

**[4] TIGHTENING TORQUES****1) Tightening Torques for Important Screws, Bolts and Nuts**

Section	Screws, Bolts and Nuts	Tightening Torque		
		N·m	kgf·m	ft-lbs
<b>Transmission</b> <b>(Transmission Case</b> <b>Differential Gear Case)</b>  <b>[Hydrostatic</b> <b>Transmission]</b>	37T spiral bevel gear mounting screws	30 to 35	3.0 to 3.5	21.7 to 25.3
	Bearing holder mounting screws	18 to 24	1.8 to 2.4	13.0 to 17.3
	Differential bearing holder mounting screws	18 to 24	1.8 to 2.4	13.0 to 17.3
	Bearing support mounting screws	17 to 22	1.7 to 2.2	12.3 to 15.9
	Front cover mounting screws	30 to 44	3.0 to 4.5	21.7 to 32.5
	PTO shaft staking nut	98 to 147	1.00 to 15.0	72.3 to 108
	Mid PTO drive case mounting screws	48 to 56	4.9 to 5.7	35.4 to 41.2
	Front drive shift fork mounting screws	9.8 to 11.3	1.00 to 1.15	7.3 to 8.3
	Clutch housing case mounting screws and nuts	74 to 78	7.5 to 8.0	54.2 to 57.9
	Transmission case mounting screws, bolt and nuts	35 to 39	3.5 to 4.0	25.3 to 28.9
	Rear cover mounting screws	48 to 56	4.9 to 5.7	35.4 to 41.2
	HST mounting screws	48 to 56	4.9 to 5.7	35.4 to 41.2
	Accumulator mounting screws	36.8 to 41.8	3.75 to 4.25	27.1 to 30.7
	Neutral adjuster mounting bolt	30.9 to 37.8	3.15 to 3.85	22.8 to 27.8
	Trunnion shaft cover mounting screws	3.53 to 4.31	0.36 to 0.44	2.6 to 3.2
<b>Rear Axle</b>	Axle case mounting screws and nut (M10)	48 to 56	4.9 to 5.7	35.4 to 41.2
	(M12)	78 to 90	7.9 to 9.2	57.1 to 66.5
	Rear wheel mounting screws and nuts	196 to 225	20 to 23	145 to 166
<b>Hydraulic System</b>	Hydraulic cylinder mounting screws and nuts	30 to 44	3.0 to 4.5	21.7 to 32.5
	Cylinder cap mounting screws	30 to 39	3.0 to 4.0	21.7 to 28.9
	Piston rod set pin mounting screws	44 to 59	4.5 to 6.0	32.6 to 43.4
	Control valve mounting screws	24 to 28	2.4 to 2.8	17.4 to 20.2
	Delivery pipe 1 connecting bolts	54 to 69	5.5 to 7.0	39.8 to 50.6
	Delivery pipe 2 connecting bolts	54 to 69	5.5 to 7.0	39.8 to 50.6
	Charge Pipe 1 connecting bolts	54 to 69	5.5 to 7.0	39.8 to 50.6
	Charge Pipe 2 connecting bolts	54 to 69	5.5 to 7.0	39.8 to 50.6
	Suction Pipe 1 connecting bolts	54 to 69	5.5 to 7.0	39.8 to 50.6
	Front Pipe connecting bolt	34 to 49	3.5 to 5.0	25.3 to 36.2
	Return pipe 1 connecting bolt	54 to 69	5.5 to 7.0	39.8 to 50.6
	Mounting screws	18 to 21	1.8 to 2.1	13.0 to 15.0
	Relief valve plug	49 to 59	5.0 to 6.0	36.2 to 43.4
	Flow priority valve plug	49 to 59	5.0 to 6.0	36.2 to 43.4