



Service Letter

SL04-439/HMH
August 2004

K/L/S-MC/MC-C Engines
Instruction books – Standard Tightening Torques
Action Code: WHEN CONVENIENT

Dear Sirs

During overhauling jobs on the engine, the correct tightening torques must be applied when the engine components are re-assembled.

The instruction books specify the essential tightening torques which are vital for the correct tightening of relevant bolted joints. However, as an assistance to the crew, we have updated the instruction books to include all tightening torques.

We enclose the [procedure \(913-4\)](#) specifying these Standard Tightening Torques, so that the instruction books (Volume II, Chapter 13 - General Tools) already on board ships in service can be updated.

When tightening screws or nuts for which no other torque is specified in the instruction procedure, or the related data sheet, the standard torques specified in this procedure are to be applied.

Questions or comments regarding this SL should be directed to our Dept. 2140.

Yours faithfully
MAN B&W Diesel A/S

Carl-Erik Egeberg

Kjeld Aabo

Encl.: Procedure M91304, ed. 0201

When tightening screws or nuts for which no torque is specified in the instruction procedure or the related data sheet, the standard torques specified in this procedure are to be applied.

1. Standard screws and nuts lubricated with a Molybdenum Disulphide (MoS₂) based lubricant.

Thread	Tightening torque	Thread	Tightening torque
M8	17 Nm	M22	400 Nm
M10	35 Nm	M24	460 Nm
M12	50 Nm	M27	610 Nm
M14	80 Nm	M30	950 Nm
M16	135 Nm	M33	1200 Nm
M18	190 Nm	M36	1650 Nm
M20	260 Nm	M39	2100 Nm

2. Self-locking nuts.

Thread	Tightening torque	Thread	Tightening torque
M8	20 Nm	M22	430 Nm
M10	40 Nm	M24	490 Nm
M12	60 Nm	M27	650 Nm
M14	90 Nm	M30	1000 Nm
M16	150 Nm	M33	1250 Nm
M18	210 Nm	M36	1700 Nm
M20	290 Nm	M39	2200 Nm

3. Screws and nuts locked with glue/Loctite.

Thread	Tightening torque	Thread	Tightening torque
M8	23 Nm	M22	580 Nm
M10	50 Nm	M24	680 Nm
M12	70 Nm	M27	900 Nm
M14	115 Nm	M30	1350 Nm
M16	190 Nm	M33	1700 Nm
M18	270 Nm	M36	2350 Nm
M20	380 Nm	M39	3000 Nm