0 lbf-ft)
1/2"	40.0 - 60.0 Nm (30.0 - 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"	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"	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

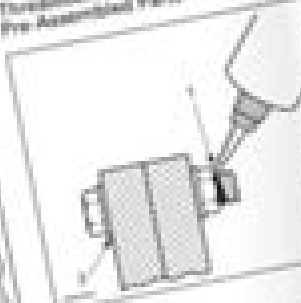


1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE Hysseal (Hysseal may not be used on threads and allow to dry).
3. Put 2 or 3 drops of proper strength Loctite Threadlocker on top of Hysseal and a hole.

**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 underside 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 nuts.
4. Apply a few drops of proper strength Loctite on both contact surfaces.
5. Avoid loading metal with full force.

**NOTE:** For permanent installation, use Loctite Hysseal (Hysseal may not be used on threads and allow to dry).

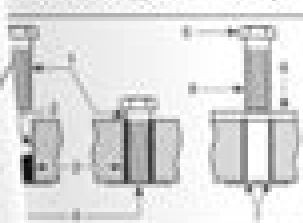
### Threadlocker Application for Adjustment Screws



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

If it is difficult to tighten, heat screws with heating coil (220°C (425°F)).

### Threadlocker 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.
5. Avoid loading metal with full force.

**NOTE:** For permanent installation, use Loctite Hysseal (Hysseal may not be used on threads and allow to dry).

**Thread Repair:** Loctite Hysseal (Hysseal may not be used on threads and allow to dry).

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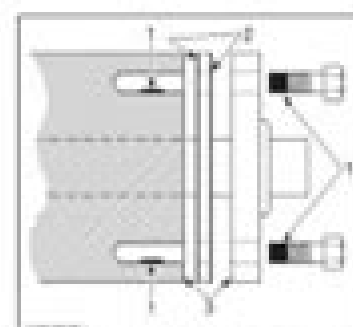
**Thread Repair:** Loctite Hysseal (Hysseal may not be used on threads and allow to dry).

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## INTRODUCTION

### Gasket Compound Application



1. Clean both mating surfaces with solvent.
2. Apply Loctite Hysseal (Hysseal may not be used on threads and allow to dry).
3. Tighten as required.

**NOTE:** For permanent installation, use Loctite Hysseal (Hysseal may not be used on threads and allow to dry).

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