



# INSTALLATION TORQUE VALUES



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Brake Valves			
NPTF Thread	Recommended Torque	Metric Thread	Recommended Torque
1/8" – 27	18Nm	M10 x 1.0	18Nm
1/4" – 18	28Nm	M12 x 1.5	24Nm
3/8" – 18	38Nm	M14 x 1.5	28Nm
1/2" - 15	42Nm	M16 x 1.5	35Nm
		M22 x 1.5	40Nm

Air Suspension		
	Metric Thread	Recommended Torque
Shock Absorber Mounting Bolts	M16	200Nm
U Bolts	M16	400Nm
	M20	500Nm
Pivot Bolts – Torque Method	M27	1000Nm
Pivot Bolts – Angular Method	M27	200Nm plus 270°
Airbag Mounting	M10	25Nm
	M12	35Nm

Spring Brake 12/16		
Description	Thread	Recommended Torque
Ports	3/8" x 18	45Nm
Mounting	7/16 UNC	100Nm

Mechanical Suspension		
	Thread	Recommended Torque
Spring Eye Bolt	M14	180Nm
Spring Eye Bolt	M18	300 – 330Nm
Equaliser Bolt	M18	430Nm
Spring Retaining Bolt	M10	70Nm
U Bolt	M16	380-400Nm
U Bolt	M18	400-450Nm

Axles			
	Imperial Thread	Metric Thread	Recommended Torque
3T Axle Lock Nut		M45 x 1.5	480Nm
3T Cap Screw	Requires loctite	M12 x 1.25	130 – 150Nm
5T Axle Lock Nut	Refer to page 2.		
6T Axle Lock Nut	2 5/8" UNF		400Nm
Hub Cap Bolts	5/16" UNC		20 – 35Nm
Camshaft Bracket Bolts		M8 x 1.5	30 – 35Nm
Wheel Nuts	3T	M14 x 1.5	200 – 225Nm
	5T & 6T Single Wheel	M20	400 – 430Nm
	6T Dual Wheel 2 piece nut	M20	600 – 675Nm

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### 5T Axle Castellated Nut Torque Setting

1. Install the thrust washer and the castellated nut, torque the nut to 270Nm (200lb/ft) while rotating the hub in both directions.
2. Back off the nut one full turn.
3. Re-torque to 50Nm while rotating the hub in both directions.
4. Back off the nut 1/6 of a turn, do not include socket back lash.
5. Turn nut to nearest slot and install a new cotter (split pin) in the axle spindle hole.
6. Check the hub rotates freely.
7. Bearing end float should be 0.025 - 0.127mm (0.001 - 0.005"). For longer bearing life, keep it to the lower end of the tolerance – 0.001". No pre-load is allowed on bearing.
8. The above procedures are recommended installation procedures; however, it is paramount that point 7 is the final outcome.
9. Ensure the hub cap is in good order and refitted with a new gasket.

**Note: All torques for dry condition and in Nm.**