

TORQUE SPECIFICATIONS

For each step, tighten following the specified torque pattern to the torque figure indicated below. All readings are in foot pounds unless otherwise indicated. Degrees of rotation refers to the rotation of the nut or capscrew.

Operation	903 Series Engines	855 Series Engines	378, 504, 555 Series Engines	1150 Series Engines
Cylinder Head Bolts ①				
Step 1	50-80	25	80-90	40-60
Step 2	115-135	80-100	110-115	110-130
Step 3	175-185	280-300		180-190
Step 4	200-240			250-250
Step 5	280-300			
Main Bearing Capscrew				
Step 1	50	145-155	55-65	190-200
Step 2	140-170	300-310	115-125	440-450
Step 3	300-320	loosen fully	165-175	loosen fully
Step 4	loosen fully	140-145	loosen fully	190-200
Step 5	50	300-310	55-65	440-450
Step 6	140-170		115-125	
Step 7	300-320		165-175	
Side Capscrews				
Step 1	25		35-40	
Step 2	70-75		100-110	
Step 3	140-150			
Connecting Rod Bolts ②				
Step 1	55-60	70-75	25-30	70-80
Step 2	90-100	140-150	50-55	140-150
Step 3	loosen fully	loosen fully	loosen fully	210-220
Step 4	30-40	25-30	25	loosen fully
Step 5	60-70	70-75	60 degrees	70-80
Step 6	95-110	140-150		140-150
Step 7				210-220
Oil Pan Bolts ③				
Step 1	30-35	28-40	15-17 (3/16" bolts)	30-35 (3/16" bolts)
Step 2				40-45 (3/16" bolts)
Step 3				60-70 (3/16" bolts)
Flywheel Housing	50-55	150	70-75	140-160
Flywheel ④				
Step 1	200-210	200-220	50-60	100-120
Step 2			135-145	200-220
Crankshaft Adapter Capscrews	340-350		135-140	
Valve Crosshead Adjustment Locknut ⑤	40-45	25-30	25-28	25-30
Intake Manifold ⑥				
Step 1	30-35	15-20	10	30-35
Step 2			20	
Step 3			34-37	
Exhaust Manifold ⑦	40-45	25	30-32	40-45
Crankshaft Vibration Damper				
Step 1	200-205		30-35	65-75
Step 2			110-120	
Crankshaft Drive Pulley				
Step 1			20	
Step 2			90-100	

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Table of Contents Engine Torque Specs Manual

1. Understanding the eBook Engine Torque Specs Manual
 - The Rise of Digital Reading Engine Torque Specs Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Engine Torque Specs Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Engine Torque Specs Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Engine Torque Specs Manual
 - Personalized Recommendations
 - Engine Torque Specs Manual User Reviews and Ratings
 - Engine Torque Specs Manual and Bestseller Lists
5. Accessing Engine Torque Specs Manual Free and Paid eBooks
 - Engine Torque Specs Manual Public Domain eBooks
 - Engine Torque Specs Manual eBook Subscription Services
 - Engine Torque Specs Manual Budget-Friendly Options

6. Navigating Engine Torque Specs Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Engine Torque Specs Manual Compatibility with Devices
 - Engine Torque Specs Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Engine Torque Specs Manual
 - Highlighting and Note-Taking Engine Torque Specs Manual
 - Interactive Elements Engine Torque Specs Manual
8. Staying Engaged with Engine Torque Specs Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Engine Torque Specs Manual
9. Balancing eBooks and Physical Books Engine Torque Specs Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Engine Torque Specs Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Engine Torque Specs Manual
 - Setting Reading Goals Engine Torque Specs Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Engine Torque Specs Manual
 - Fact-Checking eBook Content of Engine Torque Specs Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

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- Interactive and Gamified eBooks

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