

SKID-STEER DISC MULCHER

48"(1219MM) DISC HEAD

DOC #15-1357

SERIAL #30382+

WARRANTY + SERVICE 888.960.0364

PARTS 888.960.0361



DIAMONDMOWERS.COM

TABLE OF CONTENTS

CUTTER ASSEMBLIES

DECK ASSEMBLY.....	4
MOTOR - DECK SUBASSEMBLY.....	6
SPINDLE - DECK SUBASSEMBLY.....	7
CUTTING HEAD - DECK SUBASSEMBLY.....	8
CHAIN GUARD ASSEMBLY.....	10
DECAL ASSEMBLY.....	11

DECK ASSEMBLIES

MOTOR ASSEMBLY - 30-0515.....	13
MOTOR ASSEMBLY - 30-0520.....	14
SPINDLE ASSEMBLY - 35-0204.....	15

APPENDIX

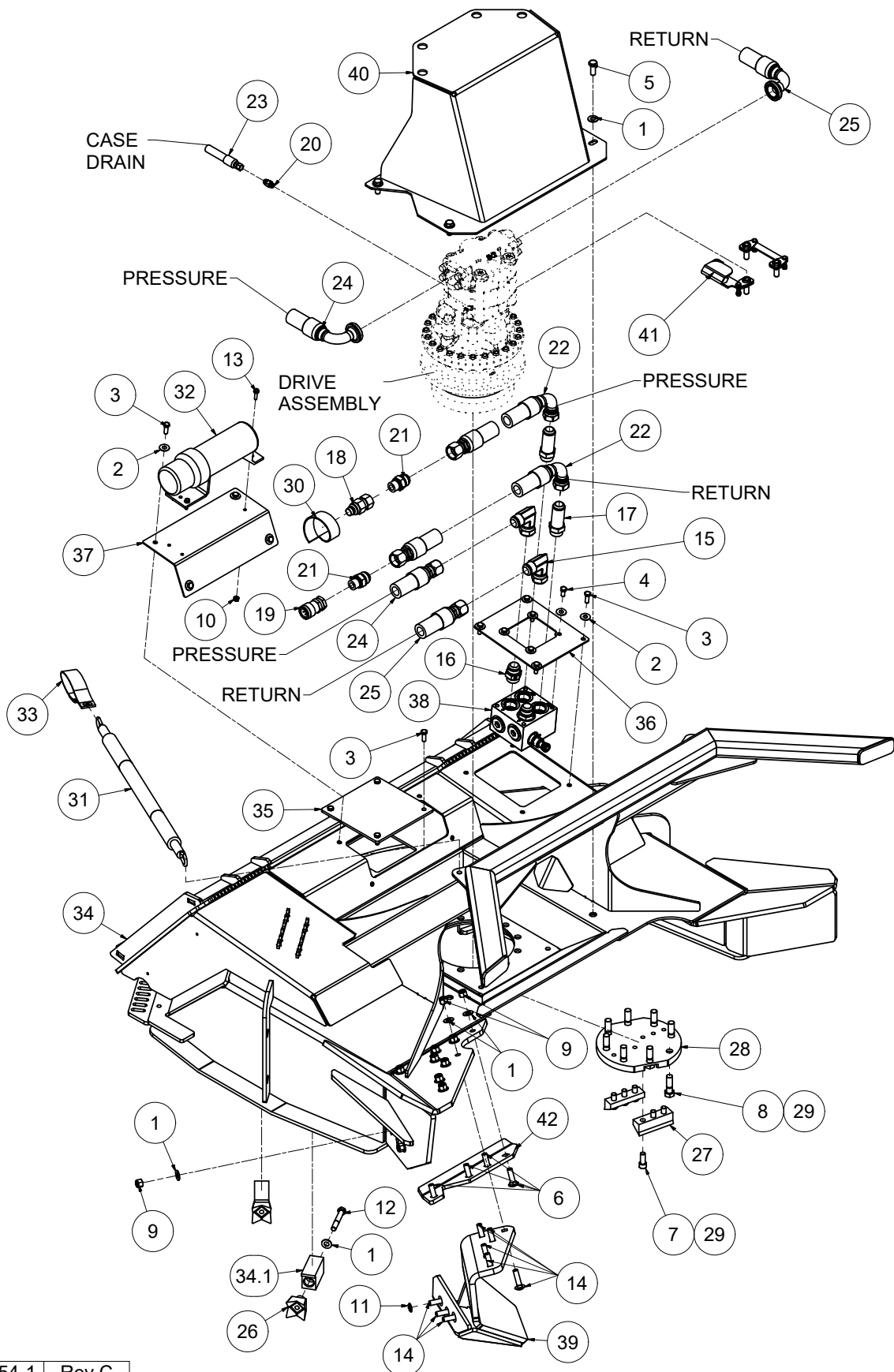
O-RINGS - S.A.E.....	17
S.A.E. TORQUE SPECIFICATIONS.....	18
METRIC TORQUE SPECIFICATIONS.....	18



CUTTER ASSEMBLIES

CUTTER ASSEMBLIES

DECK ASSEMBLY



25-1954-1 Rev C

CUTTER ASSEMBLIES

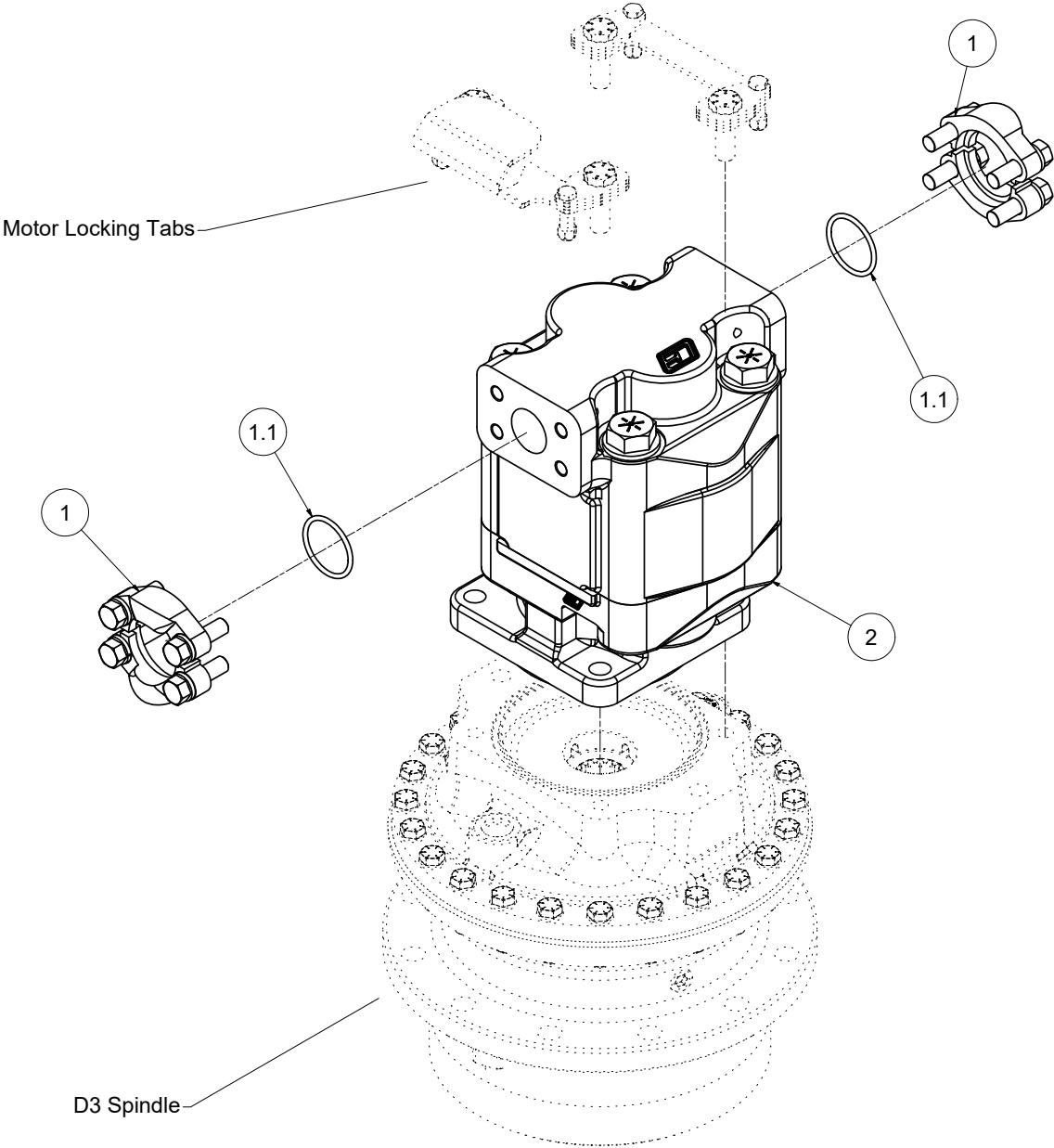
DECK ASSEMBLY

REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)
1	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	18	11-0042	
2	3/8 THRU-HARDENED FLAT WASHER, YELLOW ZINC	16	11-0092	
3	3/8-16 X 1 GR 5 HEX CAP, ZINC	12	11-0532	31
4	3/8-16 X 3/4 GR 5 HEX CAP, ZINC	4	11-0545	31
5	1/2-13 X 1-1/4 GR 5 HEX CAP, ZINC	4	11-0570	75
6	1/2-13 X 1-3/4 GR 8 CARRIAGE BOLT, PLAIN	4	11-0961	
7	1/2-13 X 1-1/4 ASTM A574 SOCKET CAP, BLACK OXIDE	6	11-0965	124
8	5/8-11 X 2-1/2 GR 8 HEX CAP, YELLOW ZINC	8	11-0971	**212
9	1/2-13 GR 8 NYLOCK NUT, ZINC	12	11-1072	
10	1/4-20 GR 5 NYLOCK FLANGE NUT, ZINC	3	11-1090	
11	1/2 PUSH NUT, BOLT RETENTION, ZINC	3	11-1665	
12	1/2-20 X 3-1/4 GR 8 HEX CAP, YELLOW ZINC	2	11-1666	120
13	1/4-20 X 1 GR 5 HEX FLANGE BOLT, ZINC	3	11-2210	8.5
14	1/2-13 x 2 GR 8 CARRIAGE BOLT, YELLOW ZINC	8	11-2226	
15	ELBOW 1MJ X 1FJX-90DEG	2	21-1004	
16	1MOR X 1MJIC, ADAPTER	2	21-1005	
17	1MOR X 1MJIC ADAPTER, LONG	2	21-1457	
18	1/2" MALE QUICK COUPLER X 3/4" SAE, FLAT FACE	1	21-1559	
19	1/2" FEMALE QUICK COUPLER X 3/4" SAE, FLAT FACE	1	21-1560	
20	ADAPTER, 1/4MOR X 3/8MJIC	1	21-1597	
21	1MJIC X 3/4 MORB ADAPTER	2	21-1602	
22	HOSE 1 X 84 (1FJIC-90DEG X 1FJIC)	2	21-3645	
23	HOSE 3/8 X 118 (3/8FJIC X 1/2MP) KEVLAR	1	21-4613	
24	HOSE, 1 X 33 (20 FLG 90 DEG X 1 FJIC)	1	21-4934	
25	HOSE, 1 X 21 (20 FLG 90 DEG X 1 FJIC)	1	21-4935	
26	FOUR-POINT HARDENED STEEL TOOTH	2	22-0019	
27	FBC, CENTER PLANER	2	24-0192	
28	BOLT PROTECTOR, FBS, D3 SPINDLE	1	24-0224	
29	LOCTITE 262, .017 OZ (RED)	1	24-0382	
30	HOSEGUARD 3" SPIRAL / 54"	1	24-0390	
31	ELASTIC STRAP WITH CLIPS, 24", 47lb at 60"	1	24-0391	
32	LARGE MANUAL CANISTER, 12" X 3.25"	1	24-0397	
33	HANGING STRAP - ADJ 10-12"	1	24-0427	
34	FBS048 GEN 4, DECK SHELL	1	25-0346	
34.1	DECK TOOTH HOLDER	2	90-7076	
35	60 SKID FBC ACCESS PORT COVER	1	31-0455	
36	MANIFOLD CUTOUT ACCESS PLATE	1	31-1055	
37	FBS048 COVER PLATE	1	31-1058	
38	MANIFOLD, ANTI-CAVITATION ATTACHMENT			
	OPTION A, 30-37 GPM (3050 PSI RELIEF)	1	39-0123	
	OPTION B, 23-29 GPM (3300 PSI RELIEF)	1	39-0124	
39	FBS 48 GEN 4 CHUTE	1	41-1927	
40	MOTOR GUARD, D3 FBS	1	41-1928	
41	MOTOR HARDWARE LOCK KIT	1	44-0916	
42	THROAT PLATE 80%	1	91-0032	

** CRITICAL TORQUE VALUES **MUST** BE FOLLOWED.

CUTTER ASSEMBLIES

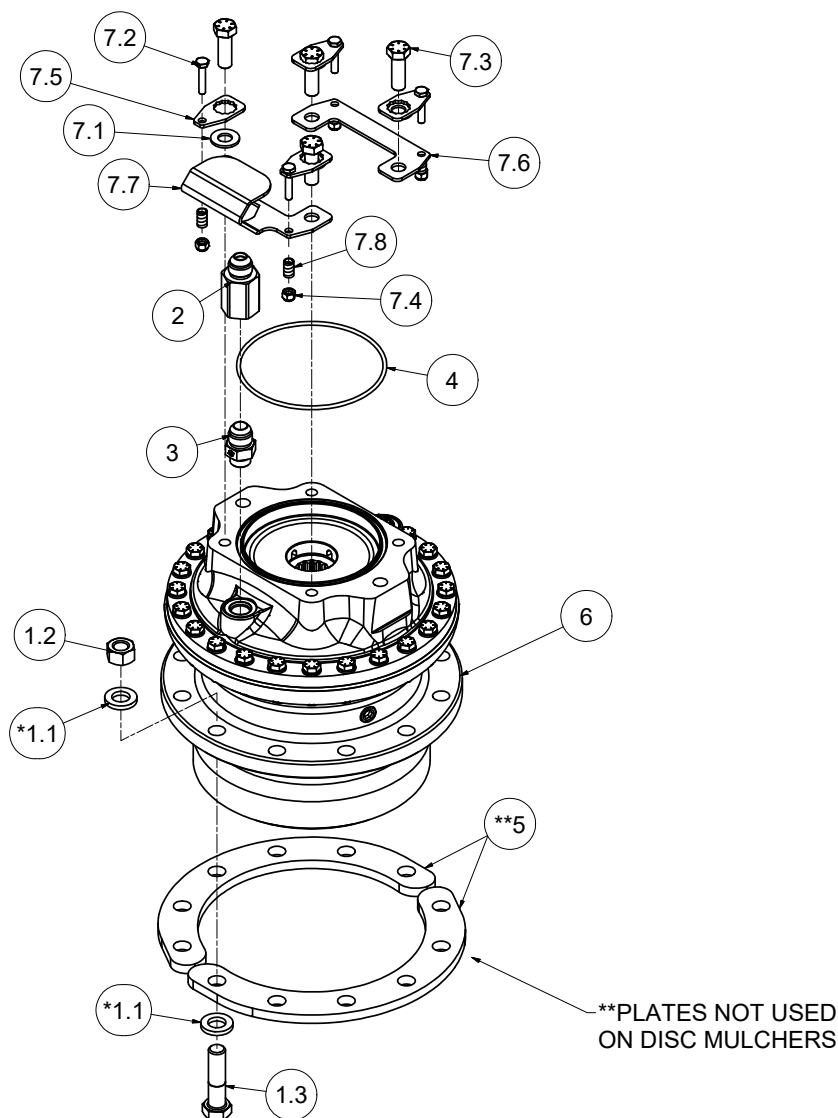
MOTOR - DECK SUBASSEMBLY



REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)
1	#20 FLANGE KIT	2	21-2105	49
1.1	O-RING, #20 FLANGE	2	33-0013	
2	MOTOR	1		
	48" SKID LOADER MOTORS:			
	M365 1-1/2" GEAR 14 SPLINE MOTOR		30-0515	
	23-29 GPM (87-110 LPM)			
	M365, 1-3/4" GEAR, 1-1/4 14 SPLINE SHAFT		30-0520	
	30-37 GPM (114-140 LPM)			
	60" SKID LOADER MOTOR:			
	M365, 2-1/4" GEAR, 1-1/4 14 SPLINE SHAFT		30-0524	
	32-45 GPM (121-170 LPM)			

CUTTER ASSEMBLIES

SPINDLE - DECK SUBASSEMBLY



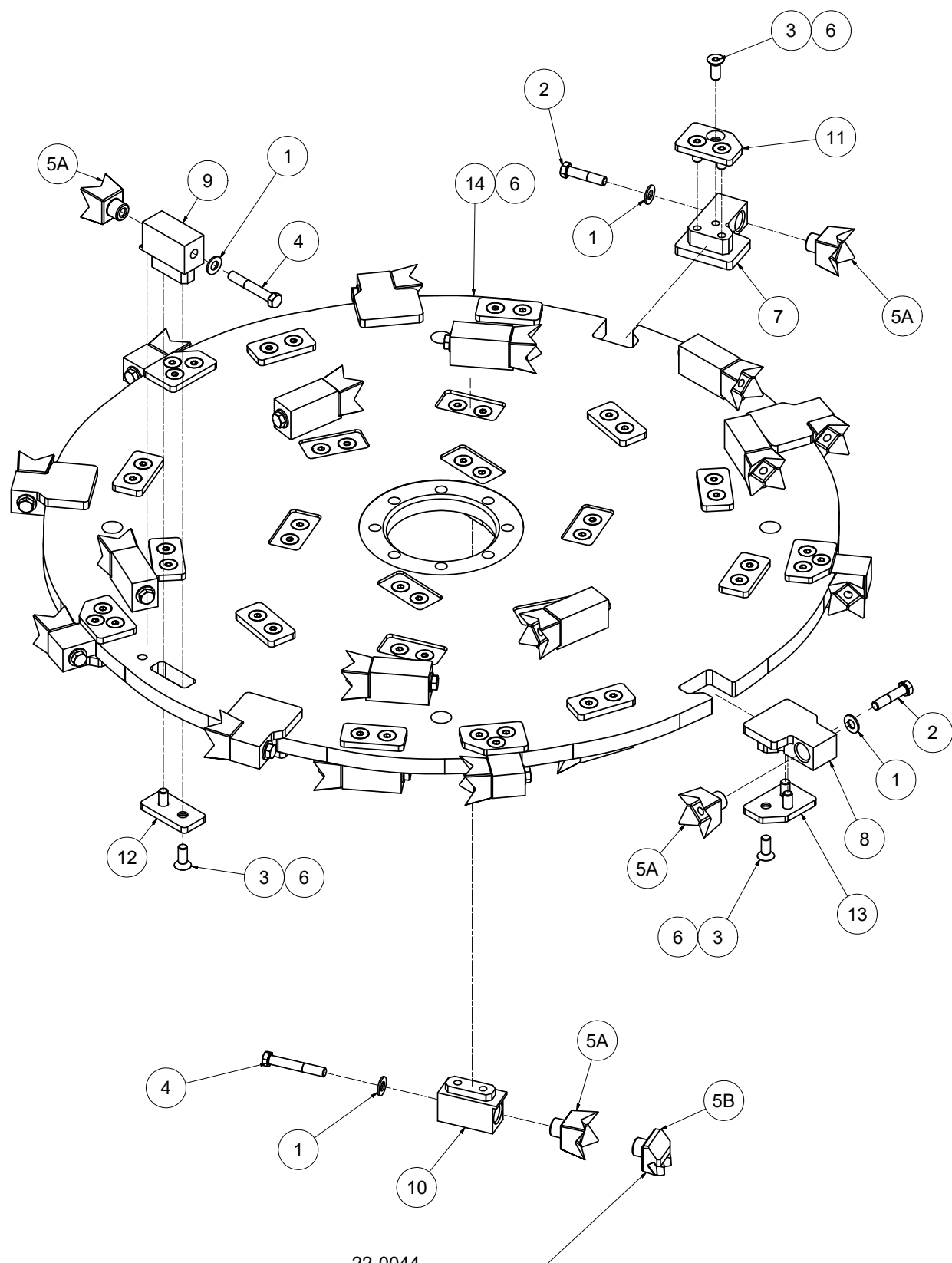
REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)
1	BOLT KIT - 1/2" SPINDLE (FBS/DBR) SHELL	1	11-3624	
*1.1	M16 DIN EN 14399 THRU-HARDENED FW, ECOGUARD	24	11-0102	
1.2	5/8-11 GR 8 HEX NUT, ECOGUARD	12	11-1166	
1.3	5/8-11 X 2.5 GR 8 HEX CAP, ECOGUARD	12	11-2233	150
2	RELIEF VALVE, D3 SPINDLE	1	21-1653	
3	5/8MJIC X 1/2MORB	1	21-1706	
4	O-RING, D3 SPINDLE	1	24-0305	
**5	LOWER BOLT PLATE, D3	2	31-0893	
6	SPINDLE-D3 DIRECT DRIVE SAE C	1	35-0204	
7	MOTOR HARDWARE LOCK KIT	1	44-0916	
7.1	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	4	11-0042	
7.2	1/4-20 X 1-1/4 GR 5 HEX CAP, ZINC	4	11-0702	8.5
7.3	1/2-13 X 1-1/2 GR 8 HEX CAP SCREW, YELLOW ZINC	4	11-0972	90
7.4	1/4-20 GR 5 NYLOCK NUT, ZINC	4	11-1022	
7.5	MOTOR BOLT LOCK TAB	4	31-0503	
7.6	V3LOCK BOTTOM	1	31-0504	
7.7	MOTOR LOCKING BASE WITH PRV PROTECTION	1	31-0824	
7.8	BOLT LOCKING TAB SPRING	4	36-0013	

* NOTE: FLAT SIDE OF WASHERS TOWARDS HARDWARE.
CHAMFER SIDE TOWARDS SPINDLE & DECK.

35-0204-1 Rev 000

CUTTER ASSEMBLIES

CUTTING HEAD - DECK SUBASSEMBLY



22-0044
OPTION ONLY
AVAILABLE ON
BOTTOM OF DISK

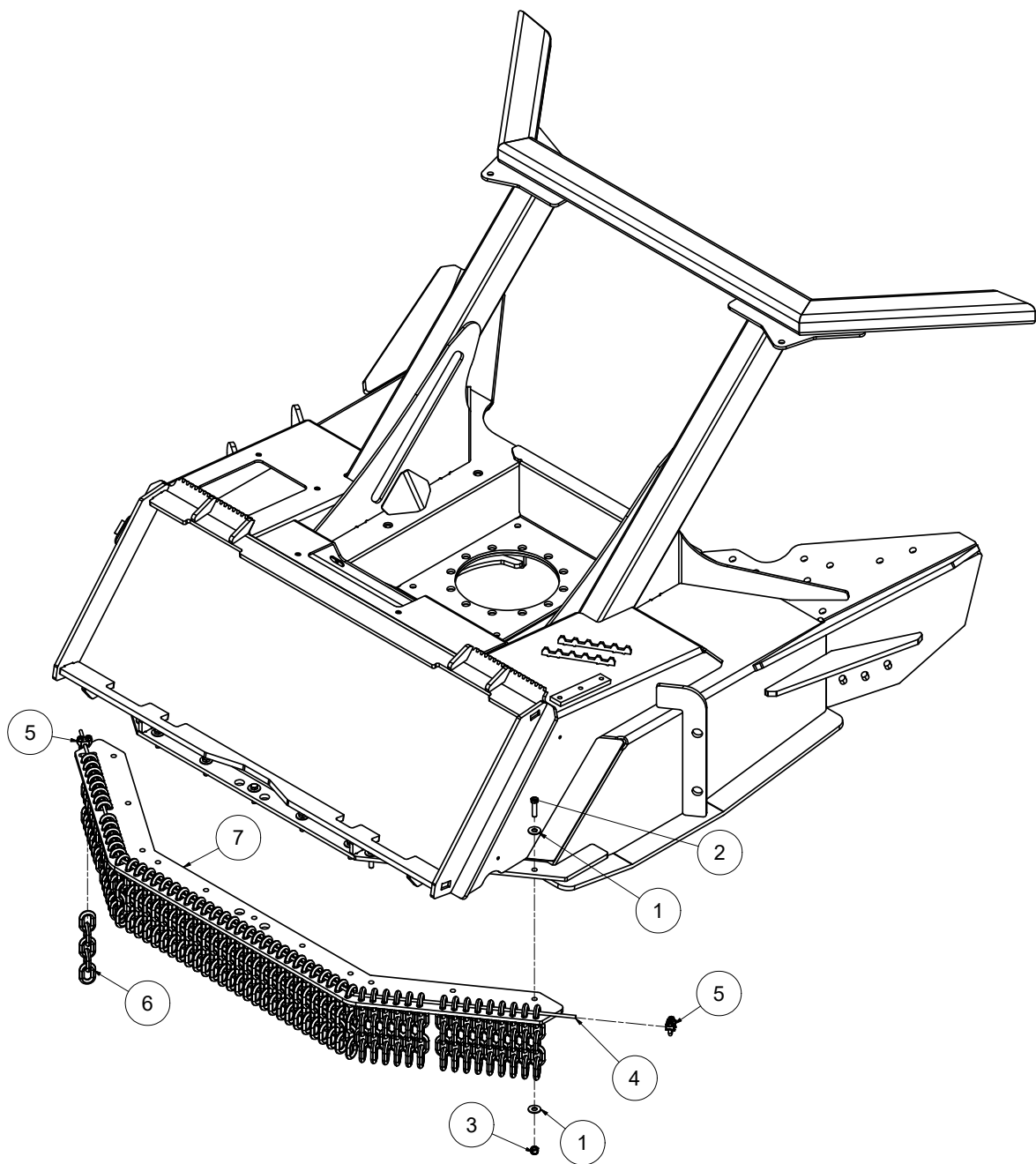
CUTTER ASSEMBLIES

CUTTING HEAD - DECK SUBASSEMBLY

REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)
1	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	36	11-0042	
2	1/2-20 X 2-1/4 GR 8 HEX CAP, YELLOW ZINC	10	11-0660	120
3	1/2-13 X 1-1/4 ASTM F835 FLAT SOCKET CAP SCREW	82	11-1178	110
4	1/2-20 X 3-1/4 GR 8 HEX CAP, YELLOW ZINC	26	11-1666	120
5A	FOUR-POINT HARDENED STEEL TOOTH	36	22-0019	
5B	TWIN MAUL® CARBIDE TOOTH	15	22-0044	
6	LOCTITE 277, 10ML	2	24-0309	
7	OUTER TOOTH HOLDER	5	90-7054	
8	OUTER TOOTH HOLDER CC	5	90-7070	
9	MIDDLE TOOTH HOLDER W-O COUNTERSINK	18	90-7073	
10	INNER TOOTH HOLDER W-O COUNTERSINK	8	90-7074	
11	OUTER TOOTH HOLDER COVER	5	P24-0270-12	
12	COVER	26	P24-0270-13	
13	OUTER TOOTH COVER	5	P24-0310-12	
14	D3 48" FBE WELD FREE DISC BLANK	1	P24-0384-11	
	TOOTH KIT - 20 TEETH, NO HARDWARE	1	44-0830	
	FOUR-POINT HARDENED STEEL TOOTH	20	22-0019	
	TOOTH KIT - 50 TEETH, NO HARDWARE	1	44-0831	
	FOUR-POINT HARDENED STEEL TOOTH	50	22-0019	
	OUTER BOTTOM TOOTH HOLDER KIT	1	44-0835	
	1/2-13 X 1-1/4 ASTM F835 FLAT SOCKET CAP SCREW	3	11-1178	110
	OUTER TOOTH HOLDER - BOLT ON	1	90-7054	
	OUTER TOOTH HOLDER COVER	1	P24-270-12	
	OUTER TOP TOOTH HOLDER KIT	1	44-0960	
	1/2-13 X 1-1/4 ASTM F835 FLAT SOCKET CAP SCREW	3	11-1178	110
	OUTER TOOTH HOLDER - BOLT ON	1	90-7070	
	OUTER TOOTH HOLDER COVER	1	P24-0310-12	
	MIDDLE TOOTH HOLDER KIT	1	44-0862	
	1/2-13 X 1-1/4 ASTM F835 FLAT SOCKET CAP SCREW	2	11-1178	110
	MIDDLE TOOTH HOLDER W-O COUNTERSINK	1	90-7073	
	COVER	1	P24-0270-13	
	INNER TOOTH HOLDER KIT	1	44-0863	
	1/2-13 X 1-1/4 ASTM F835 FLAT SOCKET CAP SCREW	2	11-1167	
	INNER TOOTH HOLDER W-O COUNTERSINK	1	90-7074	
	COVER	1	P24-0270-13	
	TOOTH KIT - FOUR-POINT FBS048	1	44-0956	
	1/2 X 2-1/4 H.S. NF HEX CAP	10	11-0660	120
	1/2-20 X 3-1/4 GR 8 HEX CAP, YELLOW ZINC	28	11-1666	120
	1/2 SAE FLAT WASHER GR 8,	38	11-0042	
	FOUR-POINT HARDENED STEEL TOOTH	38	22-0019	
	TOOTH KIT - TWIN MAUL® FBS048	1	44-0944	
	1/2 X 1.062 GR 8 SAE FLAT WASHER, YELLOW ZINC	15	11-0042	
	1/2-20 X 3-1/4 GR 8 HEX CAP, YELLOW ZINC	15	11-1666	120
	TWIN MAUL® CARBIDE TOOTH	15	22-0044	

CUTTER ASSEMBLIES

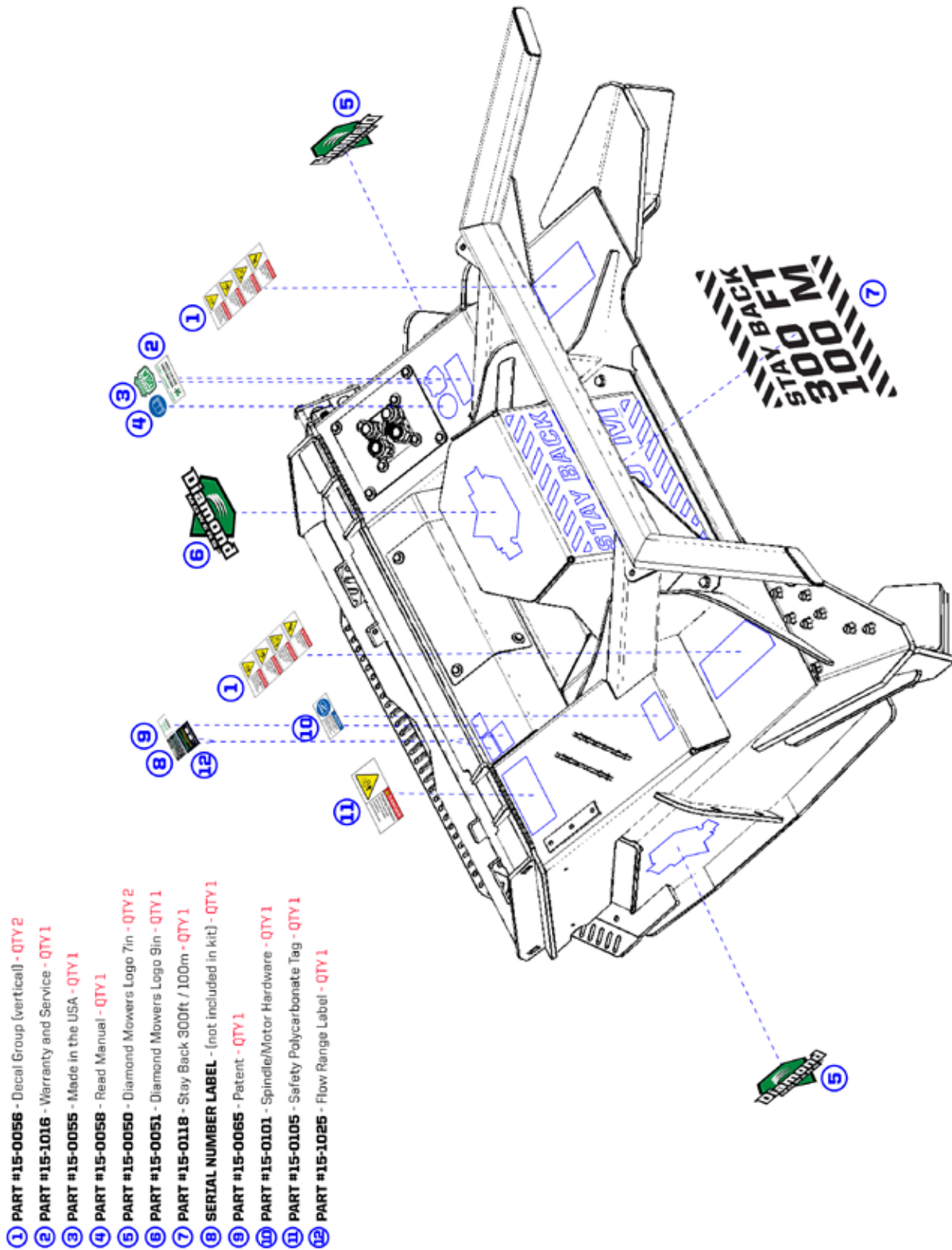
CHAIN GUARD ASSEMBLY



REF#	PARTS DESCRIPTION	REQ	PART#	TORQUE (ft-lbs)
1	3/8 THRU-HARDENED FLAT WASHER, YELLOW ZINC	22	11-0092	
2	3/8-16 X 1-1/2 GR 5 HEX CAP, ZINC	11	11-0529	31
3	3/8-16 GR 2 NYLOCK NUT, ZINC	11	11-1024	
4	1/4" GALVANIZED CABLE 7,000 LBS TENSILE (SOLD/FT)	11	12-0032	
5	1/4" WIRE ROPE CLAMP	2	12-0033	
6	3/8" CHAIN - 5 LINKS	58	12-0047	
7	FBS048 CHAIN GUARD	1	31-1056	

DECAL ASSEMBLY

1220740

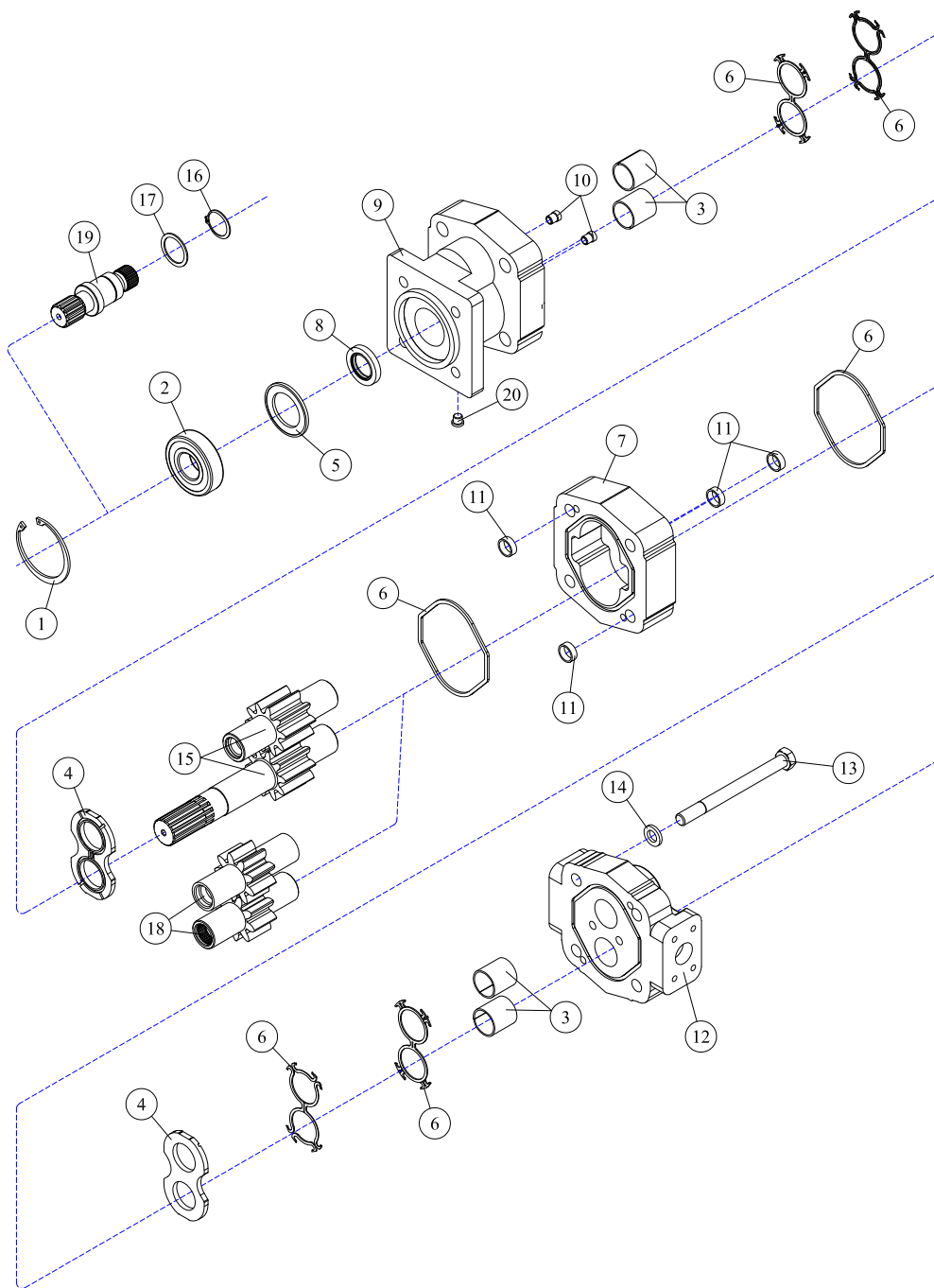




DECK ASSEMBLIES

DECK ASSEMBLIES

MOTOR ASSEMBLY - 30-0515

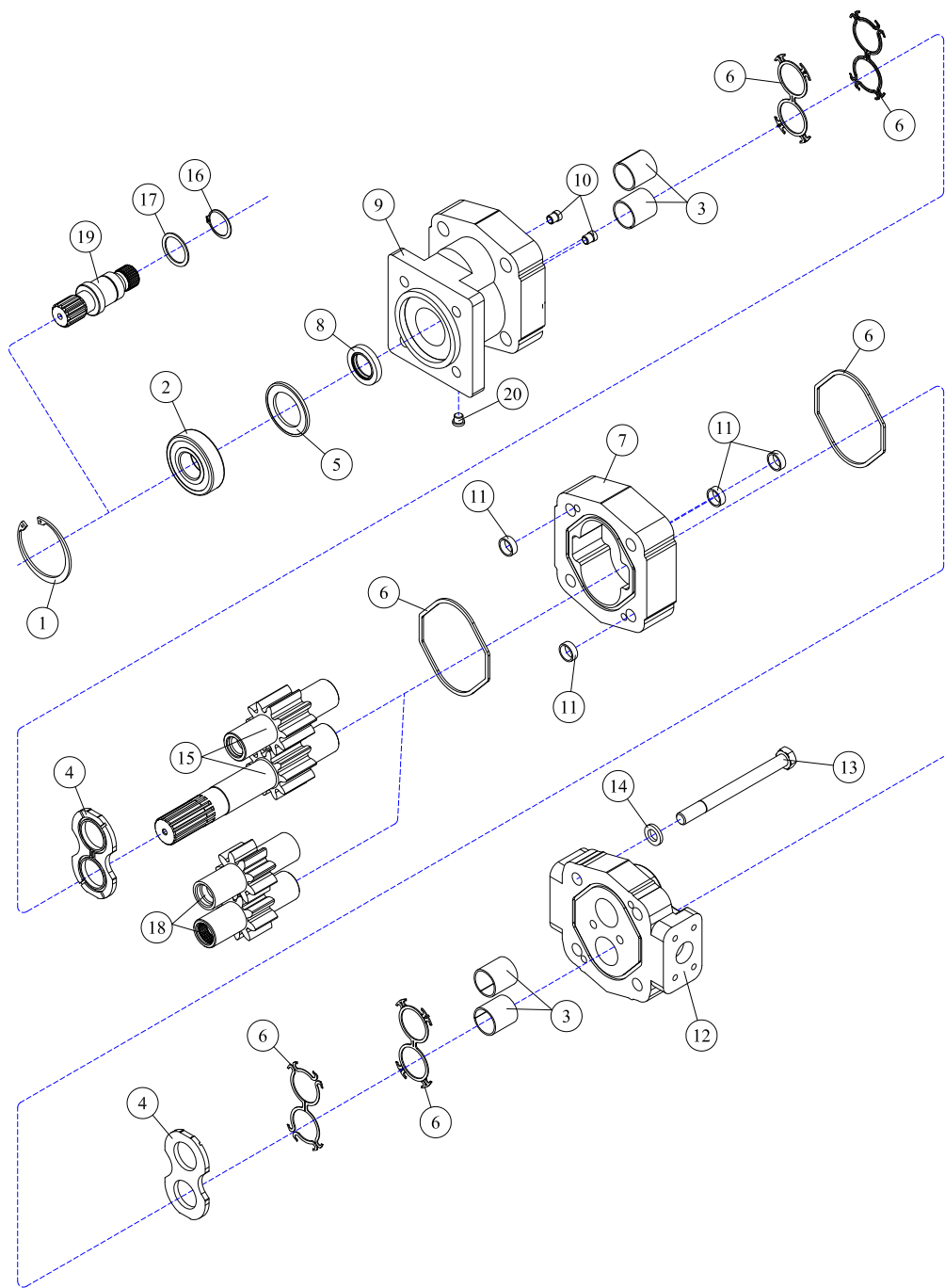


REF#	PARTS DESCRIPTION	REQ	PART #
1	SNAP RING	1	30-1009
2	OUTBOARD BEARING	1	30-1010
3	BUSHING	4	30-1011
4	THRUST PLATE	2	30-1012
5	SEAL RETAINER	1	30-1017
6	M365 SEAL KIT	Avail	30-1021
7	GEAR HOUSING	1	30-1023
8	SHAFT SEAL		
	150 PSI (included in M365 seal kit)	1	30-1210
	500 PSI	1	30-1156
9	SHAFT END COVER	1	30-1086
10	CHECK ASSEMBLY	2	30-1087
11	ALIGNMENT BUSHING	4	30-1090

REF#	PARTS DESCRIPTION	REQ	PART #
12	PORT END COVER	1	30-1091
13	STUD	4	30-1092
14	WASHER	4	30-1093
	GEAR SET OPTION A:		
15	1-1/2" GEAR SET	1	30-1159
	GEAR SET OPTION B:		
16	RETAINING RING	1	30-1019
17	WASHER	1	30-1020
18	1-1/2" GEAR SET	1	30-1022
19	CONTINENTAL SHAFT, SPLINED	1	30-1144
20	PLUG	1	30-1096
*	SEAL APPLICATOR TOOL (not shown)	Avail	30-1048

DECK ASSEMBLIES

MOTOR ASSEMBLY - 30-0520



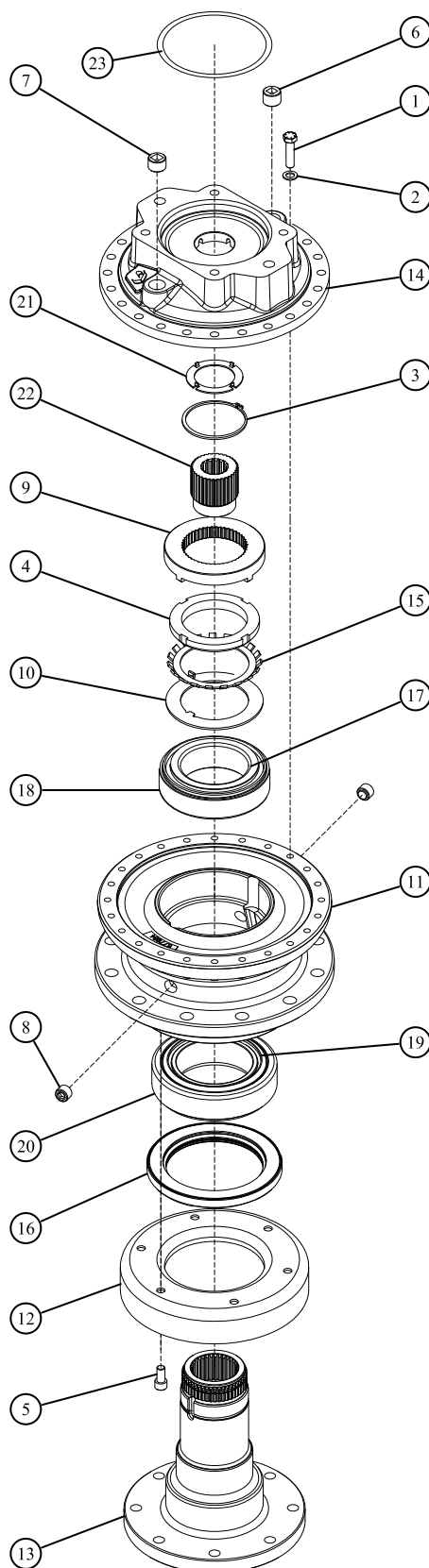
REF#	PARTS DESCRIPTION	REQ	PART #
1	SNAP RING	1	30-1009
2	OUTBOARD BEARING	1	30-1010
3	BUSHING	4	30-1011
4	THRUST PLATE	2	30-1012
5	SEAL RETAINER	1	30-1017
6	M365 SEAL KIT	Avail	30-1021
7	GEAR HOUSING	1	30-1015
8	SHAFT SEAL		
	150 PSI (included in M365 seal kit)	1	30-1210
	500 PSI	1	30-1156
9	SHAFT END COVER	1	30-1086
10	CHECK ASSEMBLY	2	30-1087
11	ALIGNMENT BUSHING	4	30-1090

REF#	PARTS DESCRIPTION	REQ	PART #
12	PORT END COVER	1	30-1091
13	STUD	4	30-1092
14	WASHER	4	30-1093
	GEAR SET OPTION A:		
15	1-3/4" GEAR SET	1	30-1166
	GEAR SET OPTION B:		
16	RETAINING RING	1	30-1019
17	WASHER	1	30-1020
18	1-3/4" GEAR SET	1	30-1013
19	CONTINENTAL SHAFT, SPLINED	1	30-1144
20	PLUG	1	30-1096
*	SEAL APPLICATOR TOOL (not shown)	Avail	30-1048

DECK ASSEMBLIES

SPINDLE ASSEMBLY - 35-0204

REF#	PARTS DESCRIPTION	REQ	PART #
1	BOLT-HEX HEAD	24	11-1611
2	WASHER-FLAT	24	11-1612
3	RING-RETAINING	1	11-1613
4	NUT-LOCK	1	11-1614
5	SCREW-SKT HD CAP	6	11-1616
6	PLUG (TO COVER) (MAGNETIC)	1	35-0200
7	PLUG (TO COVER) (NON-MAGNETIC)	1	35-0202
8	PIPE PLUG (TO HUB) (MAGNETIC)	2	21-1611
9	PLATE-KEEPER	1	35-0098
10	WASHER-THRUST (BOTTOM)	1	35-0099
11	HUB	1	35-0100
12	GUARD	1	35-0102
13	SHAFT-OUTPUT	1	35-0103
14	COVER		
	C COVER (STANDARD)	1	35-0199
	D COVER (OPTIONAL)	1	35-0109
	SEAL KIT		33-0078
15	WASHER-LOCK	1	
16	SEAL-OIL	1	
	SEALANT		
	BEARING AND SEAL KIT		33-0079
17	BEARING-CONE (TOP)	1	
18	BEARING-CUP (TOP)	1	
19	BEARING-CONE (BOTTOM)	1	
20	BEARING-CUP (BOTTOM)	1	
15	WASHER-LOCK	1	
16	OIL SEAL	1	
	SEALANT	1	
	D3 SPINDLE REPLACEMENT INSERT KIT		33-0080
21	WASHER-THRUST (TOP)	1	
22	COUPLING	1	
	SEALANT		
23	O-RING, D3 SPINDLE	1	24-0305



Assy: 35-0204



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	Class 4.6				Class 8.8				Class 10.9				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

(This Page Is Intentionally Left Blank)

**DEMAND
BRILLIANCE**