

## GROUP 2 TIGHTENING TORQUE

### 1. MAJOR COMPONENTS

No.	Descriptions	Bolt size	Torque		
			kgf · m	lbf · ft	
1	Engine	Engine mounting bolt, nut	M24 × 3.0	88.2 ± 8.8	638 ± 63.7
2		Radiator mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
3		Coupling mounting socket bolt	M24 × 3.0	89.2 ± 2.5	645 ± 18.1
4		Main pump housing mounting bolt	M 8 × 1.25	13.4 ± 1.3	97 ± 9.4
5	Hydraulic system	Main pump mounting bolt	M24 × 3.0	80 ± 8.0	579 ± 57.9
6		Main control valve mounting nut	M20 × 2.5	45 ± 4.5	326 ± 32.5
7		Fuel tank mounting bolt	M20 × 2.5	58 ± 6.0	420 ± 43.4
8		Hydraulic oil tank mounting bolt	M20 × 2.5	58 ± 6.0	420 ± 43.4
9		Turning joint mounting bolt, nut	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
10	Power train system	Swing motor mounting bolt	M24 × 3.0	100 ± 15	723 ± 109
11		Swing bearing upper part mounting bolt	M30 × 3.0	175 ± 20	1266 ± 145
12		Swing bearing lower part mounting bolt	M30 × 3.0	175 ± 20	1266 ± 145
13		Travel motor mounting bolt	M30 × 3.0	100 ± 8.0	723 ± 57.9
14		Sprocket mounting bolt	M30 × 3.5	200 ± 15	1447 ± 109
15	Under carriage	Carrier roller mounting bolt, nut	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
16		Track roller mounting bolt	M27 × 3.0	135 ± 15	977 ± 109
17		Track tension body mounting bolt	M20 × 2.5	57.9 ± 6.0	419 ± 43.4
18		Track shoe mounting bolt, nut	1 1/8"-12UNF	196.2 ± 15.9	1419 ± 115
18		Track guard mounting bolt	M27 × 3.0	135 ± 15	977 ± 109
19	Others	Counter weight mounting bolt	M42 × 3.0	390 ± 40	2821 ± 289
20		Center frame support & lower track mounting bolt	M36 × 3.0	280 ± 30	2025 ± 21.7
21		Cab mounting bolt	M12 × 1.75	12.2 ± 1.3	88.2 ± 9.4
22		Operator's seat mounting bolt	M 8 × 1.25	2.5 ± 0.5	18.1 ± 3.6

※ For tightening torque of engine and hydraulic components, see each component disassembly and assembly.

## 2. TORQUE CHART

Use following table for unspecified torque.

### 1) BOLT AND NUT - 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	2.7 ~ 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(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
1"	41	21	152
1-1/4"	50	35	253

**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
1-7/16-12	41	21	152
1-11/16-12	50	35	253

**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
1"	41	21	152
1-1/4"	50	35	253