

3.1.12. TIGHTENING TORQUE SETTINGS

DESCRIPTION	SCREW / NUT	TIGHTENING TORQUE SETTINGS	NOTES
		Nm	
<b>HANDLEBAR AND CONTROLS</b>			
Screw securing clutch control to handlebar	M6	10	
Throttle control screw	M6	4	
Ignition switch screw	M8	24	
<b>FOOTRESTS</b>			
Footrest support bracket screw	M12	55	loctite 243
Footrest support bracket screw	M8	25	loctite 243
<b>CHASSIS</b>			
Screw securing linkage to mudguard at front end	M6	12	
Screw securing linkage to mudguard at rear end	M6	12	
Screw securing mudguard to bottom yoke	M6	12	
Conveyors screw	M6	12	
Side body panels screw	M6	12	
Front screw securing tail end to subframe	M6	12	
Central nut securing tail end – mudguard – subframe	M6	12	
Rear screw securing tail end to subframe	M6	12	
Screw securing tail end to mudguard	M6	12	
Top screw securing under-tail end to number plate holder	M5	7	
Bottom screw securing under-tail end to number plate holder	M5	7	
Screw securing under-tail end – mudguard – starter contactor ext.	M6	12	
Shock absorber guard screw	M5	6	
Screw securing headlight fairing to instrument support	M5	6	
Instrument support screw	M5	6	
Under-tail end lower screw	M6	12	
<b>LIGHTS AND INSTRUMENT PANEL</b>			
Tail light screw	3.9	2	
Turn indicators nut	M8	6	
Digital instrument nut	M5	6	
Headlight screw	M6	6	
<b>TANKS</b>			
Screw securing plate to fuel tank	M6	12	
Screw securing fuel tank to frame	M6	12	
Screw securing pump body to fuel tank	M6	10	
Oil tank nut	M6	5	
<b>FRAME</b>			
Subframe screw	M10	49	
Upper chain roller screw	M8	22	
Lower slider rear screw	M5	4.4	
Lower slider front screw	M5	4.4	
<b>STAND</b>			
Stand plate screw	M8	22	loctite 243
Side stand nut	M10	34	loctite 243

DESCRIPTION	SCREW / NUT	TIGHTENING TORQUE SETTINGS	NOTES
		Nm	
<b>EXHAUST SYSTEM</b>			
Screw securing silencer to subframe	M8	22	
Exhaust pipes nut	M6	12	
Screw securing tubes to head	M6	12	
Screw securing brake to handlebar	M6	10	
<b>COOLING SYSTEM</b>			
Radiators upper screw	M6	5	
Radiators lower screw	M6	12	
<b>FRONT BRAKE</b>			
Front brake calliper screw - RXV 450/550	M8	25	
Front brake calliper screw - SXV 450/550	M10	50	
<b>REAR BRAKE</b>			
Rear brake master cylinder screw	M6	10	
Brake pedal screw	M8	25	loctite 243
<b>FRONT WHEEL</b>			
Wheel shaft cap	M22	60	
<b>REAR WHEEL</b>			
Wheel shaft nut	M25	127	
<b>FRONT SUSPENSION</b>			
Steering head screw	M8	24	
Bottom yoke screw	M8	22	
Wheel shaft pinch bolt - RXV 450/550	M6	10	
Wheel shaft pinch bolt - SXV 450/550	M8	22	
Handlebar upper clamps screw	M8	24	
Steering shaft nut	M26	108	
Steering shaft ring nut	M30	7	
Handlebar lower clamp nut	M10	32	
Leg guard screw	M6	12	
<b>REAR SUSPENSION</b>			
Nut securing frame to linkage	M12	80	
Nut securing linkage to rocker	M12	80	
Nut securing rocker to swinging arm	M12	80	
Shock absorber nut	M10	52	
<b>SWINGING ARM</b>			
Chain guide nut	M6	12	
Nut securing swinging arm shaft	M14	100	
Chain stretcher adjuster nut	M8	26	
Screw securing chain slider and tube guides to rear brake	4.8	4.4	
Rear chain guard screw	4.8	4.4	
Chain guide screw	M6	12	

DESCRIPTION	SCREW / NUT	TIGHTENING TORQUE SETTINGS	NOTES
		Nm	
Crankshaft stop screw	M8x1.25	22	loctite 270
Freewheel outer ring screws	M6x1	13	loctite 270
Throttle body screws	M6x1	13	
Camshaft gear retaining screw	M16x1	35	
<b>ELECTRICAL COMPONENTS</b>			
Screw securing solenoid starter and fuse holder	M5	7	loctite 243
Frame ground retaining screw	M6	12	
Solenoid starter cables screw	M6	12	
Horn screw	M8	22	

2.1.3. TIGHTENING TORQUE SETTINGS

DESCRIPTION	SCREW / NUT	TIGHTENING TORQUE SETTINGS	NOTES
		Nm (Lbft)	
<b>ENGINE</b>			
Nut securing engine to frame	M10	54 (39.82)	
Screw securing throttle body to head	M6	12 (8.85)	loctite 243
Screw securing control unit to plate	M4	4.4 (3.24)	loctite 243
Screw securing voltage regulator and control unit to frame	M6	12 (8.85)	
Coil screw	M6	12 (8.85)	
Screw securing sprocket cover and chain guide plate	M6	12 (8.85)	
Engine oil drain cap	M12x1.5	18 (13.28)	
Gearbox fluid drain cap	M10X1.5	18 (13.28)	
Oil filter cover	M56x1.5	25 (18.44)	
Piston mounting hole plug	M30x2	30 (22.13)	
Spark plug	M10X1.25	12 (8.85)	
Gearbox fluid check screw	M6x1	9.8 (7.23)	
Water pump impeller	M7x1	12 (8.85)	
Head cover screw	M6x1	9.8 (7.23)	
Water pump cover screw	M6x1	9.8 (7.23)	
Clutch cover screw	M6x1	9.8 (7.23)	
Right casing cover screw	M6x1	9.8 (7.23)	
Casing jointing bolt	M6x1	12 (8.85)	
Casing jointing bolt	M7x1	15 (11.06)	
Ignition cover screw	M6x1	9.8 (7.23)	
Pick-up screw	M5x0.8	8 (5.90)	loctite 270
Stator fixing screw	M5x0.8	8 (5.90)	loctite 270
Chain tensioner sliding shoe screw	M6x1	9.8 (7.23)	loctite 270
Timing chain tensioner screw	M6x1	10 (7.37)	
Cable guide ring screw	M6x1	10 (7.37)	
Oil lines mounting plate screw	M6x1	9.8 (7.23)	loctite 270
Blow-by breather union	M12x1	18 (13.28)	Use sealant
Flywheel nut	M14x1	98 (72.28)	
Starter motor screw	M6x1	9.8 (7.23)	
Chain guide plate screw	M6x1	12 (8.85)	
Screw securing primary shaft bearing	M6x1	12 (8.85)	loctite 270
Screw securing lay shaft bearing	M6x1	12 (8.85)	loctite 270
Desmo bearing screw	M5x0.8	8 (5.90)	loctite 270
Gear indicator screw	M5x0.8	6 (4.43)	loctite 270
Gear change pedal screw	M6x1	12 (8.85)	
Head bolt (pre-torque)	M10X1.25	30 (22.13)	Smear screws and washers with oil
Head bolt	M10X1.25	50 (36.88)	
Head bolt	M6x1	12 (8.85)	
Timing gear nut	M12x1	50 (36.88)	
Timing cover screw	M5x0.8	6 (4.42)	loctite 243
Primary sprocket nut	M18x1.25	160 (118.00)	
Gear selector stop plate screw	M6x1	12 (8.85)	loctite 270
Oil collector plate screw	M6x1	12 (8.85)	loctite 270
Gear selector shaft stop screw	M10X1.25	25 (18.44)	loctite 270
Gear ratchet rotation screw	M6x1	12 (8.85)	loctite 243
Selector shaft	M8x1.25	22 (16.23)	loctite 270
Clutch hub nut	M18x1.25	75 (55.32)	
Clutch spring screw	M6x1	12 (8.85)	
Pressure reducing valve	M14x1.5	20 (14.75)	
Feed pump retaining screw	M6x1	9.8 (7.23)	
Scavenge pump retaining screw	M6x1	9.8 (7.23)	
Head lubricating nozzle	M7x1	2.5 (1.84)	
Valve lift block screw	M5x0.8	9 (6.64)	loctite 270
Water union plate screw	M5x0.8	9 (6.64)	

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		Nm	
Crankshaft stop screw	M8x1.25	22 (16.23)	loctite 270
Freewheel outer ring screws	M6x1	13 (9.58)	loctite 270
Throttle body screws	M6x1	13 (9.58)	loctite 243
Camshaft gear retaining screw	M16x1	35 (25.82)	
Con-rod cap screw	M8x1	15+(48°±50°) 11.06+(48°±50°)	Molicote G-N Plus