

Torque specifications list

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CONVERSIONS

1Nm = 8.805 lbin or 0.73 lbft.
 1KgCm = 0.098066Nm
 1KgCm = 0.86795 lbin or 13.9 ounce inches

CHASSIS COMPONENTS - S/metal,Ute,& F/K Decks

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Blade retaining nut, B/disc 3/8	CAO9241D	14	19
Nut-A/F to Handle,10-24UNC plain	HA24742D	9	14Kgcm
Nut-A/F to Handle,10-24UNC Nyloc	HA24979D	13	18Kgcm
Lower Handle mtg nuts- Utility	5/16 nyloc	20	24
Lower Handle mtg nuts-Classic	5/16 nyloc	20	24
Lower Handle mtg nuts-F/K deck	5/16 nyloc	20	24
Rear Safety Skirt / Axle mount.	1/4 nyloc	7	10
Front/Rear bumper Export Ute	1/4 nyloc	7	10
Axle Clip bolt/nut - all Utes	1/4 nyloc	7	10
Segment to L/Handle - Utes	1/4 nyloc	7	10
Eyebolt Nut (torque locked)	HA24845D	8	10
Support Plate / Anti Trail Bracket	HA20415D	4.5	5.5 Nm

CHASSIS PARTS - 505,550

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Blade Retaining nut, B/disc3/8	CAO9241D	14	19
Fuel Tank, Nut & Bush - all	EN71129A/71138A	4	7
Lower Handle mtg nuts-505	5/16 plain	15	20
Tank Bkt to B/plate M8 n/nut	HA24981D	20	24
Front Axle Mtg Bolts 505/550	1/4 UNC	7	10
Rear Axle Mtg Screw - 550	1/4-20/ HA21186D	11	14
G/box Pulley Cover 505/550 (Old)	HA20290D	6	8
Belt Cover-No8 s/tap 505/550	HA20249D	8	12Kgcm
Flap Mtg Nuts - 550	1/4 Nyloc	7	10
Capsule Mtg nut - 505/550SP	1/4 Nyloc	7	10
Eyebolt Nut (torque locked)	HA24845D	8	10
G/box Pulley Cover 505/550 (New)	HA20415D	4.5	5.5 Nm

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CHASSIS PARTS S600

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Blade Disc Retain Screw, 3/8unc	HA21131D	23	30
Belt Cover to B/plate, 1/4 nyloc	HA24844D	7	10
Front Axle Clamp 1/4 nyloc	HA24844D	7	10
Rear Axle Clamp 1/4 nyloc	HA24844D	7	10
Handle Bkt to B/plate 5/16 nyloc	HA24845D	20	24
Shaft Lock Screw M10	HA21193D	12	14
Belt Adjuster Nut	HA24977D	15	20

SELF PROPELLED GEARBOX

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Gearbox body-Top half mtg Screw	M6/HA20417D	7	8
Gearbox retaining Screw	M6/HA20350D	8	10
Idler Arm Pivot bolt	M8/HA21264D	8	10
Screw – grease fill plug	HA21155D	22	34Kgcm

TILT A-CUT EDGER

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Height Segment to B/plate 1/4 nyloc	HA24844D	7	10
Rear Segment to B/plate 1/4 nyloc	HA24844D	7	10
Front Axle to baseplate	HA24844D	7	10
Lower Handle to B/plate 5/16 nyloc	HA24845D	20	24
Wheel Lug to B/plate 1/4unc screw	HA20229D	7	10
Guard to Spindle Housing 5/16 nyloc	HA24845D	20	24
Cover Plate to Guard 3/16 nyloc	HA24979D	46	52Kgcm
Engine Pulley Nut (Waxed)	EN72534D	52	79
Engine Pulley Nut (plain)	EN72534D	52	79
Blade Mounting Nut 5/8UNC	HA24974D	41	47

VICTA VAC 500

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Handgrip assy screw (anti-tamper)	HA20338D	11	14Kgcm
Handgrip assy screw 1 off	HA20329D	11	14Kgcm
Involute to Carriage assy-nut M6	HA24982D	8	11
Lower Handle to Carriage- M6	HA24982D	8	11
Motor Mtg to Involute U nut 1/4UNC	HA20348D	28	34Kgcm
Elec Motor to Motor Mount	HA21248D	24	30Kgcm

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VICTA VAC 2000

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Impellor Blade assy to Disc	M6 Bolt/Nyloc Nut	4.0	6.0
Impellor Assy to Crankshaft	M14 Nyloc Nut	52	79
Lower Handle to Cowl Assy.	3/8 UNC Nyloc Nut	34	38
Lower Handle to Axle/Guard	M6 Bolt/Nyloc nut	4.0	6.0
Back plate to Cowl assy	5/16 Nyloc nut	20	24
Cowl assy to front Cover	5/16 Nyloc nut	20	24
Front Wheel Axle/ nut	5/16 Nyloc nut	20	24
Engine mounting Screws	M8	15	20
Heat Shield to starter	M6 Duo Taptite(wax)	8	10
Eye-bolt Nut (torque locked)	HA24845D	8	10

POWER TORQUE ENGINE

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Engine Pulley,S600 retain nut(wax)	EN72534D	69	78
Blade disc Nut(WAXED)-all brakes	EN72534D	60	79
Blade disc Nut(plain)46cmNobrake	EN72534D	52	79
Blade disc Nut(WAXED)46cmNobrake	EN72534D	52	79
Blade Disc Nut(plain)505/550	EN72534D	75	88
Engine Mounting Screws all places	M8 Plain	15	20
Starter retaining screw – Tufloc	HA21267D/M8	25	30
Starter retaining screw + Loctite	HA21244D	20	25
Starter retaining screw + DriLoc	HA21244D	20	25
Cylinder Head screws	HA21244D	20	25
Crankpin	EN02109B	60	75
Spark Plug CJ8/ BM6R	HA25454A	16	30
Decompressor	EN72614A	16	30
Starter Nut	ST12633D	11	22
Flywheel - Magnet/CW hold screw	HA21247D	5	7
C-Core assy screw	HA24311B	20	25
Manifold Retaining screw	HA21248D	20	28Kgcm
Dress Cowl to Starter - M6 DuoTap	HA20322D	35	46Kgcm
Dress Cowl to sub cowl,No10-16HiLo	HA20239D	17	23Kgcm
Jet Assy to Carby body	1/4unc	7	8 Kgcm
Air Filter Mounting	3/16 BSW	9	14Kgcm
Air filter Adj. Block Screw	HA20249D	8	12Kgcm
Deluxe Cowl - Intake Grill (HiLo)	HA21305D	17	23Kgcm
Deluxe Cowl - Heat Shield (HiLo)	HA21305D	17	23Kgcm
Block Cowl - Heat Shield (HiLo)	HA21305D	17	23Kgcm
Air Deflector to Cowl S600	HA20329D	17	23Kgcm
Pressed Nut Vacuum Button	HA25684D	*3.5	4.5Kgcm

*Assemble till nut contacts block and Vacuum button is tight.

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BRAKE - POWER TORQUE

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Brake Mtg screw to block M6	HA20339D	30	40Kgcm
Cover Mtg screw	HA20411D	14	18Kgcm
Cut out Block Mtg Screw	HA20411D	14	18Kgcm
Brake Cable mtg to handle.	3/16unc	9	14Kgcm
Muffler Guard to block M6 Taptite	HA21307D	4.5	5.0
Wire Eyelet to Starter	HA21268D	20	25
EBS to S600 Baseplate (Wax screw)	HA20322D	3.5	5.0

KEY START - POWER TORQUE

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Elec Motor mounting to Cover	HA24400D	14	16Kgcm
Top Cover to Bot. Cover mtg screw	HA24400D	24	30Kgcm
Start Assy to block Should. Screw	HA20401D	30	40Kgcm
Battery Bkt to baseplate 1/4 unc	HA24982D	7	10
Wing Nut & bolt Battery cover	HA24898D	3	4

LEGEND,VANTAGE,CONCEPT,CENTURA,35,38,40 (TVS/LEV90 SERIES)

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Flange bolt retain blade disc (WITH paraffin wax coating)	EE14541B	68	75
Hex/hd Bolt Grade8 ret Blade disc. (WITH paraffin wax coating)	EE14536B	47	51
Hex/hd Bolt Grade5 ret Blade disc. (NO paraffin wax coating)	EE14239B	52	60
Engine Mounting Screw 5/16 plain		15	20
Air Filter Mtg screw/nut	HA20402D/24742D	9	14Kgcm
Throttle Cable hold screw	VU41041A	17	20Kgcm
Throttle Control Mtg nut - Plain	HA24742D	9	14Kgcm
Throttle Control Mtg nut - Nyloc	HA24979D	13	18Kgcm

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**ULTIMA, MILLENNIA, CONCEPT, CENTURA, 45, 50, 55, 60, 65
(LEV115, LEV120, TVS115, TVS120, & OVRM60/65 SERIES)**

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Flange bolt retain blade disc (apply paraffin wax coating)	EE14541B	73	75
Hex/hd Bolt Grade8 ret blade disc. (apply paraffin wax coating)	EE14536B	47	51
Engine Mounting Screw 5/16UNC plain		15	20
Air Filter Mtg screw/nut	HA20402D/24742D	9	14
Throttle Cable hold screw	VU41041A	17	20Kgcm
Throttle Control Mtg nut – plain	HA24742D	9	14Kgcm
Throttle Control Mtg nut - nyloc	HA24979D	13	18Kgcm

TUV/ CE GUARDS & MISC.PARTS

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Zone Start Nyloc Nut M5	HA24996D	8	11Kgcm
S600, RH Guard to B/plate, 1/4unc	HA24844D	7	10
S600, Nose to baseplate, 1/4 unc	HA24844D	7	10
S600, LH Guard to b/plate, 1/4unc	HA24844D	7	10
Ute, Front & Rear Bumper, 1/4unc	HA24844D	7	10

HONDA GXV 140, GCV135 / GCV160

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Hex/hd Bolt Grade 8 ret blade disc. (apply paraffin wax coating)	HA21313B	47	51
Flange bolt retain blade disc* (apply paraffin wax coating)	EE14541B*	73*	75*

*Note: EE14541B can only be used with shorter spacer 16,0 mm thick, & Sintered Sleeve EE14543A.

Engine Mounting Screw GXV 5/16UNF	HA20418D	18	20
Engine Mounting Screw GCV 5/16UNF	HA20425D	18	20
Throttle Control Mtg nut - nyloc	HA24979D	13	18Kgcm
Throttle cable anchor block GXV/GCV	Supplied	14	17kgcm
Console – T/control mtg nut	HA24979D	13	18Kgcm
Console – Mtg to RHS handle	HA24979D	13	18Kgcm
Console – Mtg to LHS handle	HA20426D	6	10Kgcm

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MULCH ONLY MOWER with GCV160/ Concept 50

LOCATION USED	PART No SCREW / BOLT	ASSY TORQUE	
		MIN	MAX Nm
Blade Bar Mounting Bolt-GCV160	supplied in kit	47	51
Blade Bar Mounting Bolt-CONCEPT 50	supplied in kit	47	51
Engine mounting Screw 5/16 UNC plain nut		15	20
Throttle Cable hold screw GCV160	Supplied	17	20Kgcm
Lower Handle mtg nuts	5/16 nyloc	20	24
Cam Lock Nut (torque locked)5/16	HA24845D	8	10
Rear Axle Mtg Screw	HA20417D	7	8
Key Clamp Screw(Concept Adaptor)	HA20415D	60	80Kgcm

UNSPECIFIED TORQUES- UNC THREADS

NOMINAL	THREAD SIZE	PLAIN NUTS		NYLOC NUTS	
		MIN	MAX Nm	MIN	MAX Nm
8 - 32	UNC	30	43Kgcm	37	48Kgcm
10 - 24	UNC	37	52Kgcm	45	60Kgcm
1/4 -20	UNC	7	9	8	11
5/16 -18	UNC	15	20	20	24
3/8 -16	UNC	27	34	34	42
7/17 -14	UNC	43	54	52	65
1/2 -13	UNC	66	83	80	100
9/16 -12	UNC	90	113	110	135
5/8 -11	UNC	125	156	150	188
3/4 -10	UNC	220	275	255	320

UNSPECIFIED TORQUES- METRIC BOLTS & NUTS.**STRENGTH GRADE 4.6**
TENSILE STRENGTH 400 mpa

NOM SIZE	ASSY TORQUE Nm
M5	2.0
M6	3.5
M8	8.6
M10	17.0
M12	30.0
M16	74.0
M20	144
M24	250
M30	500
M36	865

STRENGTH GRADE 8.8
TENSILE STRENGTH 800 mpa

ASSY TORQUE Nm
5.0
9.0
22.0
44.0
77.0
190.0
370
640

