

2. TIGHTENING TORQUE

Use following table for unspecified torque.

1) BOLT AND NUT

(1) Coarse thread

Bolt size	8T		10T	
	kgf · m	lbf · ft	kgf · m	lbf · ft
M 6 × 1.0	0.9 ~ 1.3	6.5 ~ 9.4	1.1 ~ 1.7	8.0 ~ 12.3
M 8 × 1.25	2.0 ~ 3.0	14.5 ~ 21.7	2.7 ~ 4.1	19.5 ~ 29.7
M10 × 1.5	4.0 ~ 6.0	28.9 ~ 43.4	5.5 ~ 8.3	39.8 ~ 60.0
M12 × 1.75	7.4 ~ 11.2	53.5 ~ 81.0	9.8 ~ 15.8	70.9 ~ 114
M14 × 2.0	12.2 ~ 16.6	88.2 ~ 120	16.7 ~ 22.5	121 ~ 163
M16 × 2.0	18.6 ~ 25.2	135 ~ 182	25.2 ~ 34.2	182 ~ 247
M18 × 2.0	25.8 ~ 35.0	187 ~ 253	35.1 ~ 47.5	254 ~ 344
M20 × 2.5	36.2 ~ 49.0	262 ~ 354	49.2 ~ 66.6	356 ~ 482
M22 × 2.5	48.3 ~ 63.3	349 ~ 458	65.8 ~ 98.0	476 ~ 709
M24 × 3.0	62.5 ~ 84.5	452 ~ 611	85.0 ~ 115	615 ~ 832
M30 × 3.0	124 ~ 168	898 ~ 1214	169 ~ 229	1223 ~ 1656
M36 × 4.0	174 ~ 236	1261 ~ 1704	250 ~ 310	1808 ~ 2242

(2) Fine thread

Bolt size	8T		10T	
	kgf · m	lbf · ft	kgf · m	lbf · ft
M 8 × 1.0	2.2 ~ 3.4	15.9 ~ 24.6	3.0 ~ 4.4	21.7 ~ 31.8
M10 × 1.2	4.5 ~ 6.7	32.5 ~ 48.5	5.9 ~ 8.9	42.7 ~ 64.4
M12 × 1.25	7.8 ~ 11.6	56.4 ~ 83.9	10.6 ~ 16.0	76.7 ~ 116
M14 × 1.5	13.3 ~ 18.1	96.2 ~ 131	17.9 ~ 24.1	130 ~ 174
M16 × 1.5	19.9 ~ 26.9	144 ~ 195	26.6 ~ 36.0	192 ~ 260
M18 × 1.5	28.6 ~ 43.6	207 ~ 315	38.4 ~ 52.0	278 ~ 376
M20 × 1.5	40.0 ~ 54.0	289 ~ 391	53.4 ~ 72.2	386 ~ 522
M22 × 1.5	52.7 ~ 71.3	381 ~ 516	70.7 ~ 95.7	511 ~ 692
M24 × 2.0	67.9 ~ 91.9	491 ~ 665	90.9 ~ 123	658 ~ 890
M30 × 2.0	137 ~ 185	990 ~ 1339	182 ~ 248	1314 ~ 1796
M36 × 3.0	192 ~ 260	1390 ~ 1880	262 ~ 354	1894 ~ 2562

2) PIPE AND HOSE

Thread size	Width across flat(mm)	kgf · m	lbf · ft
1/4"	19	3	21.7
3/8"	22	4	28.9
1/2"	27	5	36.2
3/4"	36	12	86.8
1"	41	14	101

3) FITTING

Thread size	Width across flat(mm)	kgf · m	lbf · ft
1/4"	19	4	28.9
3/8"	22	5	36.2
1/2"	27	6	43.4
3/4"	36	13	94.0
1"	41	15	109

4) TIGHTENING TORQUE OF MAJOR COMPONENT

No.	Descriptions		Bolt size	Torque	
				kgf · m	lbf · ft
1	Engine	Engine mounting bolt(Engine-Bracket)	M12 × 1.75	10.0±0.5	72.3±3.6
2		Engine mounting bolt(Bracket-Frame)	M20 × 2.5	30±3.5	253±25.3
3		Radiator mounting bolt, nut	M12 × 1.75	12.2±1.3	88.2±9.4
4		Coupling mounting bolt	M16 × 2.0	22.1±2.4	159±17.3
5	Hydraulic system	Main pump mounting bolt	M16 × 2.0	22.1±2.4	159±17.3
6		Main control valve mounting bolt	M12 × 1.75	12.2±1.3	88.2±9.4
7		Fuel tank mounting bolt	M20 × 2.5	45±5.1	325±36.9
8		Hydraulic oil tank mounting bolt	M20 × 2.5	45±5.1	325±36.9
9		Turning joint mounting bolt, nut	M12 × 1.75	12.2±1.3	88.2±9.4
10	Power train system	Swing motor mounting bolt	M20 × 2.5	57.9±8.7	419±62.9
11		Swing bearing upper mounting bolt	M20 × 2.5	57.8±6.4	418±46.3
12		Swing bearing lower mounting bolt	M20 × 2.5	57.8±6.4	418±46.3
13		Travel motor mounting bolt	M16 × 2.5	23±2.5	166±18.1
14		Sprocket mounting bolt	M16 × 2.0	29.7±4.5	215±32.5
15		Carrier roller mounting bolt, nut	M20 × 2.5	54.7±6.0	396±43.4
16	Under carriage	Track roller mounting bolt	M20 × 2.5	54.7±6.0	396±43.4
17		Track tension cylinder mounting bolt	M16 × 2.0	29.7±4.5	215±32.5
18		Track shoe mounting bolt, nut	5/8-18UNF	42±4	304±28.9
19		Track guard mounting bolt	M20 × 2.5	57.9±8.7	419±62.9
20	Others	Counter weight mounting bolt	M30 × 3.9	199±30	1439±217
21		Cab mounting bolt, nut	M12 × 1.75	12.2±1.3	88.2±9.4
22		Operator's seat mounting bolt	M 8 × 1.25	1.17±0.1	8.5±0.7