

TIGHTENING TORQUES

Part	Nominal torque	Products
Screw fastening damper to the crankshaft	450 Nm	LOCTITE 242
Screw fastening flywheel to crankshaft	91 Nm	
Solenoid valves' Screw fastening screw	10 Nm	
Screw fastening pump control gearing	23 Nm	
Oil filter cartridge	25 Nm	engine oil on gasket
Screw fastening piston cooling system multiple union (oil nozzles)	3 Nm	LOCTITE 242
Screw fastening RH head alternator	49 Nm	
Screw fastening LH head alternator	49 Nm	
Timing chain tensioner for camshaft axle control	40 Nm	
Screw fastening belt-tensioner pulley	49 Nm	
Screw fastening coils on head cover	10 Nm	
Screw fastening pumps to the sump	25 Nm	
Crankcase pumps fastening	25 Nm	
Screw fastening exchanger to crankcase	10 Nm	
Screw fastening variator oil pump	3 Nm	

Part	Nominal torque	Products
Screw fastening exhaust manifolds	25 Nm	
Screw fastening front cover to sub-crankcase-crankcase-heads	10 Nm	
Check valve on LH cylinder head	30 Nm	
Threaded union on delivery pump for fastening oil filter	60 Nm	
Mounting bracket - engine fastening	45 Nm	
Sub-crankcase - crankcase fastening (external seam)	10 Nm	
Chassis plate - bushing fastening	50 Nm	
Self-locking nut for fastening bushing	120 Nm	
Alternator cable - starter motor fastening	14 Nm	
Injectors to fuel pipes connection	30 Nm	
Pipe from accumulator to cylinder heads	22 Nm	
Union on heads and accumulator, for oil pipes running from accumulator and heads	27 Nm	
Threaded plug for clutch housing - crankcase oil hole	60 Nm	
Plug on oil tank suction screen	32 Nm	
Exhaust system thermocouples	10 Nm	
Lambda sensors	50 Nm	
Water temperature sensor	16 Nm	
Screw fastening injector rails to intake manifold	15 Nm	
Screw fastening detonation sensor	20 Nm	
Spark plug	10 Nm	Spark plug lubricant
"Torca" clamp for exhaust system	54 Nm	with spinner max 400 rpm
Screw fastening r.p.m. sensor	8 Nm	
Threaded plug on front cover for bleeding	15 Nm	

Timing variators	200 Nm	
Outlet union for water vapour from the exchanger	15 Nm	
Screw fastening hydraulic steering pump	25 Nm	
Screw fastening A.C. compressor	25 Nm	
Screw fastening auxiliary belt tensioners	25 Nm	
Screw fastening timing control transmission mount	6 Nm	LOCTITE 242
Screw fastening bushing for LH head tensioner	10 Nm	
Screw fastening gearing on timing variator	15 Nm	LOCTITE 242

Part	Nominal torque	Products
Screw fastening pipe running from the compressor to the condenser	50 Nm	
Screw fastening timing sensor and revolution sensor	8 Nm	
Screw fastening cylinder head cover	12 Nm	
Screw fastening fixed runner onto transmission	10 Nm	
Screw fastening fixed runner for timing system control	25 Nm	
Screw fastening pump control fixed runner	10 Nm	
Screw fastening moving runner for transmission	10 Nm	
Screw fastening timing system movable runner	25 Nm	
Screw fastening pump movable runner	10 Nm	
Screw fastening intake manifold to head	10 Nm	
Screw fastening oil delivery pipe to pump	10 Nm	
Threaded union on pipe from exchanger to oil tank	75 Nm	
Fastening on tank for oil delivery pipe to oil pump	78 Nm	
Clutch - flywheel engine fastening	18 Nm	
Threaded plug on cylinder head cover for timing inspection	50 Nm	
Screw fastening wiring cover	7 Nm	LOCTITE 242
Pump - inlet water cover fastening	10 Nm	
Thermal pressure gauge cover fastening	10 Nm	
Screw fastening engine electric earth	25 Nm	
Threaded union on fibre plenum chamber for brake servo vacuum	22 Nm	
Threaded union on oil tank in suction screen area	75 Nm	
Threaded plug for oil bleeding into the sub-crankcase	60 Nm	
Nuts for fastening oil suction screen onto tank	16 Nm	

Belt tensioner - crankcase fastening	25 Nm	
Nut for fastening sub-crankcase to crankcase in clutch housing area	10 Nm	
Screw for fastening mounting bracket to starter motor	10 Nm	LOCTITE 242
Nut for fastening bracket to starter motor	6 Nm	LOCTITE 242
Triple gearing retaining screw	25 Nm	
Fastening for gearing on exhaust camshaft	17 Nm	LOCTITE 242
Self-locking nut for fastening rubber bushing	5 Nm	LOCTITE 242
Threaded tapered plug on cylinder heads (M6)	7 Nm	LOCTITE 242
Threaded tapered plug on cylinder heads (M8)	10 Nm	LOCTITE 242
Threaded tapered plug on cylinder heads (M10)	32 Nm	
Electric oil pressure transmitter	40 Nm	

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