

# TECHNICAL DATA

## 2.3 Screws - Tightening Torques, Sealing and Adhesive Materials

|   |              | <b>Technical data</b> |              |  |
|---|--------------|-----------------------|--------------|--|
| <b>Engine type</b>                      |              | <b>18W</b>            |              |  |
| <b>Tightening torques</b>               |              |                       |              |  |
| Cylinder head<br>torque / wrench width  | (Nm)<br>(mm) |                       | 30 - 33 / 13 |  |
| Rocker bracket<br>torque / wrench width | (Nm)<br>(mm) |                       | *            |  |
| Bearing cover<br>torque / wrench width  | (Nm)<br>(mm) |                       | 30 - 33 / 13 |  |
| Connecting rod<br>torque / wrench width | (Nm)<br>(mm) |                       | 30- 33 / 13  |  |
| Nozzle holder<br>torque / wrench width  | (Nm)<br>(mm) |                       | 20 - 23 / 13 |  |
| Injection pump<br>torque / wrench width | (Nm)<br>(mm) |                       | 8 – 12 / 10  |  |
| Delivery valve<br>torque / wrench width | (Nm)<br>(mm) |                       | 34 - 39 / 22 |  |
| Flywheel<br>torque / wrench width       | (Nm)<br>(mm) |                       | 8 – 12 / 10  |  |
| Speed governor<br>torque / wrench width | (Nm)<br>(mm) |                       | 55 - 60 / 14 |  |
| <b>Maximum operation angles</b>         |              |                       |              |  |
| Longitudinal<br>(in dir. of crankshaft) | (deg.)       |                       | 15           |  |
| Transverse                              | (deg.)       |                       | 15           |  |
| <b>Sealing and adhesive materials</b>   |              |                       |              |  |
| <b>Text Code</b>                        |              | <b>Type</b>           |              |  |
| A                                       |              | Loctite 573           |              |  |
| B                                       |              | Loctite 270           |              |  |
| C                                       |              | Loctite 415           |              |  |