

Torque Requirement Procedures

All fasteners should be re-torqued according to the following schedule.

- after 30 days
- every 6 months thereafter

Capscrew/Bolt (Grade 8 UNF) Torque Requirements

Capscrew/Bolt Size	3/8"	1/2"	5/8"	3/4"	3/4" (Stabilizer Shock Stud)	7/8"	1"	1 1/8"
Torque minimum feet/lbs.	25	50	150	300	150	500	700	900
Torque maximum feet/lbs.	35	75	200	350	175	550	800	1000

NOTE

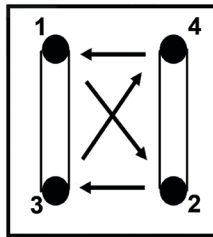
Torque Values do not apply to air springs or lower grade fasteners.

U-bolt Torque Instructions

To torque or re-torque u-bolts:

1. Partially tighten bolts #1 and #2 according to figure 1.

Figure 1: U-Bolt Torque Pattern



2. Partially tighten bolts #3 and #4.
3. Using the same sequence, torque to the proper torque as specified below.

U-Bolt (Non-Plated Clean Lubricated Thread) Torque Requirements

UNF Grade 8 Size	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1 1/8"
U-bolt minimum feet/lbs.	15	40	120	200	400	650	800
U-bolt maximum feet/lbs.	20	60	150	250	450	750	900

Airspring Torque Requirements

Size	Description	Max Torque Requirement (ft./lbs.)
3/8"	UNC Blind Nuts	15-20
1/2"	UNC Bolt or Stud	25
3/4"	UNC Stud	55
3/4"	UNF Combo Stud	50

Air Fitting Torque Requirements

Size	Max Torque Requirement (ft./lbs.)
1/4" NPTF	20
1/2" NPTF	20
3/4" NPTF	20