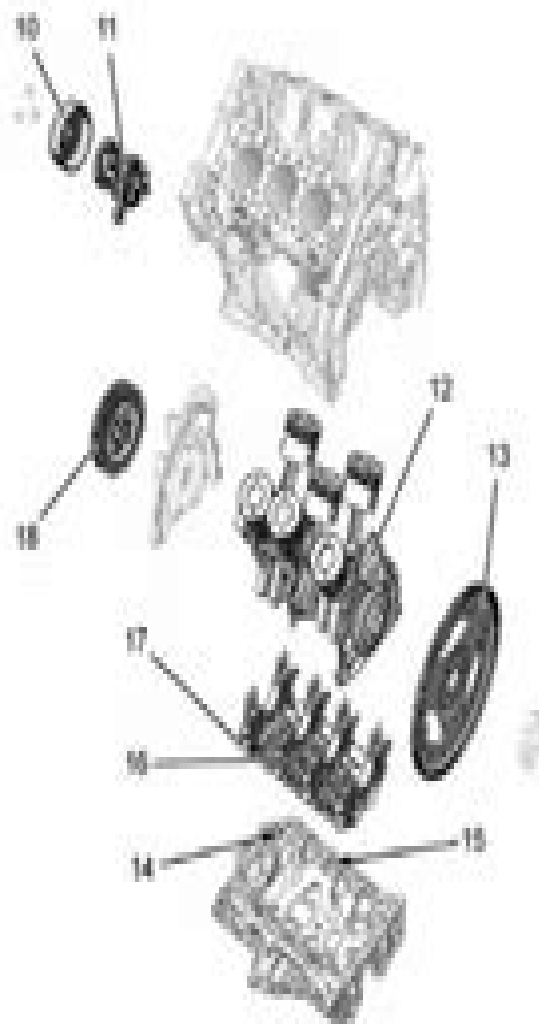


ENGINE TIGHTENING TORQUES

Engine: DT17BTED4



Cylinder block		
11	Coolant pump	$0,9 \pm 0,2$
12	Con rod screws	
	Pre-tightening	$2 \pm 0,1$
	Angular pre-tightening	$45 \pm 5^\circ$
	Angular tightening	$45 \pm 5^\circ$
13	Starter gearwheel carrier	
	Pre-tightening	$5 \pm 0,5$
	Angular pre-tightening	$45 \pm 5^\circ$
	Angular tightening	$45 \pm 5^\circ$
14	Lower engine block screw (*)	$0,9 \pm 0,2$
15	Lower engine block screw (*)	$2,3 \pm 0,3$
16	Bearing cap fixing screws (*)	
	Pre-tightening	$6 \pm 0,6$
	Tightening	$14,5 \pm 1,4$
	Angular tightening	$90 \pm 20^\circ$
17	Crankshaft bearing cap cover	
	Pre-tightening	$1,5 \pm 0,1$
	Tightening	$3,3 \pm 0,9$
	Angular tightening	$47 \pm 20^\circ$
18	Accessories drive pulley	$2,5 \pm 0,2$

(*) Respect the sequence of tightening.

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CO Houle



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