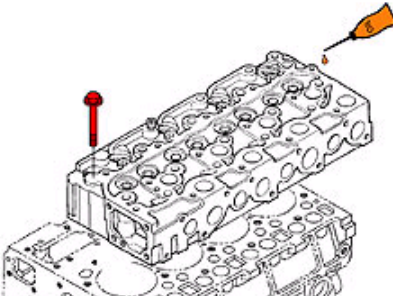
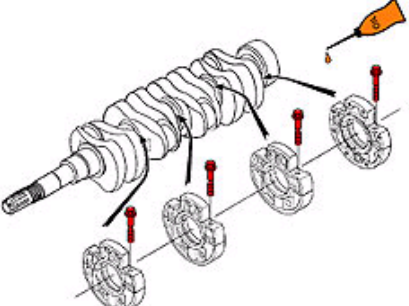
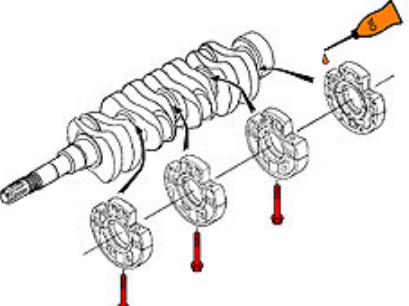
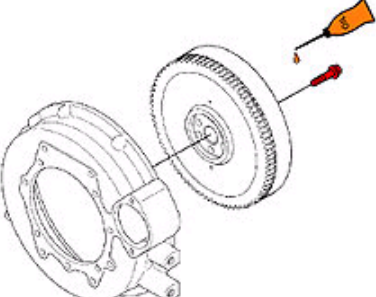
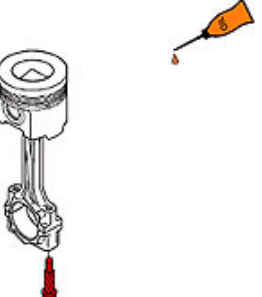
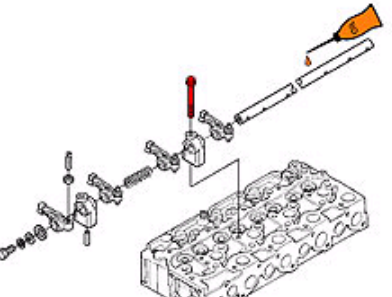




TIGHTENING TORQUES

Special Tightening Torques D650, D750

For "*" marked screws, bolts and nuts on under table, apply engine oil to their threads and seats before tightening.

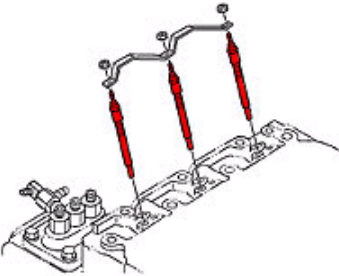
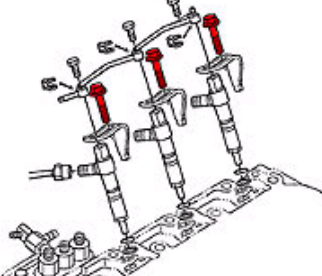
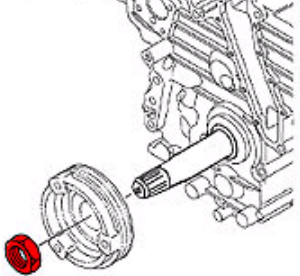
					
Head Bolts & Nuts		Main Bearing		Main Bearing Case Bolts	
D650	29 to 32 ft-lbs	D650	15 to 17 ft-lbs	D650	22 to 25 ft-lbs
D750		D750		D750	
					
Flywheel Bolts		Con Rod Bolts (Big Ends)		Rocker Arm Bracket Studs	
D650	36 to 40 ft-lbs	D650	20 to 22 ft-lbs	D650	13 to 15 ft-lbs
D750		D750		D750	



TIGHTENING TORQUES

Special Tightening Torques D650, D750

For " * " marked screws, bolts and nuts on under table, apply engine oil to their threads and seats before tightening.

					
Glow Plugs Drain Plugs		Nozzle Holders		Crankshaft Nut	
D650	15 to 18 ft-lbs	D650	22 to 36 ft-lbs	D650	101 to 116 ft-lbs
D750	29 to 36 ft-lbs	D750			

General Tightening Torques

Screw and bolt material grades are shown by numbers punched on the screw and bolt heads.

Prior to tightening, be sure to check out the numbers as shown below.

None or 4 : Standard grade

7 : Special grade

Nominal Diameter	Standard Grade	Special Grade
M6	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs
M8	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs
M10	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs
M12	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs	7.9 to 9.3 N m 0.80 to 0.95 kgf m 5.8 to 6.9 ft-lbs