

SKID-STEER DRUM MULCHER

60"(1524MM) DRUM MULCHER HEAD

SERIAL #29825+

WARRANTY + SERVICE 888.960.0364
PARTS 888.960.0361



DIAMONDMOWERS.COM

TABLE OF CONTENTS

DRUM MULCHER HEAD

DECK ASSEMBLY.....	4
DRIVE ASSEMBLY - 32-45GPM (119-171LPM).....	5
DRIVE ASSEMBLY - 23-31GPM (88-118LPM).....	6
DECK FEED ASSEMBLY - 32-45GPM (119-171LPM).....	7
DECK FEED ASSEMBLY - 23-31GPM (88-118LPM).....	8
DRUM ASSEMBLY - FOUR-POINT STEEL TOOTH.....	9
DRUM ASSEMBLY - TWIN MAUL™ TOOTH.....	10
DECAL ASSEMBLY.....	11

APPENDIX

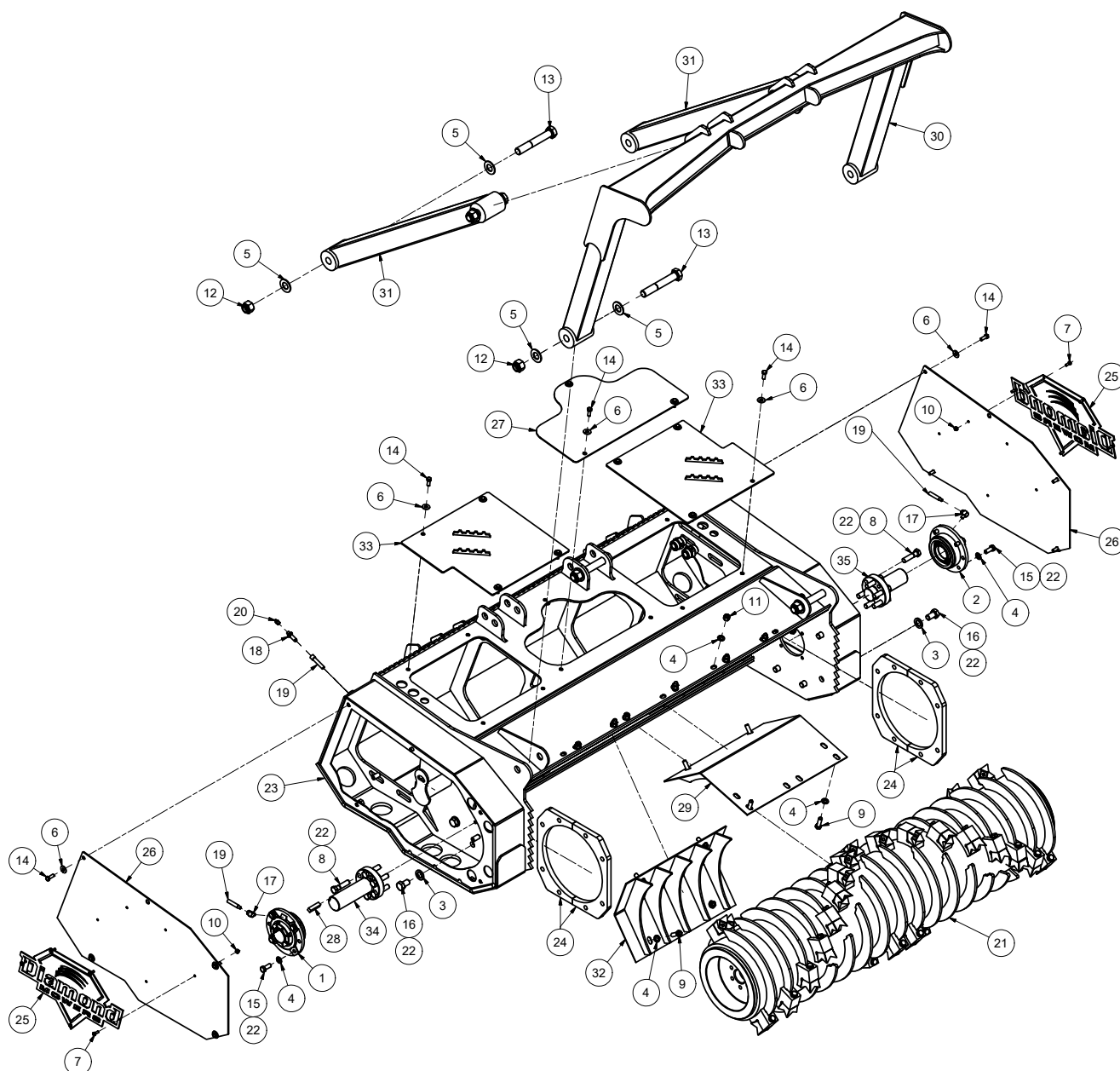
O-RINGS - S.A.E.....	13
S.A.E. TORQUE SPECIFICATIONS.....	14
METRIC TORQUE SPECIFICATIONS.....	14



DRUM MULCHER HEAD

DRUM MULCHER HEAD

DECK ASSEMBLY



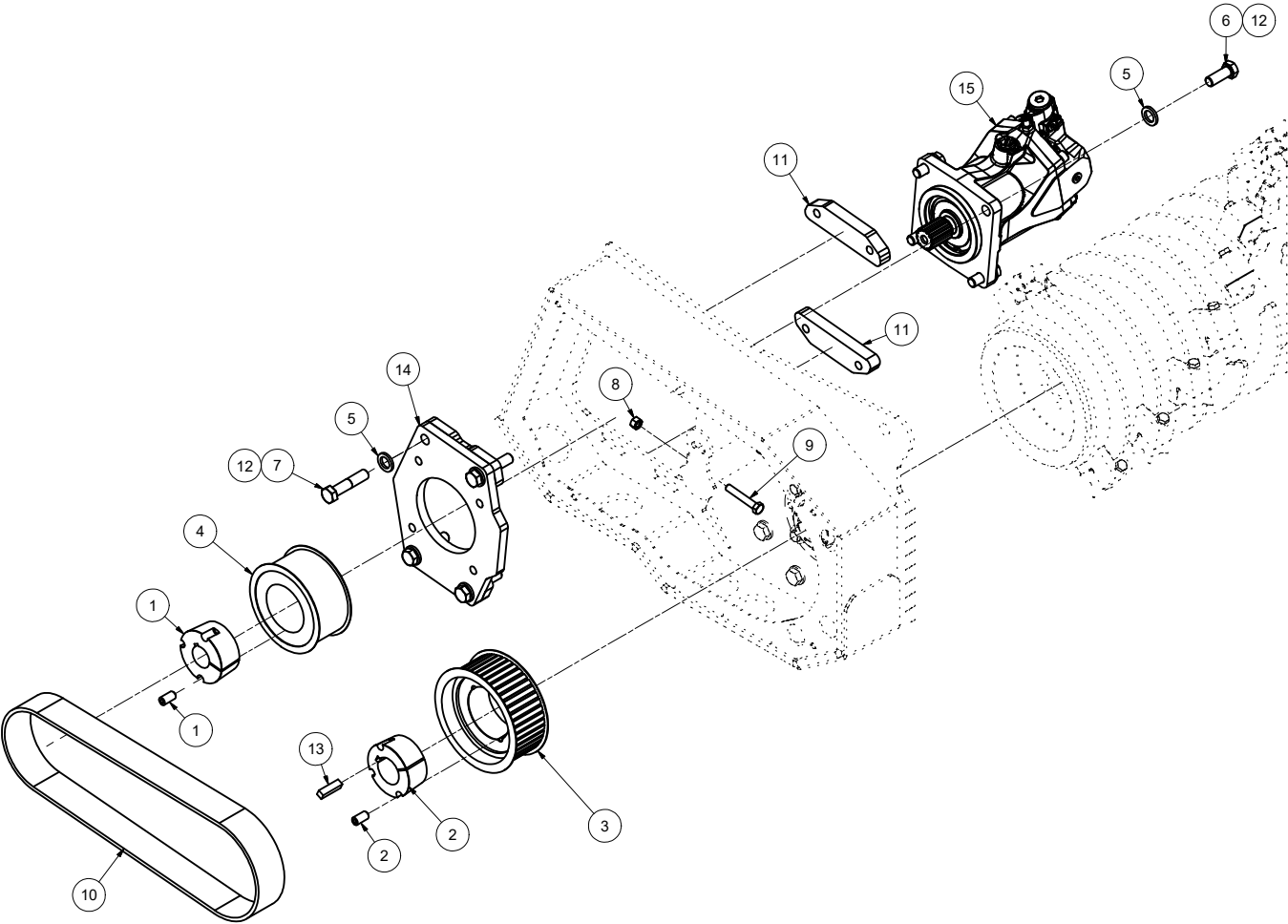
REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	BEARING, DRIVE SIDE, DRUM MULCHER	1	10-0104		
2	BEARING, NON DRIVE, DRUM MULCHER	1	10-0105		
3	3/4 SAE GR 8 FLAT WASHER, YELLOW	16	11-0039		
4	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	38	11-0042		
5	1 SAE FLAT WASHER GR 8	12	11-0056		
6	3/8 THRU-HARDENED FLAT WASHER, YELLOW ZINC	19	11-0092		
7	1/4-20 X 3/4 GR 5 HEX CAP, ZINC	10	11-0588	8.4	11.4
8	5/8-11 X 2-1/2 GR 8 HEX CAP, YELLOW ZINC	12	11-0971	212	287
9	1/2-13 X 1-1/2 GR 8 HEX CAP SCREW, YELLOW ZINC	24	11-0972	106	144
10	1/4-20 GR 2 NYLOCK NUT, ZINC	10	11-1022		
11	1/2-13 GR 8 NYLOCK NUT, ZINC	6	11-1072		
12	1 NC NYLOCK NUT, GR 8	6	11-1082		
13	1-8 X 6-1/2 GR 8 HEX CAP, YELLOW ZINC	6	11-1622	909	1232
14	3/8-16 X 1 GR 8 HEX CAP, YELLOW ZINC	19	11-1624	44	60
15	1/2-13 X 1-1/4 GR 8 HEX CAP, YELLOW ZINC	8	11-2203	106	144
16	3/4-10 X 1-1/4 GR 8 HEX CAP, YELLOW ZINC	16	11-2204	376	510

REF#	PARTS DESCRIPTION	REQ	PART#
17	ELBOW 1/8" X 90	2	21-1104
18	BULKHEAD, 1/8 MP X 1/4 MJIC	2	21-1687
19	GREASE HOSE, 1/8" X 24" (1/8MP X 1/4 FJIC)	2	21-4635
20	GREASE ZERK 1/8" FEM. NPT	2	23-0008
21	60 DRUM ASSEMBLY	1	24-0377
22	LOCTITE 262, .017 OZ (RED)	1	24-0382
23	FDS 060 SHELL WELDMENT	1	25-0248
24	ANTI-WRAP BLOCK, DRUM MULCHER	4	31-0659
25	DIAMOND LOGO CUTOUT	2	31-0670
26	BELT COVER MOUNT, FDS060	2	31-0849
27	ACCESS PLATE, FDS060	1	31-0850
28	KEY 1/2 X 1/2 X 2	1	37-0026
29	UPPER LINER FDS060	3	41-1870
30	PUSH BAR FDS 060	1	41-1871
31	PUSH BAR BRACE TUBE, DRUM MULCHER	2	41-1873
32	LOWER LINER, FDS060	3	41-1886
33	TOP COVER PLATE, FDS060	2	41-1887
34	DRIVE SHAFT, DRUM MULCHER	1	90-7058
35	IDLER SHAFT, DRUM MULCHER	1	90-7059

25-1856-1 Rev 000

DRUM MULCHER HEAD

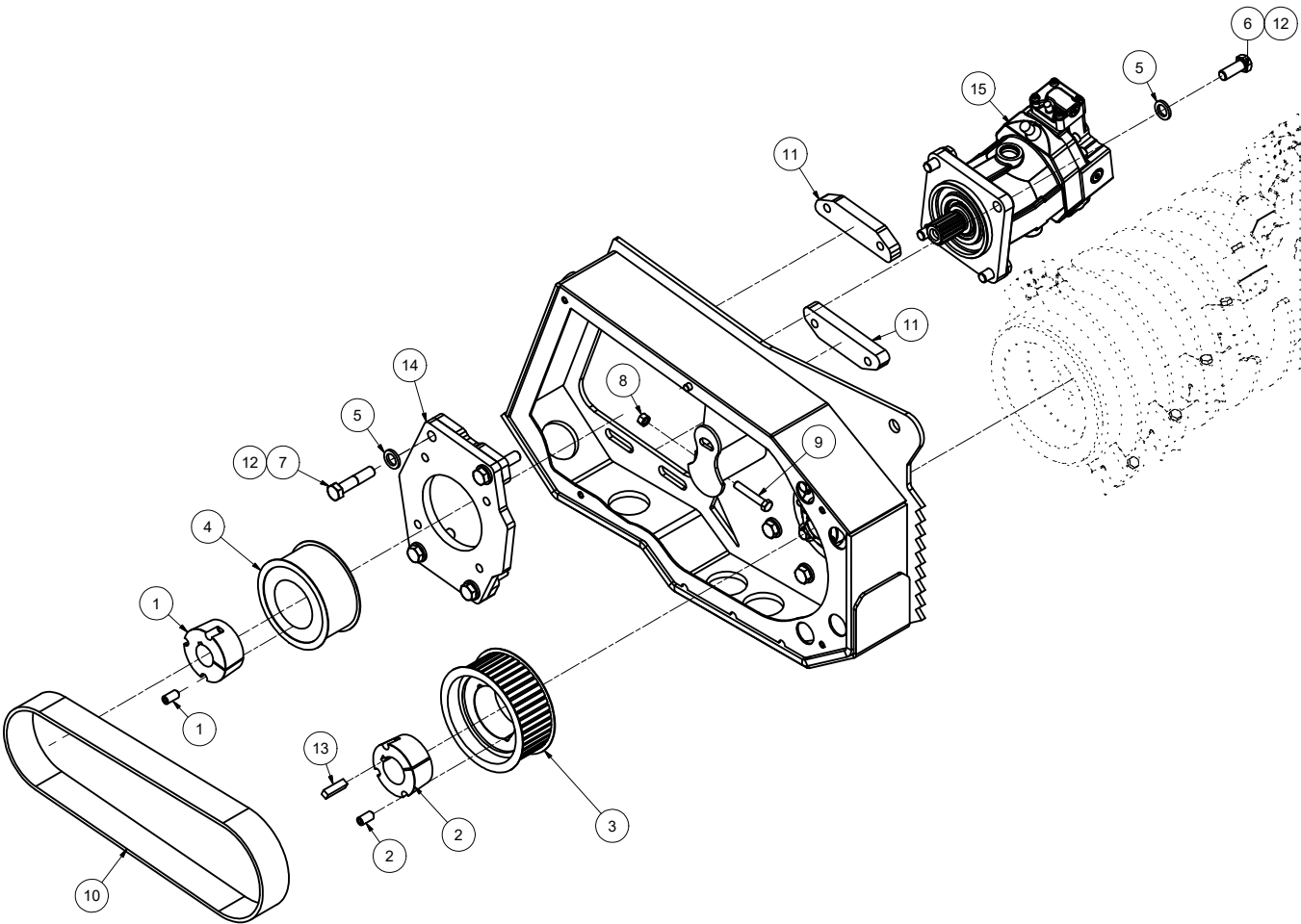
DRIVE ASSEMBLY - 32-45GPM (119-171LPM)



REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	BUSHING, 1-3/4 13T, DRUM MULCHER	1	10-1060	60	81
2	BUSHING, 2-3/16 KEYED, DRUM MULCHER	1	10-1061	60	81
3	PULLEY, 201MM X 85MM, DRUM MULCHER	1	10-1063		
4	PULLEY, 165MM X 85MM, DRUM MULCHER	1	10-1064		
5	3/4 SAE GR 8 FLAT WASHER, YELLOW	8	11-0039		
6	3/4-10 X 2 GR 8 HEX CAP, YELLOW ZINC	4	11-0751	376	510
7	3/4-10 X 3-1/2 GR 8 HEX CAP, YELLOW ZINC	4	11-0792	376	510
8	1/2-13 GR 5 HEX NUT, ZINC	1	11-1016		
9	1/2-13 X 3 GR 8 HEX CAP, YELLOW ZINC FULL THREAD	1	11-2206		
10	BELT, HT500, 68MM X 1568MM, DRUM MULCHER	1	12-0082		
11	MOTOR MOUNT CLAMP PLATE, DRUM MULCHER	2	24-0368		
12	LOCTITE 262, .017 OZ (RED)	1	24-0382		
13	KEY 1/2 X 1/2 X 2	1	37-0026		
14	MOTOR MOUNT, DRUM MULCHER	1	41-1606		
15	MVA115, VARIABLE DISPLACEMENT BENT AXIS PISTON MOTOR	1	30-0576		
	CONTROLLER, MVA115, 3000 PSI CARRIER SETTING		39-1128		
	CONTROLLER, MVA115, 3300 PSI CARRIER SETTING		39-1129		
	CONTROLLER, MVA115, 3500 PSI CARRIER SETTING		39-1130		
	CONTROLLER, MVA115, 4000 PSI CARRIER SETTING		39-1131		

DRUM MULCHER HEAD

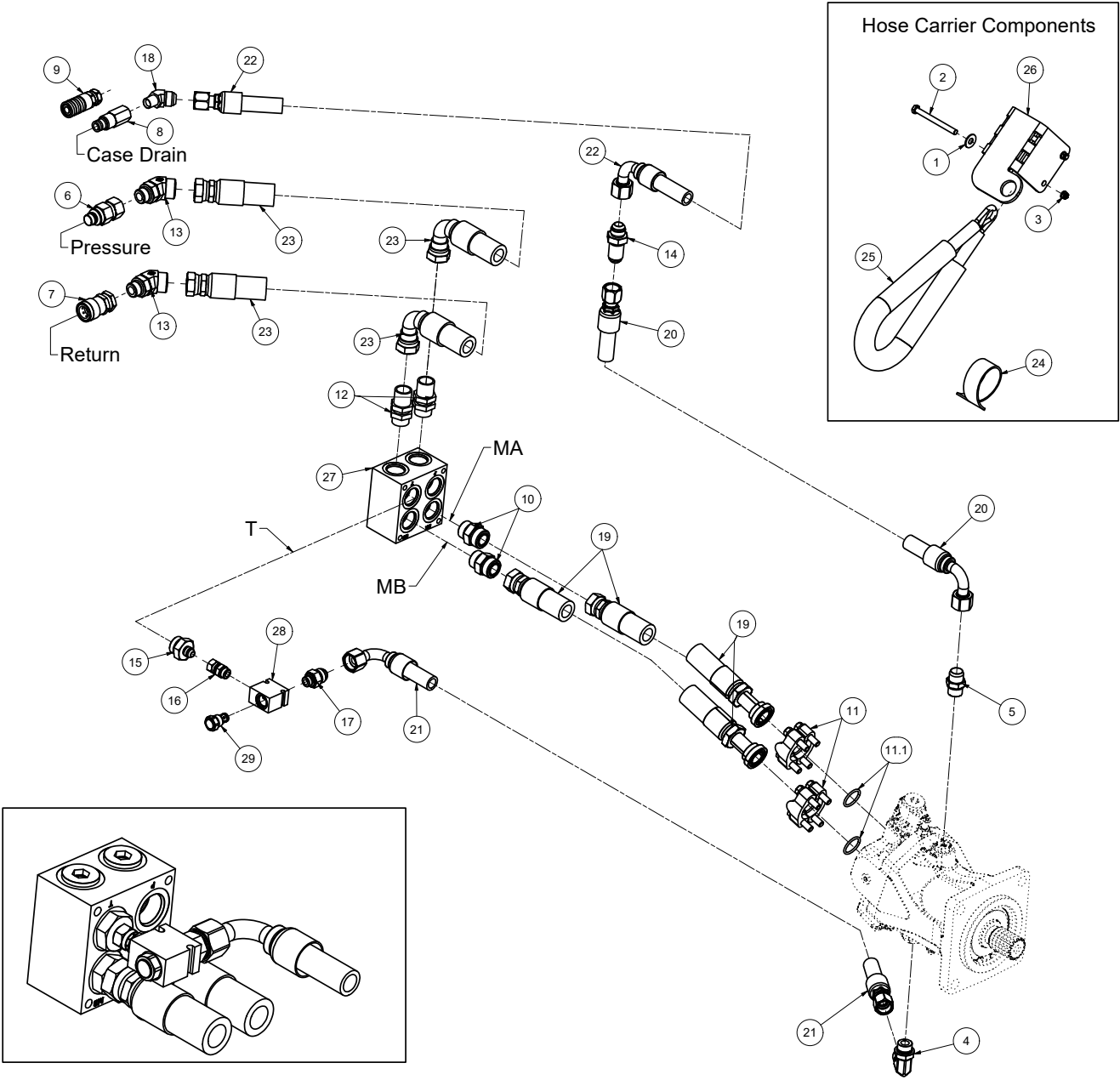
DRIVE ASSEMBLY - 23-31GPM (88-118LPM)



REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	BUSHING, 1-3/4 13T, DRUM MULCHER	1	10-1060	60	81
2	BUSHING, 2-3/16 KEYED, DRUM MULCHER	1	10-1061	60	81
3	PULLEY, 201MM X 85MM, DRUM MULCHER	1	10-1063		
4	PULLEY, 165MM X 85MM, DRUM MULCHER	1	10-1064		
5	3/4 SAE GR 8 FLAT WASHER, YELLOW	8	11-0039		
6	3/4-10 X 2 GR 8 HEX CAP, YELLOW ZINC	4	11-0751	376	510
7	3/4-10 X 3-1/2 GR 8 HEX CAP, YELLOW ZINC	4	11-0792	376	510
8	1/2-13 GR 5 HEX NUT, ZINC	1	11-1016		
9	1/2-13 X 3 GR 8 HEX CAP, YELLOW ZINC FULL THREAD	1	11-2206		
10	BELT, HT500, 68MM X 1568MM, DRUM MULCHER	1	12-0082		
11	MOTOR MOUNT CLAMP PLATE, DRUM MULCHER	2	24-0368		
12	LOCTITE 262, .017 OZ (RED)	1	24-0382		
13	KEY 1/2 X 1/2 X 2	1	37-0026		
14	MOTOR MOUNT, DRUM MULCHER	1	41-1606		
15	VARIABLE DISPLACENT BENT AXIS PISTON MOTOR				
	2400 PSI SETTING SHIFT	1	30-0580		
	2700 PSI SETTING SHIFT	1	30-0581		
	2900 PSI SETTING SHIFT	1	30-0582		
	3500 PSI SETTING SHIFT	1	30-0583		

DRUM MULCHER HEAD

DECK FEED ASSEMBLY - 32-45GPM (119-171LPM)



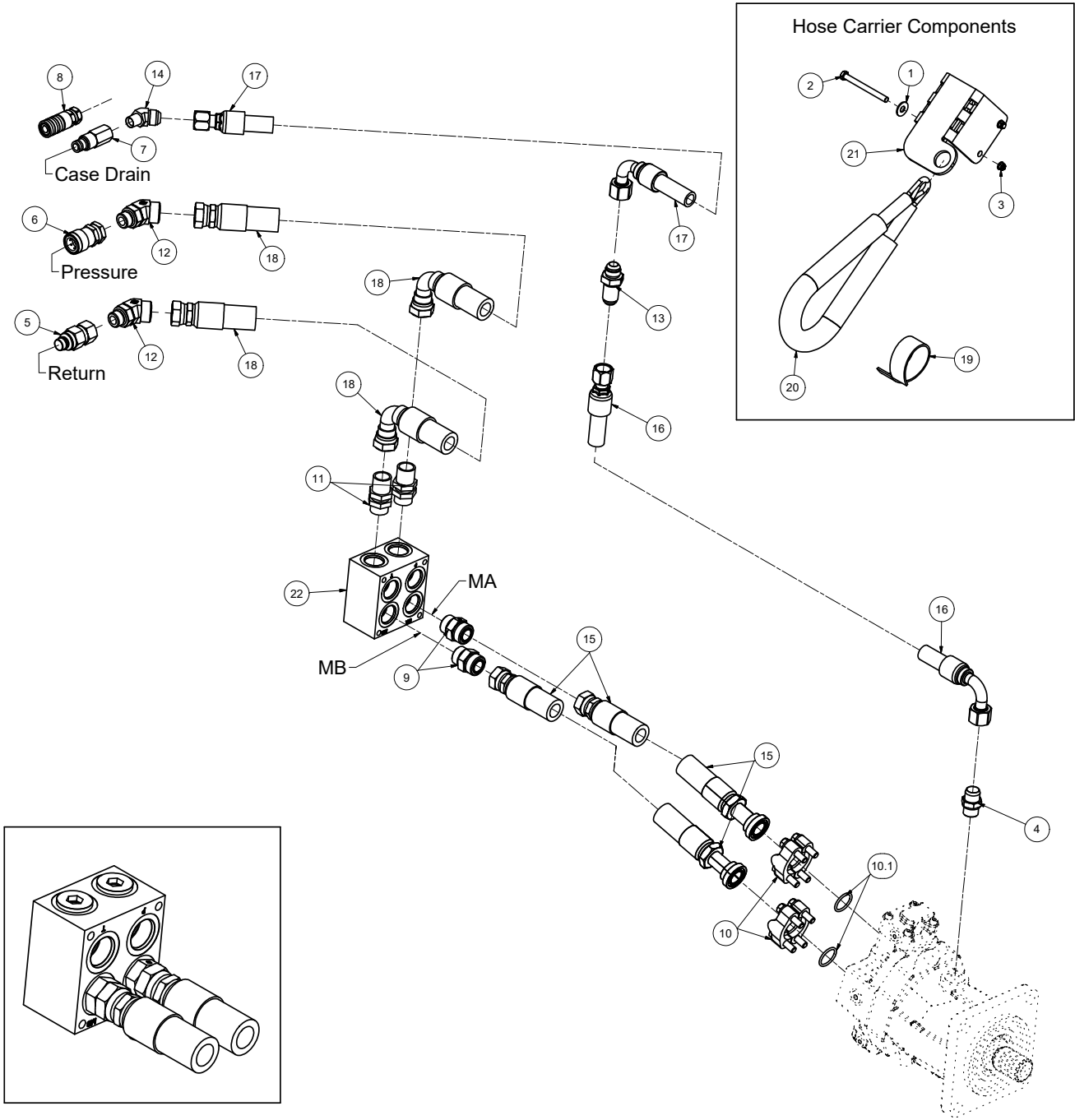
REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	3/8 THRU-HARDENED FLAT WASHER, YELLOW ZINC	2	11-0092		
2	3/8-16 X 4 GR 5 HEX CAP, ZINC	2	11-0581	31	42
3	3/8-16 GR NYLOCK FLANGE NUT, ZINC	2	11-1091		
4	3/4ADJ MOR X 3/4MJIC 90 DEG ADAPTER	1	21-1276		
5	3/4MORB X 3/4MJIC, ADAPTOR	1	21-1475		
6	1/2" MALE QUICK COUPLER X 3/4" SAE, FLAT FACE, NO SPILL	1	21-1559		
7	1/2" FEMALE QUICK COUPLER X 3/4" SAE, FLAT FACE, NO SPILL	1	21-1560		
8	3/8" MALE QUICK COUPLER, FLAT FACE, NO SPILL	1	21-1561		
9	3/8" FEMALE QUICK COUPLER, FLAT FACE, NO SPILL	1	21-1562		
10	-16 MOR X -16 MOFS	2	21-1675		
11	-16 FLANGE KIT, CODE 62	2	21-1677	49	66
11.1	O-RING, CODE 62 FLANGE, -16	2	33-0105		
12	BULKHEAD, -16 MOFS X -16 MORB	2	21-1686		
13	ELBOW, -12 ADJ MOR X -16 MFS, 45 DEG	2	21-1689		
14	BULKHEAD, -12MJIC X -12MJIC	1	21-1709		
15	ADAPTER, 1 MORB X 1/2 MJIC	1	21-1727		
16	ADAPTER, 1/2MORB X 1/2FJIC	1	21-1728		
17	ADAPTER, 1/2MORB X 3/4MJIC	1	21-1729		

25-1856-3 Rev B

REF#	PARTS DESCRIPTION	REQ	PART#
18	ADAPTER 3/4MJIC x 1/2MP -45DEG	1	21-1731
19	HOSE, 1 X 47.5 4000 PSI (-16 CODE 62 FLANGE X -16 FFS)	2	21-4785
20	HOSE, 3/4 X 64.5(-12FJIC 90 DEG X -12 FJIC)	1	21-4786
21	HOSE, 3/4 X 60, 300 PSI (-12 FJIC X -12 FJIC 90 DEG)	1	21-4804
22	HOSE 3/4 x 88, 3000 PSI (3/4FJIC-90DEG x 3/4FJIC)	1	21-4831
23	HOSE, 1 X 88, 4000 PSI (-16 FFS X -16 FFS 90 DEG) KEVLAR	2	21-4832
24	HOSEGUARD 3" SPIRAL / 54"	1	24-0390
25	ELASTIC STRAP WITH CLIPS, 24", 47lb at 60"	1	24-0391
26	BRACKET HOSE SUPPORT	1	31-1063
27	MANIFOLD ANTI-CAVITATION, ATTACHMENT	1	39-0121
28	CHECK BODY, 2 WAY, 1/2 ORB PORTS	1	39-1153
29	CHECK, CARTRIDGE STYLE, 5000 PSI, 16 GPM	1	39-1154
OPTIONAL QUICK COUPLERS			
	5/8" MALE QUICK COUPLER X 3/4 SAE, FLAT FACE		21-1574
	5/8" FEMALE QUICK COUPLER X 3/4 SAE, FLAT FACE		21-1575
	3/4" MALE QUICK COUPLER X 3/4 SAE, FLAT FACE		21-1576
	3/4" FEMALE QUICK COUPLER X 3/4 SAE, FLAT FACE		21-1577

DRUM MULCHER HEAD

DECK FEED ASSEMBLY - 23-31GPM (88-118LPM)

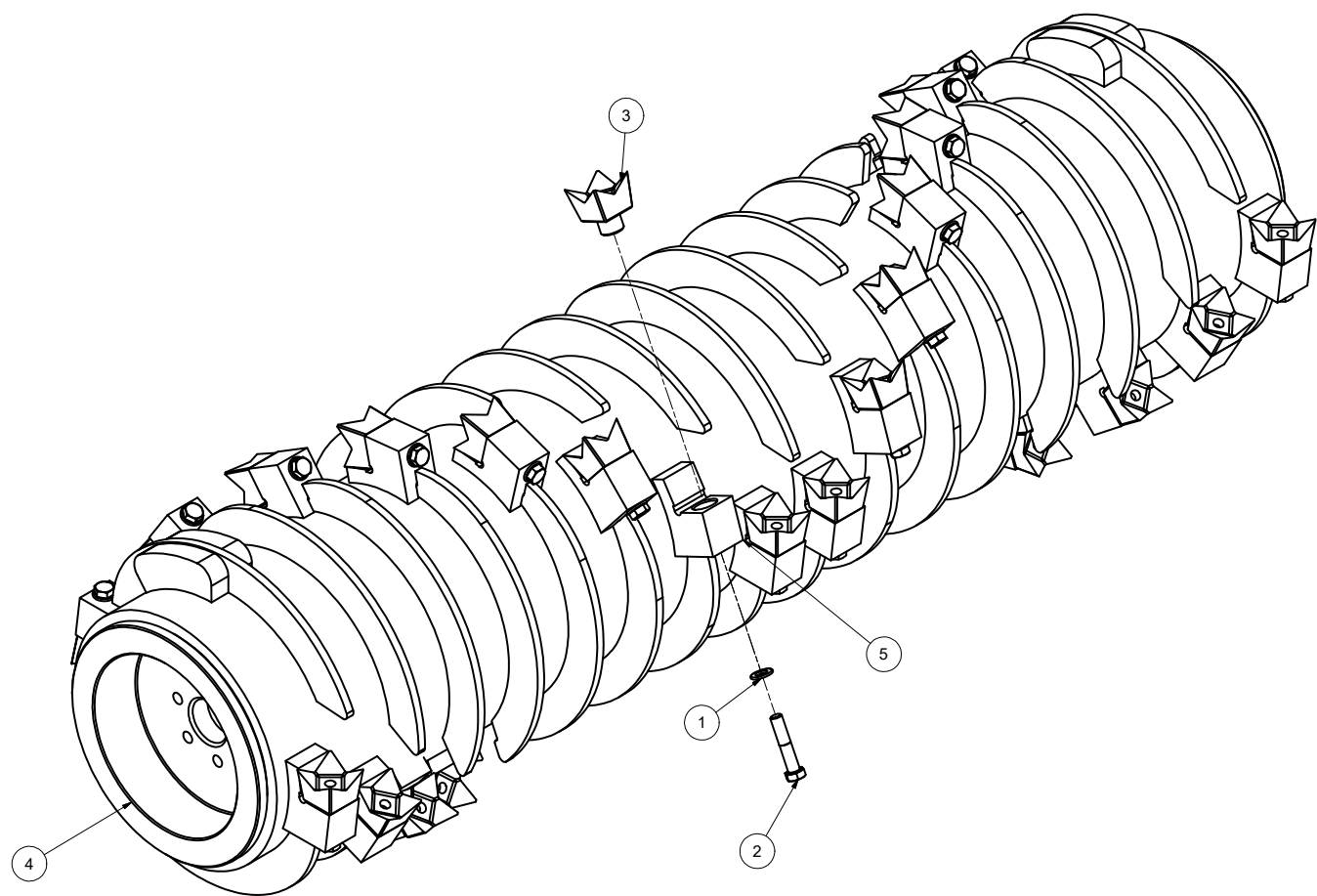


REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	3/8 THRU-HARDENED FLAT WASHER, YELLOW ZINC	2	11-0092		
2	3/8-16 X 4 GR 5 HEX CAP, ZINC	2	11-0581	31	42
3	3/8-16 GR 5 NYLOCK FLANGE NUT, ZINC	2	11-1091		
4	3/4MORB X 3/4MJIC, ADAPTOR	1	21-1475		
5	1/2" MALE QUICK COUPLER X 3/4" SAE, FLAT FACE, NO SPILL	1	21-1559		
6	1/2" FEMALE QUICK COUPLER X 3/4" SAE, FLAT FACE, NO SPILL	1	21-1560		
7	3/8" MALE QUICK COUPLER, FLAT FACE, NO SPILL	1	21-1561		
8	3/8" FEMALE QUICK COUPLER, FLAT FACE, NO SPILL	1	21-1562		
9	-16 MOR X -16 MOFS	2	21-1675		
10	-16 FLANGE KIT, CODE 62	2	21-1677	49	66
10.1	O-RING, CODE 62 FLANGE, -16	2	33-0105		
11	BULKHEAD, -16 MOFS X -16 MORB	2	21-1686		
12	ELBOW, -12 ADJ MOR X -16 MFS, 45 DEG	2	21-1689		

REF#	PARTS DESCRIPTION	REQ	PART#
13	BULKHEAD, -12MJIC X -12MJIC	1	21-1709
14	ADAPTER 3/4MJIC x 1/2MP -45DEG	1	21-1731
15	HOSE, 1 X 47.5 4000 PSI (-16 CODE 62 FLANGE X -16 FFS)	2	21-4785
16	HOSE, 3/4 X 64.5(-12FJIC 90 DEG X -12 FJIC)	1	21-4786
17	HOSE 3/4 x 88, 3000 PSI (3/4FJIC-90DEG x 3/4FJIC)	1	21-4831
18	HOSE, 1 X 88, 4000 PSI (-16 FFS X -16 FFS 90 DEG) KEVLAR	2	21-4832
19	HOSEGUARD 3" SPIRAL / 54"	1	24-0390
20	ELASTIC STRAP WITH CLIPS, 24", 47lb at 60"	1	24-0391
21	BRACKET HOSE SUPPORT	1	31-1063
22	MANIFOLD ANTI-CAVITATION, ATTACHMENT	1	39-0121
OPTIONAL QUICK COUPLERS			
	5/8" MALE QUICK COUPLER X 3/4 SAE, FLAT FACE	1	21-1574
	5/8" FEMALE QUICK COUPLER X 3/4 SAE, FLAT FACE	1	21-1575
	3/4" MALE QUICK COUPLER X 3/4 SAE, FLAT FACE	1	21-1576
	3/4" FEMALE QUICK COUPLER X 3/4 SAE, FLAT FACE	1	21-1577

DRUM MULCHER HEAD

DRUM ASSEMBLY - FOUR-POINT STEEL TOOTH

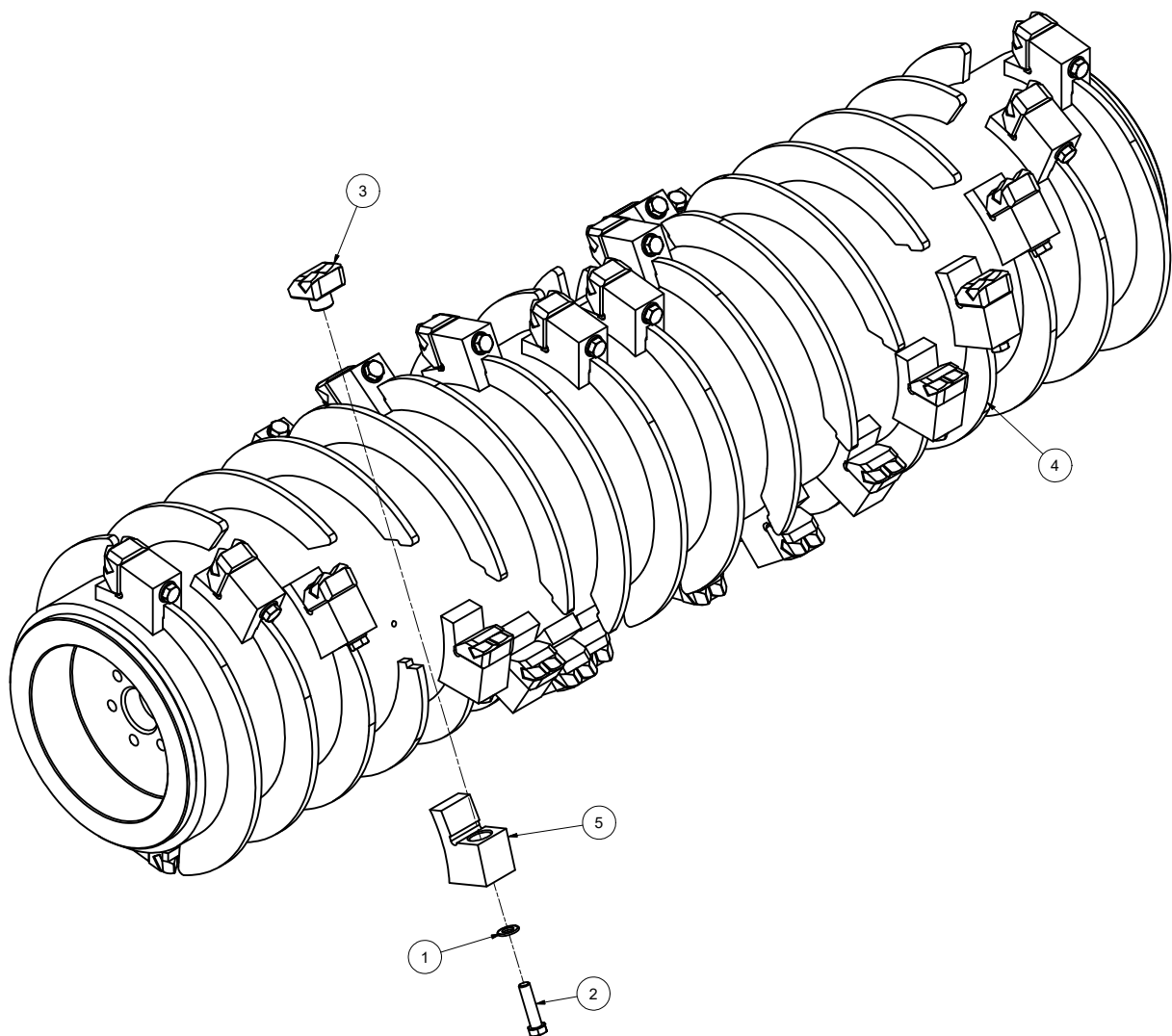


REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	33	11-0042		
2	1/2-20 X 2-1/2 GR 8 HEX CAP, YELLOW ZINC	33	11-1079	120	163
3	TOOTH	33	22-0019		
4	60 DRUM WELDMENT	1	41-1868		
5	TOOTH HOLDER	33	90-7062		

24-0377 Rev 000

DRUM MULCHER HEAD

DRUM ASSEMBLY - TWIN MAUL™ TOOTH

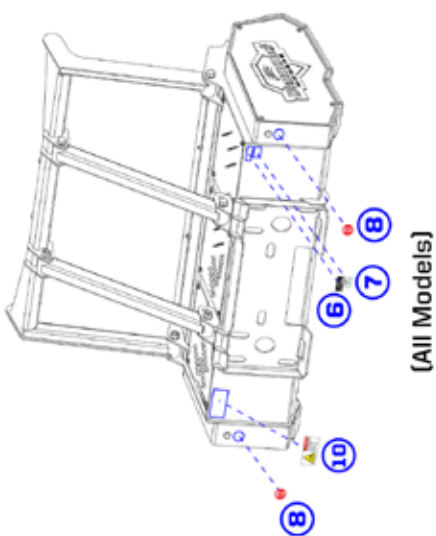
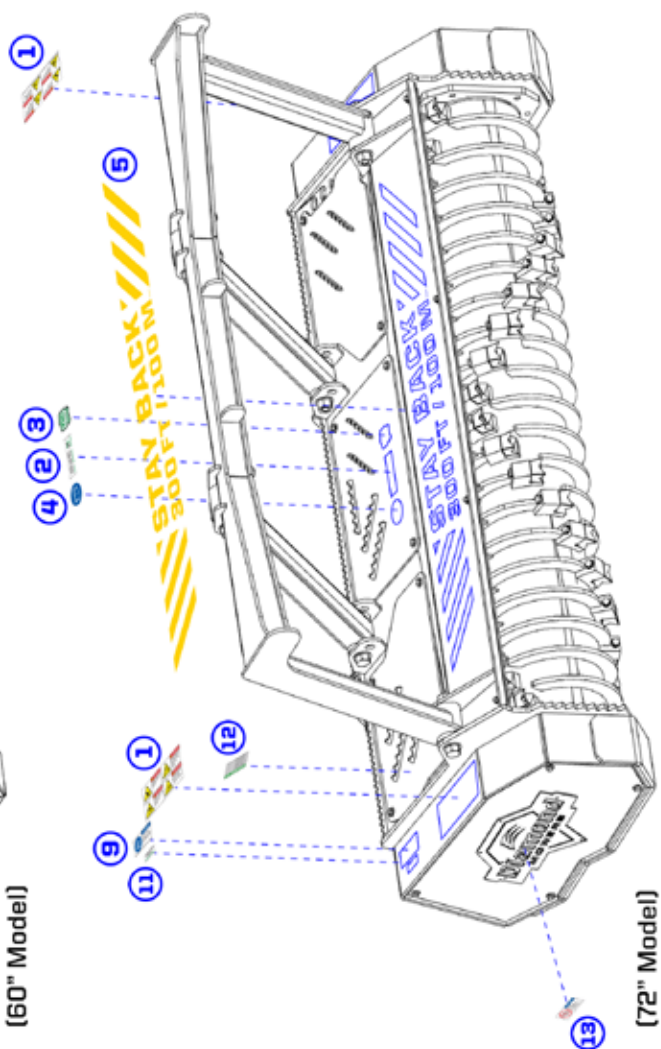
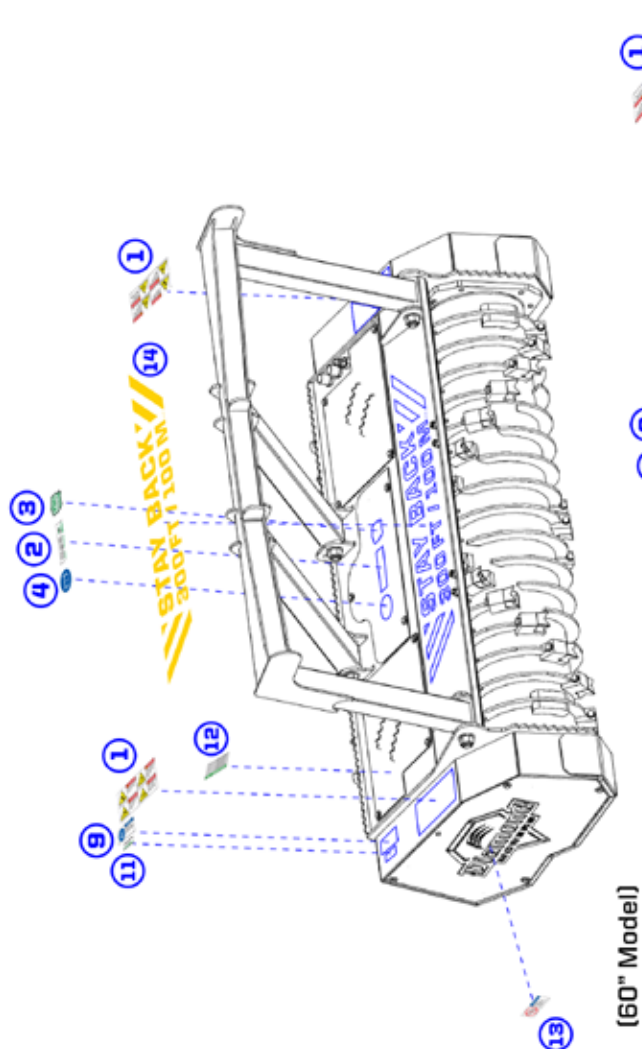


REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)	TORQUE (Nm)
1	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	33	11-0042		
2	1/2-20 X 2 GR 8 HEX CAP, YELLOW ZINC	33	11-0633	120	163
3	ASSY-CARBIDE HOLDER W/TEETH	33	22-0044		
4	FDS060 DRUM WELDMENT	1	41-1868		
5	TOOTH HOLDER, DRUM MULCHER	33	90-7062		

DRUM MULCHER HEAD

DECAL ASSEMBLY

- ① **PART #15-0057** - Decal Group (horizontal) - QTY 2
- ② **PART #15-1018** - Warranty and Service - QTY 1
- ③ **PART #15-0055** - Made in the USA - QTY 1
- ④ **PART #15-0058** - Read Manual - QTY 1
- ⑤ **PART #15-0076** - Stay Back 300ft / 100m (72") - QTY 1
- ⑥ **PART #15-0068** - Patent Denis Cimaf - QTY 1
- ⑦ **SERIAL NUMBER LABEL** - (not included in kit) - QTY 1
- ⑧ **PART #15-0005** - Grease Here - QTY 2
- ⑨ **PART #15-0077** - Variable Displacement Motor Notice - QTY 1
- ⑩ **PART #15-0105** - Safety Polycarbonate Tag - QTY 1
- ⑪ **CARRIER PSI LABEL** - (not included in kit) - QTY 1
- ⑫ **PART #15-0102** - Shift Control Module ID (machine interior) - QTY 1
- ⑬ **PART #15-0114** - Belt Tension Notice (machine interior) - QTY 1
- ⑭ **PART #15-0115** - Stay Back 300ft / 100m (60") - QTY 1



09/2019



APPENDIX

O-RINGS - S.A.E.

ORING (AS568) BOSS FITTINGS [KIT PART# 33-0122] SAE SIZES

STANDARD ORING PART #	HYDRAULIC SIZE	ORING ID SAE (IN)	ORING WIDTH SAE (IN)	ORING MATERIAL
902	-2	0.24	0.06	90-durometer Nitrile
903	-3	0.30	0.06	90-durometer Nitrile
904	-4	0.35	0.07	90-durometer Nitrile
905	-5	0.41	0.07	90-durometer Nitrile
906	-6	0.47	0.08	90-durometer Nitrile
908	-8	0.64	0.09	90-durometer Nitrile
910	-10	0.76	0.1	90-durometer Nitrile
912	-12	0.92	0.12	90-durometer Nitrile
914	-14	1.05	0.12	90-durometer Nitrile
916	-16	1.17	0.12	90-durometer Nitrile
920	-20	1.48	0.12	90-durometer Nitrile
924	-24	1.72	0.12	90-durometer Nitrile
932	-32	2.34	0.12	90-durometer Nitrile

ORING (AS568) FLAT SEAL FITTINGS [KIT PART# 33-0123] SAE SIZES & METRIC SIZES

STANDARD ORING PART #	HYDRAULIC SIZE	END SIZE		ORING ID		ORING WIDTH		ORING MATERIAL
		SAE (IN)	METRIC (MM)	SAE (IN)	METRIC (MM)	SAE (IN)	METRIC (MM)	
011	-4	1/4	6	0.30	7.70	0.07	1.78	90-durometer Nitrile
012	-6	3/8	8, 10	0.36	9.30	0.07	1.78	90-durometer Nitrile
014	-8	1/2	12	0.49	12.40	0.07	1.78	90-durometer Nitrile
016	-10	5/8	14, 15, 16	0.61	15.60	0.07	1.78	90-durometer Nitrile
018	-12	3/4	18, 20	0.74	18.80	0.07	1.78	90-durometer Nitrile
020	-14	7/8	22	0.86	21.80	0.07	1.78	90-durometer Nitrile
021	-16	1	25	0.93	23.50	0.07	1.78	90-durometer Nitrile
025	-20	1 1/4	28, 30, 32	1.18	29.90	0.07	1.78	90-durometer Nitrile
029	-24	1 1/2	35, 38	1.49	37.80	0.07	1.78	90-durometer Nitrile
135	-32	2	50	1.93	49.00	0.10	2.54	90-durometer Nitrile

S.A.E. TORQUE SPECIFICATIONS

Nominal Dia.	threads per inch	Tensile Stress Area		ASTM A307 Grade A				SAE J429 Grade 5				SAE J429 Grade 8				FNL Grade 9		
			Clamp Load (Lbs.)	Tightening Torque			Clamp Load (Lbs.)	Tightening Torque			Clamp Load (Lbs.)	Tightening Torque			Clamp Load (Lbs.)	Tightening Torque		
				K = 0.15	K = 0.17	K = 0.20		K = 0.15	K = 0.17	K = 0.20		K = 0.15	K = 0.17	K = 0.20		K = 0.15	K = 0.17	K = 0.20
(in.)		(sq. in.)	(Lbs.)	K = 0.15	K = 0.17	K = 0.20	(Lbs.)	K = 0.15	K = 0.17	K = 0.20	(Lbs.)	K = 0.15	K = 0.17	K = 0.20	(Lbs.)	K = 0.15	K = 0.17	K = 0.20
Unified Coarse Thread Series																		
1/4	20	0.0318	859	32 in-lbs	37 in-lbs	43 in-lbs	2029	76 in-lbs	86 in-lbs	101 in-lbs	2864	107 in-lbs	122 in-lbs	143 in-lbs	3357	126 in-lbs	143 in-lbs	168 in-lbs
5/16	18	0.0524	1416	66	75	88	3342	157	178	209	4719	221	251	295	5531	259	294	346
3/8	16	0.0775	2092	10 ft-lbs	11 ft-lbs	13 ft-lbs	4940	23 ft-lbs	26 ft-lbs	31 ft-lbs	6974	33 ft-lbs	37 ft-lbs	44 ft-lbs	8174	38 ft-lbs	43 ft-lbs	51 ft-lbs
7/16	14	0.1063	2870	16	18	21	6777	37	42	49	9568	52	59	70	11214	61	70	82
1/2	13	0.1419	3831	24	27	32	9046	57	64	75	12771	80	90	106	14969	94	106	125
9/16	12	0.1819	4912	35	39	46	11599	82	92	109	16375	115	130	154	19193	135	153	180
5/8	11	0.2260	6102	48	54	64	14408	113	128	150	20340	159	180	212	23840	186	211	248
3/4	10	0.3345	9030	85	96	113	21322	200	227	267	30101	282	320	376	35281	331	375	441
7/8	9	0.4617	12467	136	155	182	29436	322	365	429	41556	455	515	606	48707	533	604	710
1	8	0.6057	16355	204	232	273	38616	483	547	644	54517	681	772	909	63899	799	905	1065
1 1/4	7	0.9691	26166	409	463	545	53786	840	952	1121	87220	1363	1545	1817	102229	1597	1810	2130
1 1/2	6	1.4053	37942	711	806	949	77991	1462	1657	1950	126473	2371	2688	3162	148237	2779	3150	3706
Fine Thread Series																		
1/4	28	0.0364	982	37 in-lbs	42 in-lbs	49 in-lbs	2319	87 in-lbs	99 in-lbs	116 in-lbs	3274	123 in-lbs	139 in-lbs	164 in-lbs	3837	144 in-lbs	163 in-lbs	192 in-lbs
5/16	24	0.0581	1568	73	83	98	3702	174	197	231	5226	245	278	327	6125	287	325	383
3/8	24	0.0878	2371	11 ft-lbs	13 ft-lbs	15 ft-lbs	5599	26 ft-lbs	30 ft-lbs	35 ft-lbs	7905	37 ft-lbs	42 ft-lbs	49 ft-lbs	9265	43 ft-lbs	49 ft-lbs	58 ft-lbs
7/16	20	0.1187	3205	18	20	23	7568	41	47	55	10684	58	66	78	12523	68	78	91
1/2	20	0.1600	4319	27	31	36	10197	64	72	85	14396	90	102	120	16873	105	120	141
9/16	18	0.2030	5480	39	44	51	12940	91	103	121	18268	128	146	171	21412	151	171	201
5/8	18	0.2560	6911	54	61	72	16317	127	144	170	23036	180	204	240	27000	211	239	281
3/4	16	0.3730	10070	94	107	126	23776	223	253	297	33566	315	357	420	39343	369	418	492
7/8	14	0.5095	13756	150	171	201	32479	355	403	474	45853	502	568	669	53743	588	666	784
1	14	0.6799	18357	229	260	306	43343	542	614	722	61190	765	867	1020	71720	896	1016	1195
1 1/4	12	1.0729	28970	453	513	604	59548	930	1055	1241	96565	1509	1710	2012	113182	1768	2004	2358
1 1/2	12	1.5810	42688	800	907	1067	87747	1645	1865	2194	142292	2668	3024	3557	166778	3127	3544	4169

The torque values can only be achieved if nut (or tapped hole) has a proof load greater than or equal to the bolt's minimum ultimate tensile strength.

Clamp load calculated as 75% of the proof load when specified by the standard. ASTM A307 utilized 75% of 36,000 PSI.

Torque values for 1/4 and 5/16-in series are in inch-pounds. All other torque values are in foot-pounds.

Torque values calculated from formula $T = KDF$, where

$K = 0.15$ for "lubricated" conditions

$K = 0.17$ for zinc plated and dry conditions; we have also found various forms of customer applied thread lockers to have a similar K value.

$K = 0.20$ for plain and dry conditions

D = Nominal Diameter

F = Clamp Load

Note: When using Zinc Plated (lubricated with wax) Top Lock Nuts, the K value can vary between 0.12-0.16

METRIC TORQUE SPECIFICATIONS

Nominal Dia. (mm)	Pitch	4.6 Class 4.6				8.8 Class 8.8				10.9 Class 10.9				12.9 Class 12.9			
		Tightening Torque				Tightening Torque				Tightening Torque				Tightening Torque			
		Clamp Load (lbs)	Lubricated (ft-lbs)	Zinc Plated (ft-lbs)	Plain&Dry (ft-lbs)	Clamp Load (lbs)	Lubricated (ft-lbs)	Zinc Plated (ft-lbs)	Plain&Dry (ft-lbs)	Clamp Load (lbs)	Lubricated (ft-lbs)	Zinc Plated (ft-lbs)	Plain&Dry (ft-lbs)	Clamp Load (lbs)	Lubricated (ft-lbs)	As-Received (ft-lbs)	Plain&Dry (ft-lbs)
4	0.7	333	0.7	0.7	0.9	858	1.7	1.9	2.3	1228	2.4	2.7	3.2	1436	2.8	3.2	3.8
5	0.8	538	1.3	1.5	1.8	1387	3.4	3.9	4.5	1985	4.9	5.5	6.5	2319	5.7	6.5	7.6
6	1	763	2.3	2.6	3.0	1968	5.8	6.6	7.7	2816	8.3	9.4	11.1	3291	9.7	11.0	13.0
7	1	1095	3.8	4.3	5.0	2822	9.7	11.0	13.0	4039	13.9	15.8	18.5	4720	16.3	18.4	21.7
8	1.25	1389	5.5	6.2	7.3	3580	14.1	16.0	18.8	5123	20.2	22.9	26.9	5987	23.6	26.7	31.4
10	1.5	2200	10.8	12.3	14.4	5671	27.9	31.6	37.2	8115	39.9	45.2	53.2	9484	46.7	52.9	62.2
12	1.75	3197	18.9	21.4	25.2	8240	48.7	55.1	64.9	11792	69.6	78.9	92.8	13781	81.4	92.2	108.5
14	2	4379	30.2	34.2	40.2	11289	77.8	88.1	103.7	16154	111.3	126.1	148.4	18879	130.0	147.4	173.4
16	2	5943	47	53	62	15320	121	137	161	21924	173	196	230	25622	202	229	269
18	2.5	7301	65	73	86	18822	167	189	222	26934	239	270	318	31477	279	316	372
20	2.5	9286	91	104	122	23938	236	267	314	34256	337	382	449	40034	394	446	525
22	2.5	11509	125	141	166	29669	321	364	428	42457	460	521	613	49619	537	609	716
24	3	13372	158	179	211	34471	407	461	543	49329	582	660	777	57649	681	771	908
27	3	17428	232	262	309	44924	597	676	796	64288	854	968	1139	75132	998	1131	1331
30	3.5	21266	314	356	419	54819	809	917	1079	78448	1158	1312	1544	91680	1353	1534	1804
33	3.5	26310	427	484	570	67821	1101	1248	1468	97055	1576	1786	2101	113425	1842	2087	2455
36	4	30982	549	622	732	79866	1415	1603	1886	114291	2024	2294	2699	133569	2366	2681	3154

The torque values can only be achieved if nut (or tapped hole) has a proof load greater than or equal to the bolt's minimum ultimate tensile strength.

Clamp loads estimated as 75% of proof load for specified bolts.

Torque values listed in foot-pounds.

Torque values calculated from formula $T = KDF$ where; $K = 0.15$ for "lubricated" condition, $K = 0.17$ for zinc plated and dry condition (or as-received for the 12.9), $K = 0.20$ for plain and dry condition

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**DEMAND
BRILLIANCE**