

### RE-TORQUE SCHEDULE: • AFTER 30 DAYS • EVERY 6 MONTHS THEREAFTER

NOTE: THIS PUBLICATION SUMMARIZES GENERAL TORQUE REQUIREMENTS APPLICABLE TO ALL CURRENT WATSON & CHALIN PRODUCTS. TORQUE VALUES SHOWN APPLY ONLY TO WATSON & CHALIN SUPPLIED FASTENERS.

#### Capscrew/Bolt (Grade 8 UNF) Torque Requirements:

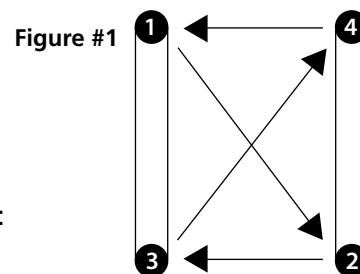
Capscrew Bolt Size	3/8 in.	1/2 in.	5/8 in.	3/4 in.	3/4 in. (Stabilizer Shock Stud)	7/8 in.	1 in.	1-1/8 in.
Torque Minimum: lbs.-ft.	25	55	150	300	150	500	700	900
Torque Maximum: lbs.-ft.	35	75	200	350	175	550	800	1000
Torque Minimum: Nm	34	75	203	407	203	678	949	1220
Torque Maximum: Nm	47	102	271	475	237	746	1085	1356

NOTE: TORQUE VALUES DO NOT APPLY TO AIR SPRINGS OR LOWER GRADE FASTENERS.

#### U-Bolt Torque Instructions:

To torque or re-torque u-bolts, follow the procedures below:

1. Partially tighten bolts #1 and #2 according to Figure #1 at right:
2. Partially tighten bolts #3 and #4.
3. Using the same sequence, tighten to the proper torque value as specified below:



#### U-Bolt (Non-Plated, Clean Lubricated Thread) Torque Requirements:

UNF Grade 8 Size	3/8 in.	1/2 in.	5/8 in.	3/4 in.	7/8 in.	1 in.	1-1/8 in.
Torque Minimum: lbs.-ft.	15	40	120	200	400	650	800
Torque Maximum: lbs.-ft.	20	60	150	250	450	750	900
Torque Minimum: Nm	20	54	163	271	542	881	1085
Torque Maximum: Nm	27	81	203	339	610	1017	1220

#### Air-Spring Requirements:

Size	Description	Max Torque Req. lbs-ft (Nm)
3/8 in.	UNC Blind Nuts	15–20 (20–27 Nm)
1/2 in.	UNC Bolt or Stud	25 (34 Nm)
3/4 in.	UNC Stud	55 (75 Nm)
3/4 in.	UNC Combo Stud	50 (68 Nm)

#### Air-Fitting Torque Requirements:

Size	Max. Torque Req. lbs-ft (Nm)
1/4 in. NPTF	20 (27 Nm)
1/2 in. NPTF	20 (27 Nm)
3/4 in. NPTF	20 (27 Nm)

*Actual product performance may vary depending upon vehicle configuration, operation, service and other factors. All applications must comply with applicable specifications from Watson & Chalin and the respective vehicle manufacturer. Contact Watson & Chalin for additional details regarding specifications, applications, capacities, and operation, service and maintenance instructions.*

Contact Watson & Chalin at 972.547.6020 for additional information.



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