

**912 SERIES TORQUES – QUICK REFERENCE GUIDE :**

Standard Torques	Fastener Size/type	Torque Nm & angle	Sealant / Locking (Loctite or wire)
Standard Torque	M4	4	
Standard Torque	M5	6	
Standard Torque	M6	10	
Standard Torque	M8	24	
Standard Torque	M10	35	

Service Items	Fastener Size/type	Torque Nm & angle	Sealant / Locking (Loctite or wire)
Crank locking bolt blanking screw	M8	15Nm	Copper Washer
Magnetic plug	M12	25Nm	Wire
Oil filter		Touch + 270°	
Spark plugs	M12	20	Heat sink
Oil tank drain plug	M12 bolt	25Nm	Copper washer / wire
Carb top	M5 bolt	5.5Nm	
Carb needle	M10 fixation screw	Feel (3.5Nm is good)	Patch on bolt
Throttle lever	M8 Nut	5Nm	
Choke lever	M8 Nut	5Nm (care not to break housing)	
Carb socket clamp	M5 Bolt	2.5Nm	
Fuel block banjo	M8	10Nm	
Banjo on fuel regulator		15Nm	Copper Washer

Most common items	Fastener Size/type	Torque Nm & angle	Sealant / Locking (Loctite or wire)
Throttle cable clamp bolt	M5	4Nm	
Carb socket bolts	M8 Bolt	15Nm	221 or 222
Fuel pump	Nuts (914 bolts)	15Nm	243
Magneto cover	M6 Bolts	5Nm	221 or 222
Oil Pressure sender		15Nm	243
Oil Pressure sender	M3 wire	1Nm	
Pressure relief Valve plug screw	M12	25Nm	Wire
Head	M8 nuts (with threaded along studs)	10Nm + 180°	
Head	M8 nuts (with plain shank studs)	22Nm	
Head water outlets	M6 bolts	10Nm	O ring
Inlet manifolds	M6 Bolts	10Nm	O ring
Exhaust stud	M8	IPC 6Nm (HMM 8NM)	2701
Exhaust nut	M8	12Nm-20Nm	
Ignition	Plug cap	Hand Tight	Cable tie
Rocker cover	M6		
Engine suspension frame to engine	M10	40Nm	O rings
Hose clamps	Sprung	N/A	
Hose clamps	M4 screw	Feel	
Gearbox housing			574 or 5910
Gearbox housing	M6 Bolts	10Nm	
Gearbox housing	M8 Bolts	24Nm	

Other useful items	Fastener Size/type	Torque Nm & angle	Sealant / Locking (Loctite or wire)
Crankcase Banjo	M16	30Nm	221 or 222
Gearbox Gear	M30 LH Nut	200Nm	648
Oil pump	M6	10Nm	
Banjo Governor/Blanking bolt	M10	17 (12 oily)	copper
Banjo bolt 914 scavenge		12	
SMD module	M8 bolt into crankcase	24	221 or 222
SMD module	M6 nut	10Nm	
SMD module	M5 Bolt	2.5Nm	221 or 222
Oil tank outlet hose nipple		25	
Servo nipple 914	M4	2.5Nm	
Crankcase Blank (banjo)	M16	35Nm	221 or 222 & Wire

Other useful items (cont.)	Fastener Size/type	Torque Nm & angle	Sealant / Locking (Loctite or wire)
Crankcase drain	¾-16UNF	25Nm	243
External alternator	M10	40Nm	
External alternator	M8	22Nm	
Fuel block clamp bolt	M5	6	
Sprag Clutch	Taper		Hmm 221 or 222 (IPC 648)
Sprag clutch	M34 LH Nut	120Nm	648
Magneto housing			574 or 5910 & O ring
Magneto	M6 Bolts	10Nm	243 (1 bolt only)
Trigger screws	M5 screws	6Nm	
Stator	M5 Screws	6Nm	
Remote aluminium box lid	M5 Screws	Hand tight	
E start	M5 Bolts On Mag Housing	6Nm	
E start	M5 Nuts	6Nm	
E start	Clamp	2.5Nm	
E Start Terminal	M6 Nut	4Nm	
E Start Solenoid	M6 Nut	4Nm	
Flywheel	Taper		221 or 222
Flywheel	M16 Bolt	45Nm + 180°	
Mag ring	M6 Bolt	10Nm	221 or 222
Trigger bolts	M5	6Nm	
Water pump housing	M6 Bolts	10Nm	1 With copper washer
Impeller	M8	15	221
Gearbox bearing	M7	15Nm	221 or 222
Oil hose Nipple	M14	15Nm	243
Oil Filter Nipple		60Nm	
Temp sender		7Nm	243
Blanking bolt Banjo	M10	10	Copper washer / 243
adaptor	¾-16UNF	25	243
Piston	Piston pin	Monohook circlip	
Cylinder	Studs	3Nm	O ring
Head water outlets	Tube thread into plate	Position only	648
Temp sender	M10	7	243
Oil tank 914 banjo	M10	17	Copper washer
Oil tank plug screw	M10	17	Copper washer
Vac pump stud	M6	5Nm	221 or 222
Hydraulic Governor plug screw	M8	10Nm	221 or 222
Hydraulic Governor	M10	17Nm	
Governor flange to case	M6	10	221 or 222
Fuel block blank	M10	15Nm	221 or 222
914 air box hose nipple	M6	3Nm	
Feul regulator mounting screw	M6	8Nm	
Air box temp probe		15Nm	221
Cap lock nut Fuel regulator		5Nm	243
914 turbo & exhaust	M8 stud	6Nm	2701
914 turbo & exhaust	M8 bolts & nuts around turbo	25Nm	
914 turbo & exhaust	M10 bolt	40Nm	
914 muffler clamp	M8	15Nm	
914 Valve housing (top of turbo)		25Nm	
914 Banjo oil inlet		10Nm	
914 servo central bolt	M5	6Nm	
Oil cooler nipple	M14	22Nm	
Oil cooler Adaptor	M18	35Nm	
Oil cooler bent socket		25Nm	
Oil cooler Angular tube	M14	22Nm	
Oil cooler adaptor	¾-16UNF	35Nm	