



nut, manufacturers specify the internal diameter and the thread pitch.

The measurement across two flats on a nut or bolt indicates the wrench size.

WARNING

Do not install fasteners with a strength less sufficient than what was originally installed by the manufacturer. Doing so may cause equipment failure and/or damage.

Torque Specifications

The materials used in the manufacture of the machinery may be subjected to uneven stresses if the fasteners of the various subassemblies are not installed and tightened correctly. Fasteners that are improperly installed or work loose can cause extensive damage. It is essential to use an accurate torque wrench, described in this chapter, with the torque specifications in this manual.

Specifications for torque are provided for Newton-meters (Nm), foot-pounds (ft.-lb.) and inch-pounds (in.-lb.) Refer to **Table 7** for general torque specifications. To use **Table 7**, first determine the size of the fastener as described in *Threaded Fasteners* in this section. Torque specifications for specific components are at the end of the appropriate chapters. Torque wrenches are covered in the *Basic Tools* section.

Self-Locking Fasteners

Several types of bolts, screws and nuts incorporate a system that creates interference between the two fasteners. Interference is achieved in various ways. The most common type is the nylon insert nut and a dry adhesive coating on the threads of a bolt.

Self-locking fasteners offer greater holding strength than standard fasteners, which improves their resistance to vibration. Most self-locking fasteners cannot be reused. The materials used to form the lock become distorted after the initial installation and removal. It is a good practice to discard and replace self-locking fasteners after their removal. Do not replace self-locking fasteners with standard fasteners.

Washers

There are two basic types of washers: flat washers and lockwashers. Flat washers are simple discs with a hole to fit a screw or bolt. Lockwashers are used to prevent a fastener from working loose. Washers can be used as spacers and ribs, or to help distribute fastener load and to prevent the fastener from damaging the component.

As with fasteners, when replacing washers, make sure the replacement washers are of the same design and quality.

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