

GROUP 2 TIGHTENING TORQUE

1. MAJOR COMPONENTS

· R480LC-9A

No.	Descriptions	Bolt size	Torque		
			kgf · m	lbf · ft	
1	Engine	Engine mounting bolt (FR, bracket)	M20 × 2.5	55 ± 5.5	398 ± 39.8
2		Engine mounting bolt (RR, bracket)	3/4-10UNC	25.5 ± 2.5	184 ± 18
3		Engine mounting bolt (frame)	M22 × 2.5	69.6 ± 7.0	503 ± 50.6
4		Radiator mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
5		Coupling mounting socket bolt	M20 × 2.5	46.5 ± 2.5	336 ± 18.1
6		Main pump housing mounting bolt	M10 × 1.5	4.8 ± 0.3	34.7 ± 2.2
7	Hydraulic system	Main pump mounting bolt	M20 × 2.5	44 ± 6.6	318 ± 47.7
8		Main control valve mounting nut	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
9		Fuel tank mounting bolt	M20 × 2.5	45 ± 5.1	325 ± 63.8
10		Hydraulic oil tank mounting bolt	M20 × 2.5	45 ± 5.1	325 ± 36.8
11		Turning joint mounting bolt, nut	M16 × 2.0	29.7 ± 3.0	215 ± 32.5
12	Power train system	Swing motor mounting bolt	M20 × 2.5	58.4 ± 6.4	422 ± 46.2
13		Swing bearing upper part mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
14		Swing bearing lower part mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
15		Travel motor mounting bolt	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
16		Sprocket mounting bolt (-#0046) Sprocket mounting bolt (#0047-)	M20 × 2.5 M22 × 2.5	57.9 ± 6.0 77.4 ± 7.5	419 ± 43.4 560 ± 54.2
17	Under carriage	Carrier roller mounting bolt, nut	M16 × 2.0	29.7 ± 3.0	215 ± 21.7
18		Track roller mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
19		Track tension cylinder mounting bolt	M22 × 1.5	87.2 ± 12.5	631 ± 90.4
20		Track shoe mounting bolt, nut	M24 × 3.0	140 ± 14	1012 ± 101
21		Track guard mounting bolt	M24 × 3.0	100 ± 15	723 ± 108
22	Others	Counterweight mounting bolt	M42 × 3.0	390 ± 40	2821 ± 289
23		Cab mounting bolt	M12 × 1.75	12.8 ± 3.0	92.6 ± 21.7
24		Operator's seat mounting bolt	M 8 × 1.25	3.4 ± 0.7	24.6 ± 5.8

※ For tightening torque of engine and hydraulic components, see engine maintenance guide and service manual.

· R520LC-9A

No.	Descriptions	Bolt size	Torque		
			kgf · m	lbf · ft	
1	Engine	Engine mounting bolt (FR, bracket)	M20 × 2.5	55 ± 5.5	398 ± 39.8
2		Engine mounting bolt (RR, bracket)	3/4-10UNC	25.5 ± 2.5	184 ± 18
3		Engine mounting bolt (frame)	M22 × 2.5	69.6 ± 7.0	503 ± 50.6
4		Radiator mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
5		Coupling mounting socket bolt	M20 × 2.5	46.5 ± 2.5	336 ± 18.1
6		Main pump housing mounting bolt	M10 × 1.5	6.7 ± 1.0	48.5 ± 7.2
7	Hydraulic system	Main pump mounting bolt	M20 × 2.5	44 ± 6.6	318 ± 47.7
8		Main control valve mounting nut	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
9		Fuel tank mounting bolt	M20 × 2.5	45 ± 5.1	325 ± 63.8
10		Hydraulic oil tank mounting bolt	M20 × 2.5	45 ± 5.1	325 ± 36.8
11		Turning joint mounting bolt, nut	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
12	Power train system	Swing motor mounting bolt	M20 × 2.5	58.4 ± 6.4	422 ± 46.2
13		Swing bearing upper part mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
14		Swing bearing lower part mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
15		Travel motor mounting bolt	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
16		Sprocket mounting bolt (-#0020)	M20 × 2.5	57.9 ± 6.0	419 ± 43.4
		Sprocket mounting bolt (#0021-)	M22 × 2.5	77.4 ± 7.5	560 ± 54.2
17	Under carriage	Carrier roller mounting bolt, nut	M16 × 2.0	29.7 ± 3.0	215 ± 21.7
18		Track roller mounting bolt	M24 × 3.0	100 ± 10	723 ± 72.3
19		Track tension cylinder mounting bolt	M22 × 1.5	87.2 ± 12.5	631 ± 90.4
20		Track shoe mounting bolt, nut	M24 × 3.0	140 ± 14	1012 ± 101
21		Track guard mounting bolt	M24 × 3.0	100 ± 15	723 ± 108
22	Others	Counterweight mounting bolt	M42 × 3.0	390 ± 40	2821 ± 289
23		Center frame support & lower track mounting bolt	M33 × 3.5	220 ± 20	1591 ± 145
24		Cab mounting bolt	M12 × 1.75	12.8 ± 3.0	92.6 ± 21.7
25		Operator's seat mounting bolt	M 8 × 1.25	3.4 ± 0.7	24.6 ± 5.8

※ For tightening torque of engine and hydraulic components, see engine maintenance guide and service manual.

2. TORQUE CHART

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	0.85 ~ 1.25	6.15 ~ 9.04	1.14 ~ 1.74	8.2 ~ 12.6
M 8 × 1.25	2.0 ~ 3.0	14.5 ~ 21.7	2.73 ~ 4.12	19.7 ~ 29.8
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 ~ 79.5	9.8 ~ 15.8	71 ~ 114
M14 × 2.0	12.2 ~ 16.6	88.2 ~ 120	16.7 ~ 22.5	121 ~ 167
M16 × 2.0	18.6 ~ 25.2	135 ~ 182	25.2 ~ 34.2	182 ~ 247
M18 × 2.5	25.8 ~ 35.0	187 ~ 253	35.1 ~ 47.5	254 ~ 343
M20 × 2.5	36.2 ~ 49.0	262 ~ 354	49.2 ~ 66.6	356 ~ 482
M22 × 2.5	48.3 ~ 63.3	350 ~ 457	65.8 ~ 98.0	476 ~ 709
M24 × 3.0	62.5 ~ 84.5	452 ~ 611	85.0 ~ 115	615 ~ 832
M30 × 3.5	124 ~ 168	898 ~ 1214	169 ~ 229	1223 ~ 1656
M36 × 4.0	174 ~ 236	1261 ~ 1703	250 ~ 310	1808 ~ 2242

(2) Fine thread

Bolt size	8T		10T	
	kg · m	lb · ft	kg · m	lb · ft
M 8 × 1.0	2.17 ~ 3.37	15.7 ~ 24.3	3.04 ~ 4.44	22.0 ~ 32.0
M10 × 1.25	4.46 ~ 6.66	32.3 ~ 48.2	5.93 ~ 8.93	42.9 ~ 64.6
M12 × 1.25	7.78 ~ 11.58	76.3 ~ 83.7	10.6 ~ 16.0	76.6 ~ 115
M14 × 1.5	13.3 ~ 18.1	96.2 ~ 130	17.9 ~ 24.1	130 ~ 174
M16 × 1.5	19.9 ~ 26.9	144 ~ 194	26.6 ~ 36.0	193 ~ 260
M18 × 1.5	28.6 ~ 43.6	207 ~ 315	38.4 ~ 52.0	278 ~ 376
M20 × 1.5	40.0 ~ 54.0	289 ~ 390	53.4 ~ 72.2	386 ~ 522
M22 × 1.5	52.7 ~ 71.3	381 ~ 515	70.7 ~ 95.7	512 ~ 692
M24 × 2.0	67.9 ~ 91.9	491 ~ 664	90.9 ~ 123	658 ~ 890
M30 × 2.0	137 ~ 185	990 ~ 1338	182 ~ 248	1314 ~ 1795
M36 × 3.0	192 ~ 260	1389 ~ 1879	262 ~ 354	1893 ~ 2561

2) PIPE AND HOSE (FLARE TYPE)

Thread size (PF)	Width across flat (mm)	kgf-m	lbf-ft
1/4"	19	4	28.9
3/8"	22	5	36.2
1/2"	27	9.5	68.7
3/4"	36	18	130.2
1"	41	21	151.9
1-1/4"	50	35	253.2

3) PIPE AND HOSE (ORFS TYPE)

Thread size (UNF)	Width across flat (mm)	kgf-m	lbf-ft
9/16-18	19	4	28.9
11/16-16	22	5	36.2
13/16-16	27	9.5	68.7
1-3/16-12	36	18	130.2
1-7/16-12	41	21	151.9
1-11/16-12	50	35	253.2

4) 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	9.5	68.7
3/4"	36	18	130.2
1"	41	21	151.9
1-1/4"	50	35	253.2