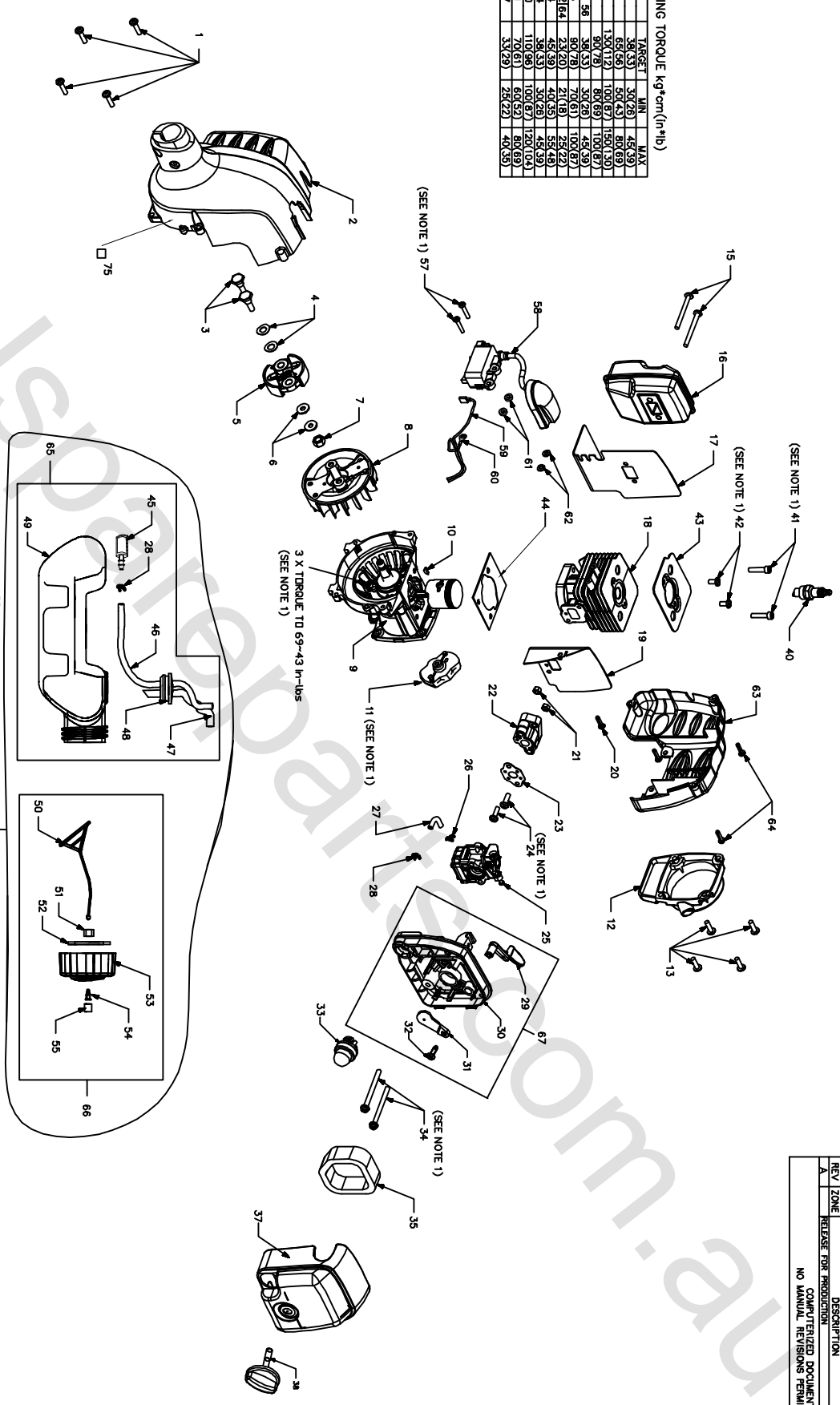


REV	ZONE	DESCRIPTION	EGR	CHECKED
A		RELEASE FOR PRODUCTION		
		COMPUTERIZED DOCUMENT		
		NO MANUAL REVISIONS PERMITTED		

FIXING TORQUE kg*cm/(in*lb)

ITEM	TARGET	MIN	MAX
1	38(33)	30(28)	45(39)
3	69(66)	50(43)	80(69)
7	130(112)	100(87)	150(130)
11	50(75)	60(69)	100(67)
13	58(75)	50(60)	105(93)
15	38(33)	30(28)	45(39)
17	38(33)	30(28)	45(39)
19	38(33)	30(28)	45(39)
21	38(33)	30(28)	45(39)
23	38(33)	30(28)	45(39)
25	38(33)	30(28)	45(39)
27	38(33)	30(28)	45(39)
29	38(33)	30(28)	45(39)
31	38(33)	30(28)	45(39)
33	38(33)	30(28)	45(39)
35	38(33)	30(28)	45(39)
37	38(33)	30(28)	45(39)
39	38(33)	30(28)	45(39)
41	70(61)	60(52)	80(69)
43	38(33)	30(28)	45(39)
45	38(33)	30(28)	45(39)
47	38(33)	30(28)	45(39)
49	38(33)	30(28)	45(39)
51	38(33)	30(28)	45(39)
53	38(33)	30(28)	45(39)
55	38(33)	30(28)	45(39)
57	33(29)	28(23)	40(35)



NOTES:
1. ASSEMBLE WITH BLUE LOCTITE THREADLOCKER #242

308277004 01 25-KW FULL CRANK POWER HEAD ASS'Y/GREEN MACHINES ASSEMBLED		REMARKS	
PART NUMBER	DATE	DESIGNER	DATE
308277004 01	2013	JUL27/05	
DESIGNED BY	DESIGNED BY	DESIGNED BY	DATE
308277004 01	308277004 01	308277004 01	2013
APPROVED BY	APPROVED BY	APPROVED BY	DATE
308277004 01	308277004 01	308277004 01	2013
DIMENSION & TOLERANCE CON		N/A	
THIRD ANGLE PROJECTION		N/A	
PART NUMBER		308277004A	
SCALE		1:1	
SHEET		1 OF 1	