



DRAMIS

DTS

Tightening torques charter

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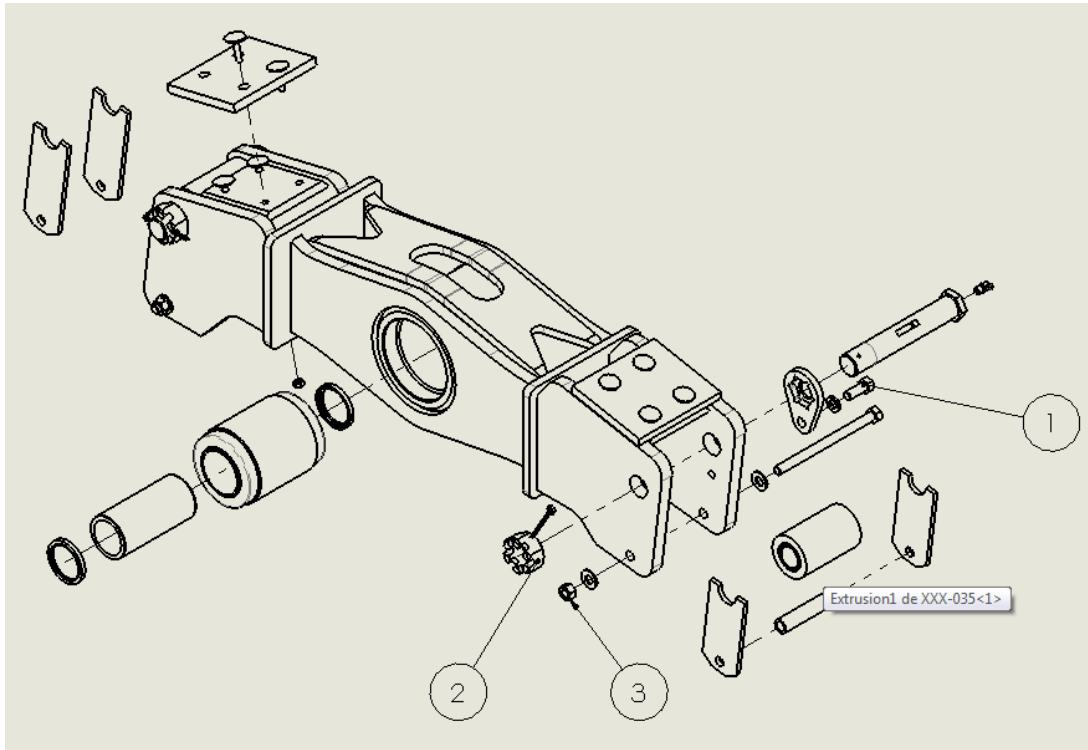
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1) Equalizer assembly



Tightening torques

#	No	Tools	Torques
1	BO_.5-13NCx1.25	Standard wrench	90 ft-lbs
2	CN_1.25-12NF	Standard wrench	See note
3	SN_.5-13NC	Pneumatic wrench	See note

Note :

Nut #2

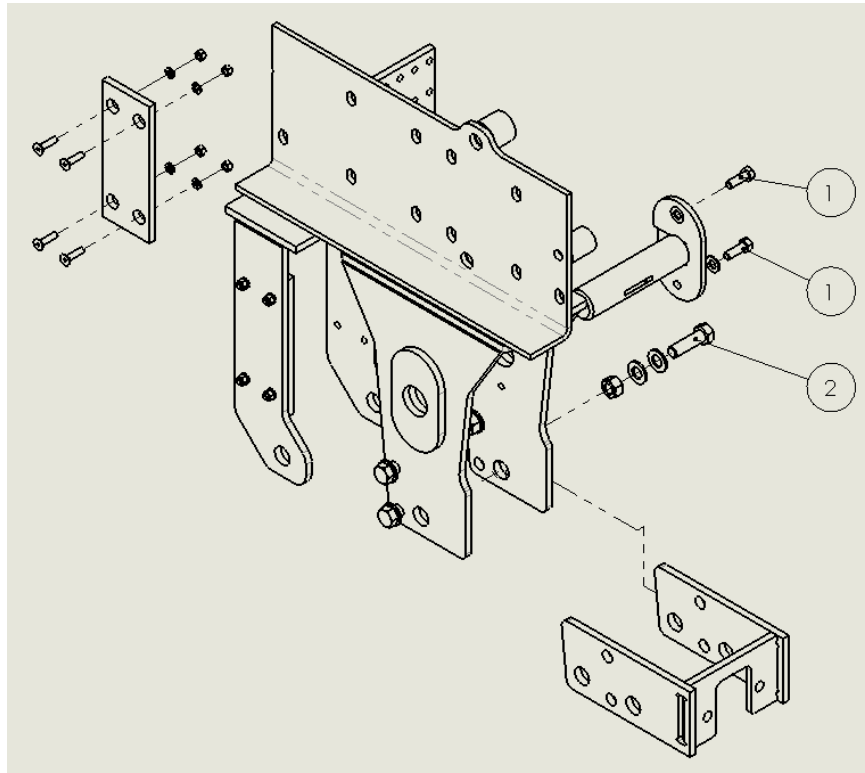
Use standard wrench

1. Tighten the nut with notch until parts block.
2. Loosen the nut.
3. Tighten until the nut is in contact with the surface.
4. Make 1/2 turn of key and align the pin hole with the notch.
5. Install and block the pin.

Boulon #3

With a pneumatic wrench, tighten the bolt until assembly is blocked.

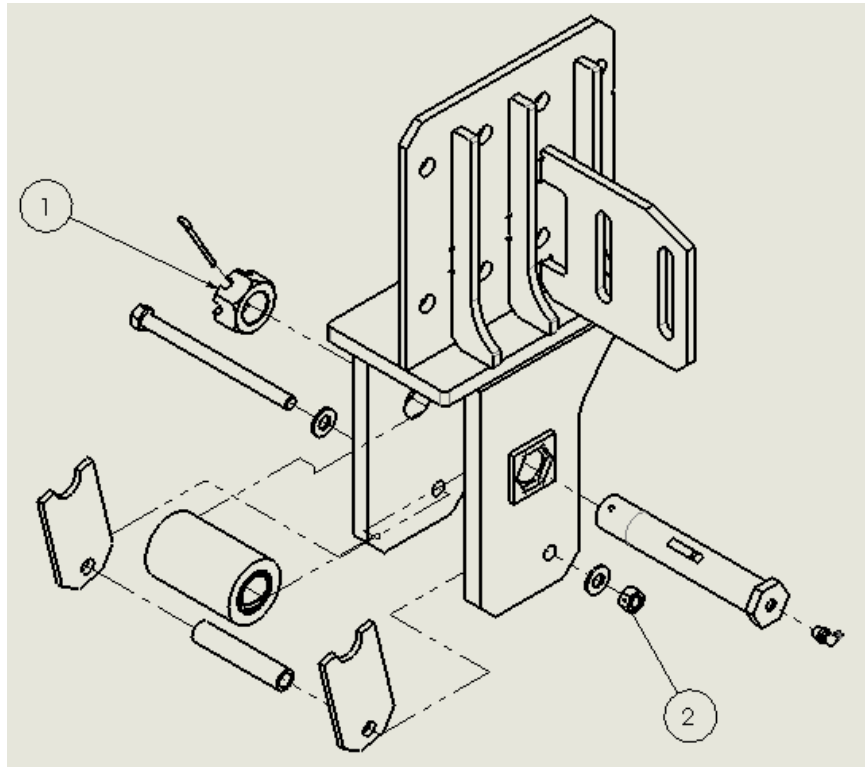
2) Equalizer hanger assembly



Tightening torques

#	No	Tools	Torques
1	BO_.5-13NCx1.5	Torque wrench	90 ft-lbs
2	BO_.75-10NCx2.5	Torque wrench	320 ft-lbs

3) Equalizer assembly



Tightening torques

#	No	Tools	Torques
1	CN_1.25-13NCx7	Standard wrench	See note
2	BO_.5-13NCx1.25	clé pneumatique	See note

Nut #2

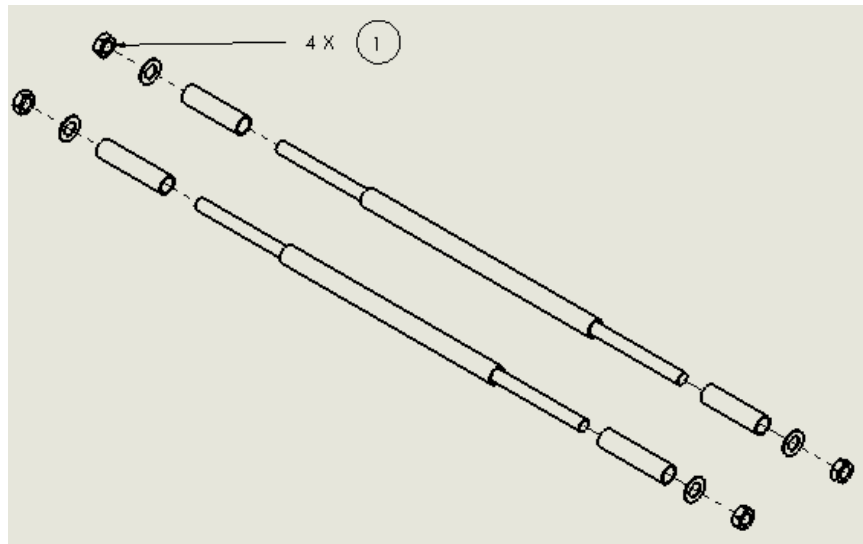
Use standard wrench

1. Tighten the nut with notch until parts block.
2. Loosen the nut.
3. Tighten until the nut is in contact with the surface.
4. Make 1/2 turn of key and align the pin hole with the notch.
5. Install and block the pin.

Boulon #3

With a pneumatic wrench, tighten the bolt until assembly is blocked.

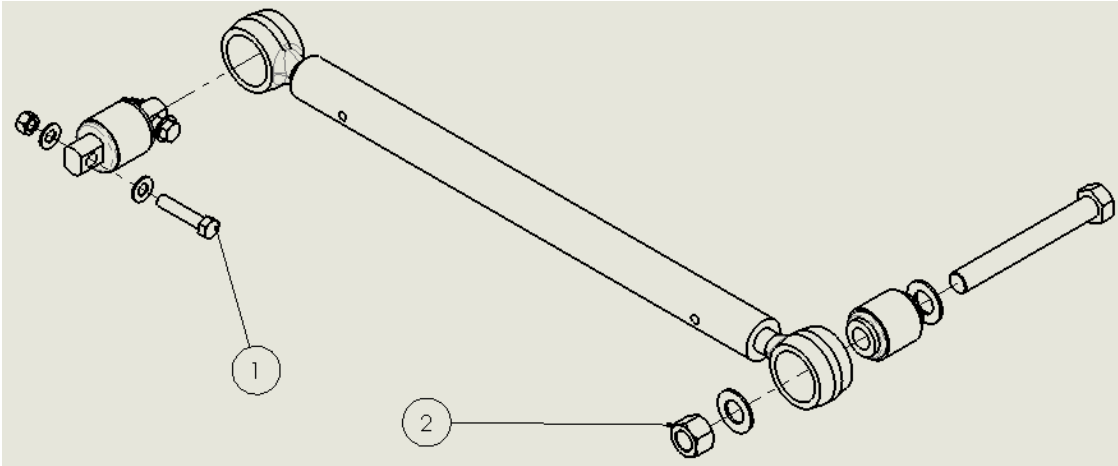
4) Cross tube assembly



Tightening torques

#	No	Tools	Torques
1	TLNN_1.125-12NF	Torque wrench	1288 ft-lbs

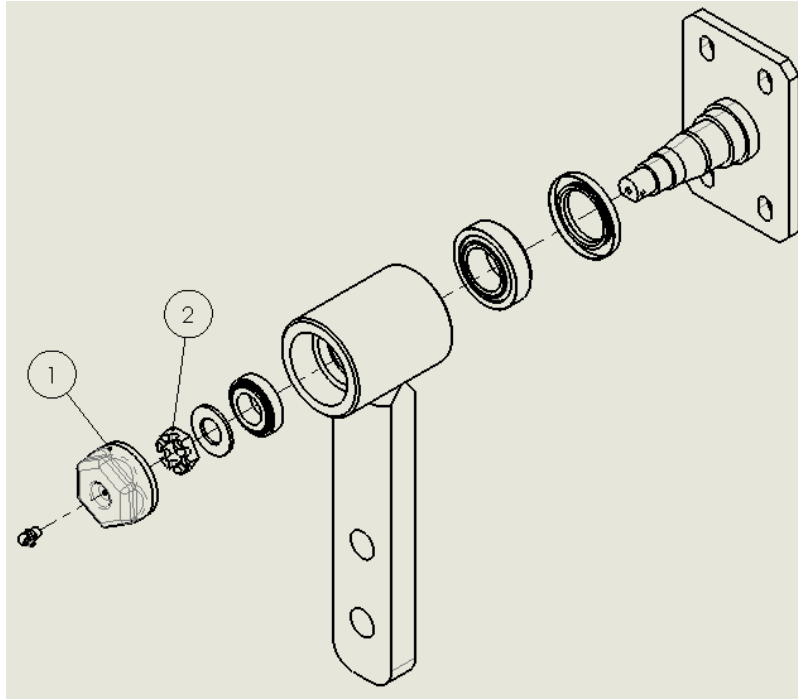
5) Torque rod assembly



Tightening torques

#	No	Tools	Torques
1	BO_.625-11NCx3	Torque wrench	180 ft-lbs
2	LNN_1.125-12NF	Torque wrench	1288 ft-lbs

6) Pivot assembly



Tightening torques

#	No	Tools	Torques
1	XXG-006A_03		See note
2	TCN_1-14NS	Torque wrench	See note

Note :

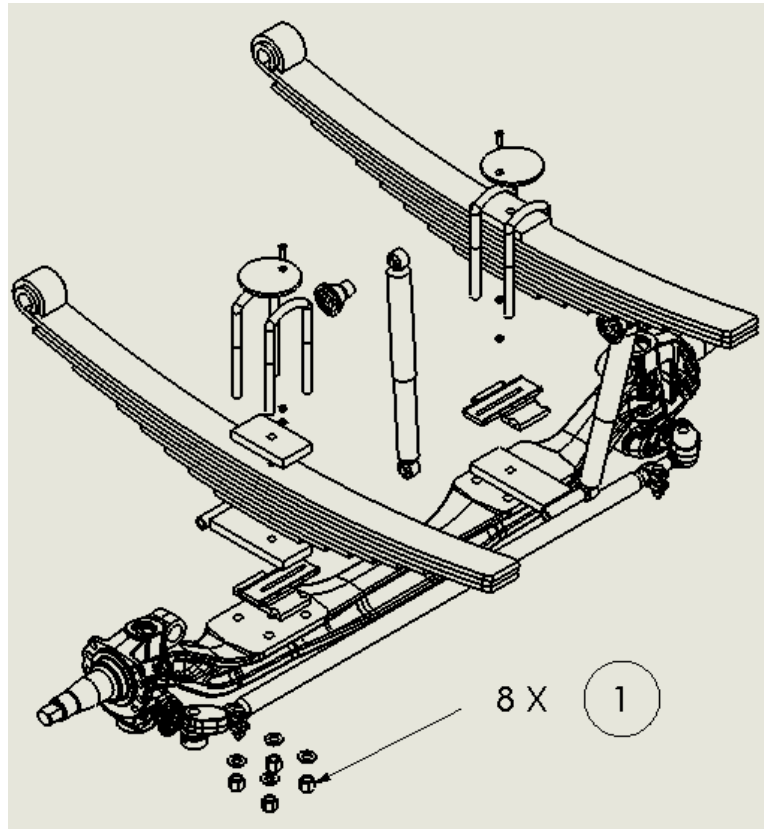
Écrou #2

1. With a torque wrench, tighten the nut at **70 lbs-pi.**
2. With a standard wrench, complete tightening until the notch is aligned with the pin hole
3. Install and block the pin

Écrou #1

With a standard wrench, tighten slightly the nut / tip

7) Front axle assembly

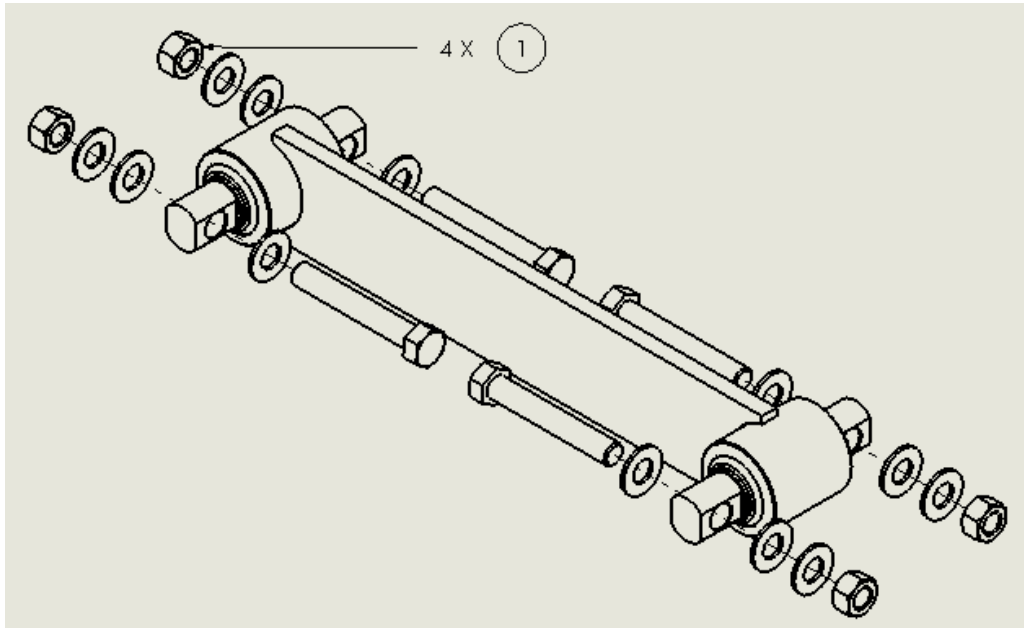


Tightening torques

#	No	Tools	Torques
1	DN_.875-16NCx1.5	Torque wrench	460 ft-lbs *

*Tolerance \pm 25ft-lbs

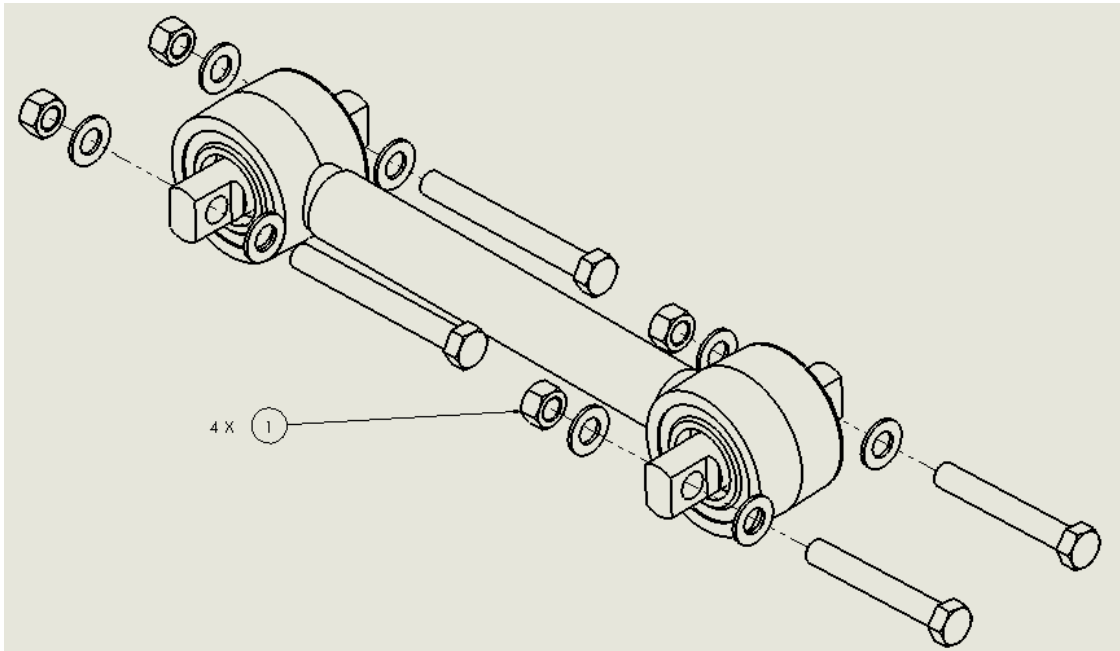
8) Cross bar assembly



Tightening torques

#	No	Tools	Torques
1	SN_.625-11NC	Torque wrench	180 ft-lbs

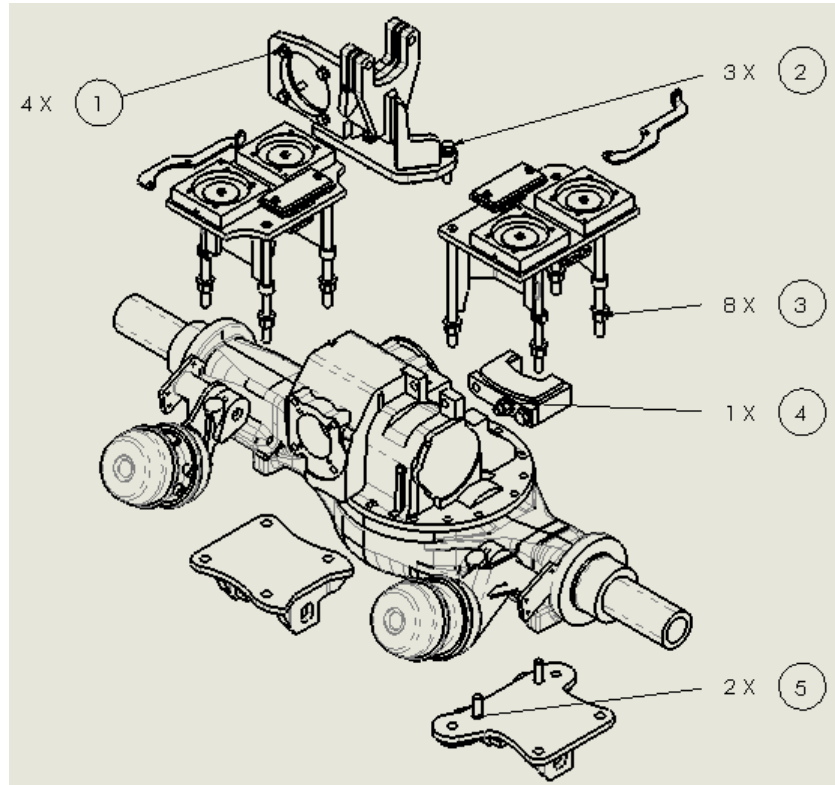
9) Torque rod assembly



Tightening torques

#	No	Tools	Torques
1	SN_825-14NF	Torque wrench	484 ft-lbs

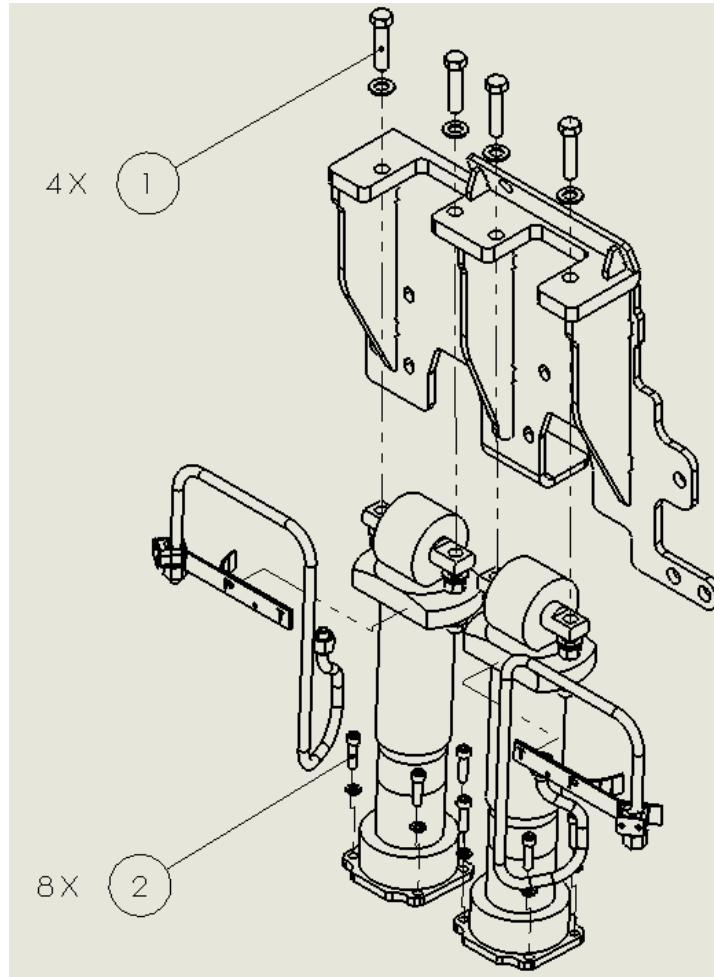
10) Rear axle assembly



Tightening torques

#	No	Tools	Torques
1	BO_.625-11NCx2.75	Torque wrench	180 ft-lbs
2	BO_.75-16NFx4	Torque wrench	357 ft-lbs
3	DN_.875-14NF	Torque wrench	568 ft-lbs
4	BO_.875-14NFx4.5	Torque wrench	568 ft-lbs
5	BO_.875-9NCx4	Torque wrench	515 ft-lbs

11) Cylinders hanger assembly



Tightening torques

#	No	Tools	Torques
1	BO_.75-10NCx3.25	Torque wrench	320 ft-lbs*
2	HSCS_.5-13NCx1.75	Torque wrench	81 ft-lbs*

*Tolerance \pm 5ft-lbs

Annex 1 : Reference table of standard tightening torques *



Torque-Tension Relationship for A307A, Grade 5, 8 & 9 Bolts

Nominal Dia. (in.)	threads per inch	Tensile Stress Area (sq. in.)	ASTM A307 Grade A						SAE J429 Grade 5						SAE J429 Grade 8						FNL Grade 9					
			Tightening Torque						Tightening Torque						Tightening Torque						Tightening Torque					
			Clamp Load (Lbs.)	K = 0.15	K = 0.17	K = 0.20	Clamp Load (Lbs.)	K = 0.15	K = 0.17	K = 0.20	Clamp Load (Lbs.)	K = 0.15	K = 0.17	K = 0.20	Clamp Load (Lbs.)	K = 0.15	K = 0.17	K = 0.20								
Unified Coarse Thread Series																										
1/4	20	0.0318	859	32 in-lbs	37 in-lbs	43 in-lbs	2029	76 in-lbs	86 in-lbs	101 in-lbs	2864	107 in-lbs	122 in-lbs	143 in-lbs	3357	126 in-lbs	143 in-lbs	168 in-lbs								
5/16	18	0.0524	1416	66	75	88	3342	157	178	209	4719	221	251	295	5531	259	294	346								
3/8	16	0.0775	2092	10 ft-lbs	11 ft-lbs	13 ft-lbs	4940	23 ft-lbs	26 ft-lbs	31 ft-lbs	6974	33 ft-lbs	37 ft-lbs	44 ft-lbs	8174	38 ft-lbs	43 ft-lbs	51 ft-lbs								
7/16	14	0.1063	2870	16	18	21	6777	37	42	49	9568	52	59	70	11214	61	70	82								
1/2	13	0.1419	3831	24	27	32	9046	57	64	75	12771	80	90	106	14969	94	106	125								
9/16	12	0.1819	4912	35	39	46	11599	82	92	109	16375	115	130	154	19193	135	153	180								
5/8	11	0.2260	6102	48	54	64	14408	113	128	150	20340	159	180	212	23840	186	211	248								
3/4	10	0.3345	9030	85	96	113	21322	200	227	267	30101	282	320	376	35281	331	375	441								
7/8	9	0.4617	12467	136	155	182	29436	322	365	429	41556	455	515	606	48707	533	604	710								
1	8	0.6057	16355	204	232	273	38616	483	547	644	54517	681	772	909	63899	799	905	1065								
1 1/4	7	0.9691	26166	409	463	545	53786	840	952	1121	87220	1363	1545	1817	102229	1597	1810	2130								
1 1/2	6	1.4053	37942	711	806	949	77991	1462	1657	1950	126473	2371	2688	3162	148237	2779	3150	3706								
Fine Thread Series																										
1/4	28	0.0364	982	37 in-lbs	42 in-lbs	49 in-lbs	2319	87 in-lbs	99 in-lbs	116 in-lbs	3274	123 in-lbs	139 in-lbs	164 in-lbs	3837	144 in-lbs	163 in-lbs	192 in-lbs								
5/16	24	0.0581	1568	73	83	98	3702	174	197	231	5226	245	278	327	6125	287	325	383								
3/8	24	0.0878	2371	11 ft-lbs	13 ft-lbs	15 ft-lbs	5599	26 ft-lbs	30 ft-lbs	35 ft-lbs	7905	37 ft-lbs	42 ft-lbs	49 ft-lbs	9265	43 ft-lbs	49 ft-lbs	58 ft-lbs								
7/16	20	0.1187	3205	18	20	23	7568	41	47	55	10684	58	66	78	12523	68	78	91								
1/2	20	0.1600	4319	27	31	36	10197	64	72	85	14396	90	102	120	16873	105	120	141								
9/16	18	0.2030	5480	39	44	51	12940	91	103	121	18268	128	146	171	21412	151	171	201								
5/8	18	0.2560	6911	54	61	72	16317	127	144	170	23036	180	204	240	27000	211	239	281								
3/4	16	0.3730	10070	94	107	126	23776	223	253	297	33566	315	357	420	39343	369	418	492								
7/8	14	0.5095	13756	150	171	201	32479	355	403	474	45853	502	568	669	53743	588	666	784								
1	14	0.6799	18357	229	260	306	43343	542	614	722	61190	765	867	1020	71720	896	1016	1195								
1 1/4	12	1.0729	28970	453	513	604	59548	930	1055	1241	96565	1509	1710	2012	113182	1768	2004	2358								
1 1/2	12	1.5810	42688	800	907	1067	87747	1645	1865	2194	142292	2668	3024	3557	166778	3127	3544	4169								

The torque values can only be achieved if nut (or tapped hole) has a proof load greater than or equal to the bolt's minimum ultimate tensile strength.

Clamp load calculated as 75% of the proof load when specified by the standard. ASTM A307 utilized 75% of 36,000 PSI.

Torque values for 1/4 and 5/16-in series are in inch-pounds. All other torque values are in foot-pounds.

Torque values calculated from formula T=KDF, where

K = 0.15 for "lubricated" conditions

K = 0.17 for zinc plated and dry conditions; we have also found various forms of customer applied thread lockers to have a similar K value.

K = 0.20 for plain and dry conditions

D = Nominal Diameter

F = Clamp Load

Note: When using Zinc Plated (lubricated with wax) Top Lock Nuts, the K value can vary between 0.12-0.16

Caution: All material included in this chart is advisory only, and its use by anyone is voluntary. In developing this information, Fastenal has made a determined effort to present its contents accurately. Extreme caution should be used when using a formula for torque/tension relationships. Torque is only an indirect indication of tension. Under/over tightening of fasteners can result in costly equipment failure or personal injury.

