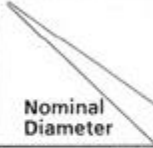


(2) Tightening torques for general use screws, bolts and nuts

When the tightening torques are not specified, tighten the screws, bolts and nuts according to the table below.

 Nominal Diameter	Grade	Standard Screw and Bolt			Special Screw and Bolt		
	Unit	N-m	kgf-m	ft-lbs	N-m	kgf-m	ft-lbs
M 6		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
M 8		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 S541, S20C
7	Special Screw and Bolt S43C, S48C (Refined)