

ENGINE TIGHTENING TORQUES

Crankcase Allen screw	M6	12 Nm
Ignition cover Allen screw, clutch, transmission (ALL 250Fi)	M5	8 Nm
Ignition cover Allen screw, clutch (ALL 450Fi+F / ALL 530F)	M5	8 Nm
Transmission cover Allen screw (ALL 450Fi+F / ALL 530F)	M6	10 Nm
Oil drain screw cap (ALL 250Fi)	M12x1.5	20 Nm
Oil drain screw cap (ALL 450Fi+F / ALL 530F)	M16x1.5	20 Nm
Oil filler screw cap	M20x1.5	20 Nm
Mesh oil filter screw cap (ALL 450Fi+F / ALL 530F)	M28x1.5	15 Nm
Cartridge oil filter cover Allen screw	M5	8 Nm
Engine oil pump body screw (ALL 250Fi)	M5	8 Nm
Engine oil pump body screw (ALL 450Fi+F / ALL 530F)	M6	12 Nm
Head-cylinder tightening nut	M10x1.25	50 Nm (1 st , 10, 2 nd , 35, 3 rd , 50)
Head-cylinder tightening flanged nut (ALL 450Fi+F / ALL 530F)	M8	25 Nm
Head-cylinder tightening flanged nut	M6	12 Nm
Camshaft bearing cap Allen screw	M6	12 Nm
Camshaft cap Allen screw	M6	12 Nm
Distribution chain tensioner Allen screw	M6	10 Nm
Water pump cover Allen screw	M5	8 Nm
Water pump impeller (ALL 250Fi)	M5	Loctite 243 + 6 Nm
Water pump impeller (ALL 450Fi+F / ALL 530F)	M6	Loctite 243 + 8 Nm
Head cover Allen screw	M5	8 Nm
Primary pinion hex nut (ALL 250Fi)	M18x1.25	Loctite 243 + 100 Nm
Primary pinion hex nut (ALL 450Fi+F / ALL 530F)	M20x1.25	Loctite 243 + 100 Nm
Clutch hub nut	M18x1.5	Loctite 243 + 100 Nm
Clutch spring Allen screw	M6	8 Nm
Starter motor bushing countersunk head Allen screw	M5	Loctite 243 + 6 Nm
Starter motor fixing Allen screw	M6	12 Nm
Mobile chain guide fixing flanged screw	M6	Loctite 243 + 10 Nm
Ignition stator Allen screw (ALL 250Fi / 450Fi EN/MX/SMR/SMM/SMX)	M4	Loctite 243 + 5 Nm
Ignition stator Allen screw (450F SMR/SMM / ALL 530F)	M5	Loctite 243 + 8 Nm
Ignition pickup fixing Allen screw	M5	8 Nm
Allen screw for gear block	M6	Loctite 243 + 10 Nm
Ignition flywheel flanged nut	M12x1.25	60 Nm
Kick starter screw	M8	Loctite 243 + 25 Nm
Gear lever Allen screw	M6	Loctite 243 + 10 Nm
Exhaust manifold flanged nut	M6	Loctite 243 + 12 Nm
Generic screws	M5	8 Nm
Generic screws	M6	10 Nm

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Kalton C. Lahue



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