

## 1.5 TORQUE SPECIFICATIONS

Screws, bolts and nuts must be tightened to the specified torque using a torque wrench. Several screws, bolts and nuts such as those used on the cylinder head must be tightened in the proper sequence and at the proper torque.

### 1.5.1 Torque Specifications For Special Use Screws, Bolts and Nuts

In removing and applying the screws, bolts and nuts marked with "\*", a pneumatic wrench or similar tool, if employed, must be used with care. Failure to do so may result in stripped or seized screws, bolts and nuts.

When replacing "\*" marked screws, bolt and nuts, apply engine oil to their threads and seats before reassembly.

The letter "M" in size and pitch means that the screw, bolt or nut dimension is metric. The size is the nominal outside diameter in mm of the threads. The pitch is the nominal distance in mm between two threads.

| Item                                  | Size x Pitch | N.m            | kgf.m        | ft-lbs         |
|---------------------------------------|--------------|----------------|--------------|----------------|
| Cylinder Head Cover Bolt              | M6 x 1.0     | 6.9 to 11.3    | 0.7 to 1.15  | 5.1 to 8.32    |
| *Cylinder Head Bolt                   | M11 x 1.25   | 93.1 to 98.0   | 9.5 to 10.0  | 68.7 to 72.3   |
| *Main Bearing Case Bolt 1             | M9 x 1.25    | 46.1 to 50.9   | 4.7 to 5.2   | 34.0 to 37.6   |
| *Main Bearing Case Bolt 2             | M10 x 1.25   | 68.6 to 73.5   | 7.0 to 7.5   | 50.6 to 54.2   |
| *Flywheel Bolt                        | M12 x 1.25   | 98.09 to 107.8 | 10.0 to 11.0 | 72.3 to 79.5   |
| *Connecting Rod Bolt                  | M8 x 1.0     | 44.1 to 49.0   | 4.5 to 5.0   | 32.5 to 36.2   |
| *Rocker Arm Bracket Bolt              | M8 x 1.25    | 23.5 to 27.5   | 2.4 to 2.8   | 17.4 to 20.3   |
| *Idle Gear Shaft Bolt                 | M8 x 1.25    | 23.5 to 27.5   | 2.4 to 2.8   | 17.4 to 20.3   |
| Crank Pulley Mounting Nut             | -            | 137.3 to 156.9 | 14.0 to 16.0 | 101.3 to 115.7 |
| *Bearing Case Cover Bolt              | M8 x 1.25    | 23.5 to 27.5   | 2.4 to 2.8   | 17.4 to 20.3   |
| Glow Plug                             | M10 x 1.25   | 19.6 to 24.5   | 2.0 to 2.5   | 14.5 to 18.1   |
| Nozzle Holder Clamp Bolt              | -            | 25.5 to 29.4   | 2.6 to 3.0   | 18.8 to 21.7   |
| Oil Switch Taper Bolt                 | PT1/8        | 14.7 to 19.6   | 1.5 to 2.0   | 10.8 to 14.5   |
| Injection Pipe Retaining Nut          | M12 x 1.5    | 14.7 to 24.5   | 1.5 to 2.5   | 10.8 to 18.1   |
| Overflow Pipe Assembly Retaining Bolt | -            | 9.8 to 11.3    | 1.0 to 1.15  | 7.2 to 8.3     |
| Camshaft Retaining Bolt               | M8 x 1.25    | 23.5 to 27.5   | 2.4 to 2.8   | 17.4 to 20.3   |
| Hi-idling Body                        | -            | 44.1 to 49.0   | 4.5 to 5.0   | 32.6 to 36.3   |

### 1.5.2 Torque Specifications For General Use Screws, Bolts and Nuts

|     | Standard Screw and Bolt<br>Grade 4 |              |              | Special Screw and Bolt<br>Grade 7 |              |              |
|-----|------------------------------------|--------------|--------------|-----------------------------------|--------------|--------------|
|     | N.m                                | kgf.m        | ft-lbs       | N.m                               | kgf.m        | ft-lbs       |
| M6  | 7.9 to 9.3                         | 0.80 to 0.95 | 5.8 to 6.9   | 9.8 to 11.3                       | 1.00 to 1.15 | 7.23 to 8.32 |
| M8  | 17.7 to 20.6                       | 1.8 to 2.1   | 13.0 to 15.2 | 23.5 to 27.5                      | 2.4 to 2.8   | 17.4 to 20.3 |
| M10 | 39.2 to 45.1                       | 4.0 to 4.6   | 28.9 to 33.3 | 48.1 to 55.9                      | 4.9 to 5.7   | 35.4 to 41.2 |
| M12 | 62.8 to 72.6                       | 6.4 to 7.4   | 46.3 to 53.5 | 77.5 to 90.2                      | 7.9 to 9.2   | 57.1 to 66.5 |

Screw and bolt material grades are shown by numbers punched on the screw and bolt heads. Prior to tightening, be sure to check out the numbers as shown below

| Punched Number | Screw And Bolt Material Grade               |
|----------------|---------------------------------------------|
| None or 4      | Standard Screw And Bolt S400, S20C          |
| 7              | Special Screw And Bolt S43C, S48C (Refined) |

# Kubota Diesel Engine Torque Specs

**Daniel F McAuley**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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