

## INTRODUCTION

### TIGHTENING TORQUE

Tighten fasteners to the torque specified. If a torque is not specified, refer to the table.

**Torque wrench tightening specification:** Locking devices when removed (e.g., pins, etc.) must be replaced.

In order to avoid a poor assembly, tighten as follows:

1. Manually rotate all screws, bolts and nuts.
2. Apply half the recommended torque value.
3. Tighten fastener to the recommended torque.

**CAUTION:** Be sure to use the recommended torque.

**NOTE:** When possible, always apply torque in the same direction.

**NOTE:** Always torque screws, bolts and nuts used to secure a cast leg, a cast roller head, a bush and torque pin(s) as defined in the instructions.

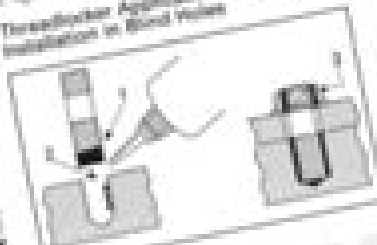
| PROPERTY CLASS AND MARKINGS | S.S. |      |
|-----------------------------|------|------|
|                             | 10.9 | 12.9 |
| Property class and markings |      |      |
| Property class and markings |      |      |

| FASTENER SIZE | FASTENER TORQUE                                    |                                                    |
|---------------|----------------------------------------------------|----------------------------------------------------|
|               | S.S. Grade 10.9                                    | S.S. Grade 12.9                                    |
| M4            | 1.5 - 2.0 Nm<br>(1.5 - 15.0 lbf-in)                | 2.0 - 2.5 Nm<br>(2.0 - 21.0 lbf-in)                |
| M5            | 2.0 Nm - 2.5 Nm<br>(17.0 lbf-in - 21.0 lbf-in)     | 2.5 Nm - 3.0 Nm<br>(21.0 lbf-in - 26.0 lbf-in)     |
| M6            | 3.0 Nm - 3.5 Nm<br>(26.0 lbf-in - 31.0 lbf-in)     | 3.5 Nm - 4.0 Nm<br>(31.0 lbf-in - 36.0 lbf-in)     |
| M8            | 5.0 Nm - 6.0 Nm<br>(44.0 lbf-in - 53.0 lbf-in)     | 6.0 Nm - 7.0 Nm<br>(53.0 lbf-in - 62.0 lbf-in)     |
| M10           | 8.0 Nm - 10.0 Nm<br>(71.0 lbf-in - 89.0 lbf-in)    | 10.0 Nm - 12.0 Nm<br>(89.0 lbf-in - 107.0 lbf-in)  |
| M12           | 12.0 Nm - 15.0 Nm<br>(107.0 lbf-in - 134.0 lbf-in) | 15.0 Nm - 18.0 Nm<br>(134.0 lbf-in - 161.0 lbf-in) |
| M16           | 20.0 Nm - 25.0 Nm<br>(178.0 lbf-in - 221.0 lbf-in) | 25.0 Nm - 30.0 Nm<br>(221.0 lbf-in - 267.0 lbf-in) |

## INTRODUCTION

1. Apply several drops along the threaded hole and at the bottom of the hole.
2. Apply several drops on both threads.
3. Tighten as required.

### Threadlocker Application for Stud Installation in Blind Holes



1. Clean threads (stud and hole) with solvent.
2. Apply LOCTITE HANDBRAND to the stud and hole.
3. Put 2 or 3 drops of proper strength Loctite on threads and allow to dry.

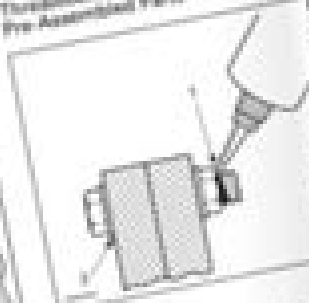
**NOTE:** For permanent installation, use Loctite HANDBRAND on threads and a hole.

**NOTE:** To avoid a leaky hole situation, do not use Loctite on stud threads.

4. Apply several drops of proper strength Loctite on stud threads.
5. Install stud.
6. Install cover, etc.

7. Apply a few drops of proper strength Loctite on cover stud threads.
8. Install and tighten retaining nut(s) as required.

### Threadlocker Application for Pre-Assembled Parts



1. Clean hole and hole with solvent.
2. Assemble components.
3. Tighten hole.

4. Apply a few drops of proper strength Loctite on threads and allow to dry.
5. Assemble retaining nut(s) with fit of 1/16 in.

**NOTE:** For permanent installation, use Loctite HANDBRAND on threads and a hole.

**NOTE:** To avoid a leaky hole situation, do not use Loctite on stud threads.

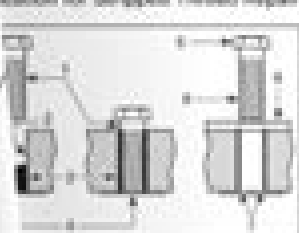
### Threadlocker Application for Adjustment Screws



1. Adjust screw to proper value.
2. Apply a few drops of proper strength Loctite on threads.
3. Assemble retaining nut(s) as required.

If it is difficult to tighten, heat screws with heating coil (220°C (425°F)).

### Threadlocker Application for Stripped Thread Repair



1. Clean hole and hole with solvent.
2. Assemble components.
3. Tighten hole.

4. Apply a few drops of proper strength Loctite on threads and allow to dry.
5. Assemble retaining nut(s) with fit of 1/16 in.

**NOTE:** For permanent installation, use Loctite HANDBRAND on threads and a hole.

**NOTE:** To avoid a leaky hole situation, do not use Loctite on stud threads.

**NOTE:** If the cover is bolted to blind holes, apply proper strength Loctite in the hole and on threads.

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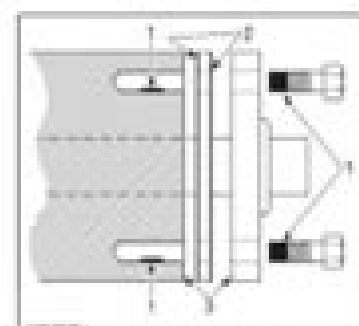
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### Gasket Compound Application



1. Clean hole and hole with solvent.
2. Assemble components.
3. Tighten hole.

4. Apply a few drops of proper strength Loctite on threads and allow to dry.
5. Assemble retaining nut(s) with fit of 1/16 in.

**NOTE:** For permanent installation, use Loctite HANDBRAND on threads and a hole.

**NOTE:** To avoid a leaky hole situation, do not use Loctite on stud threads.

**NOTE:** If the cover is bolted to blind holes, apply proper strength Loctite in the hole and on threads.

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**Didier Musso**



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changed on the water since 1983 when this book was originally published Black buoys are now green the Global Positioning Satellite navigation system GPS is almost universally used new types of anchors and sails have appeared safety skills and gear are vastly improved many more women are commanding boats and catamarans and trimarans are common where only monohulls used to sail But for all these modern developments the basic skills and spirit of sailing have not changed at all Sail trimming keeping up steerageway maintaining the dead reckoning plot heaving to these fundamentals are as important now as ever and receive much attention here Among the innovations in this edition are Basic skills in early chapters Fundamental sailing and boat handling skills and gear which are introduced in chapters 1 2 and 3 Hands On segments Three dozen special sections each devoted to a particular seamanship problem and an expert solution More how to tips Additional rules of thumb that guide a crew quickly and successfully through seamanship problems New coverage of multihulls Advice on evaluating anchoring and handling catamarans and trimarans under sail including in storms More on emergencies New material on emergencies safety and heavy weather sailing including a section on preparing a docked boat for a hurricane Equipment updates Expanded coverage of the use and care of modern gear and hardware including radar GPS rescue devices and asymmetrical spinnakers Terminology Full definition and illustration of major terms when they re first introduced with alternative language provided in parentheses Gender The use of feminine personal pronouns which reflect the fact that more women are captaining and sailing boats than ever before From navigation and seamanship to boat and gear maintenance from pleasure cruising to heavy weather sailing here is the definitive state of the art guide that provides systematic step by step techniques to see you through every situation on deck and in the cockpit



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