

5.1 GENERAL USE SCREWS, BOLTS AND NUTS

If the tightening torques are not specified for some screws, bolts and nuts in this manual, tighten them according to the table below.

Indication on top of bolt	④ No-grade or 4T						⑦ 7T						⑨ 9T		
Material of bolt	S8400, S20C						S43C, S48C						SCr435, SCM435		
Material of opponent part	Ordinariness			Aluminum			Ordinariness			Aluminum			Ordinariness		
Unit Diameter	Nm	kgf-m	lb-ft	Nm	kgf-m	lb-ft	Nm	kgf-m	lb-ft	Nm	kgf-m	lb-ft	Nm	kgf-m	lb-ft
M6 (6 mm, 0.24 in.)	7.85 9.31	0.80 0.95	5.79 6.87	7.85 8.82	0.80 0.90	5.79 6.50	9.81 11.2	1.00 1.15	7.24 8.31	7.85 8.82	0.80 0.90	5.79 6.50	12.3 14.2	1.25 1.45	9.05 10.4
M8 (8 mm, 0.31 in.)	17.7 20.5	1.8 2.1	13.1 15.1	16.7 19.6	1.7 2.0	12.3 14.4	23.6 27.4	2.4 2.8	17.4 20.2	17.7 20.5	1.8 2.1	13.1 15.1	29.5 34.3	3.0 3.5	21.7 25.3
M10 (10 mm, 0.39 in.)	39.3 45.1	4.0 4.6	29.0 33.2	31.4 34.3	3.2 3.5	23.2 25.3	48.1 55.8	4.9 5.7	35.5 41.2	39.3 44.1	4.0 4.5	29.0 32.5	60.9 70.6	6.2 7.2	44.9 52.0
M12 (12 mm, 0.47 in.)	62.8 72.5	6.4 7.4	46.3 53.5	/			77.5 90.2	7.9 9.2	57.2 66.5	62.8 72.5	6.4 7.4	46.3 53.5	103 117	10.5 12.0	76.0 86.7
M14 (14 mm, 0.55 in.)	108 125	11.0 12.8	79.6 92.5				124 147	12.6 15.0	91.2 108	/			167 204	17.0 20.0	123 144
M16 (16 mm, 0.63 in.)	167 191	17.0 19.5	123 141				197 225	20.0 23.0	145 166				260 304	26.5 31.0	192 224
M18 (18 mm, 0.71 in.)	246 284	25.0 29.0	181 209				275 318	28.0 32.5	203 235				344 402	35.0 41.0	254 296
M20 (20 mm, 0.79 in.)	334 392	34.0 40.0	246 289	/			368 431	37.5 44.0	272 318	/			491 568	50.0 58.0	362 419

5.2 STUD BOLTS

Material of opponent part	Ordinariness			Aluminum		
Unit Diameter	Nm	kgf-m	lb-ft	Nm	kgf-m	lb-ft
M8 (8 mm, 0.31 in.)	11.8 ~ 15.6	1.2 ~ 1.6	8.68 ~ 11.5	8.82 ~ 11.8	0.90 ~ 1.2	6.51 ~ 8.67
M10 (10 mm, 0.39 in.)	24.6 ~ 31.3	2.5 ~ 3.2	18.1 ~ 23.1	19.7 ~ 25.4	2.0 ~ 2.6	14.5 ~ 18.8
M12 (12 mm, 0.47 in.)	29.5 ~ 49.0	3.0 ~ 5.0	21.7 ~ 36.1	31.4	3.2	23.1

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