

Service Bulletin.

ENGINE
Tightening Torques

Table of tightening torques for engines in production

These values apply to Volvo original parts.

Required torque in kgm (lb.ft.)

	A 6		B 16		B 36 AV		ED	
Cylinder head nuts	14-16	(100-116)	7-8	(50-60)	8.5-10	(60-70)	7-8	(50-60)
Main bearing bolts	14-16	(100-116)	8-10	(60-70)	12.5	(90)	8.5-10	(60-70)
Big-end bearing bolts	8.5-10	(60-70)	4-5	(30-35)	6.5	(47)	5.5-6	(40-45)
Flywheel bolts	8.5-10	(60-70)	2.3-2.7	(17-20)	8	(58)	5.5-6	(40-45)
Spark plugs	3.5	(25)	3.5	(25)	3.5	(25)	3.5	(25)
Oil filter	-		1.4	(10)	1.5	(11)	-	

	D 47 A	D 67 A&B	D 96 AS T-D 96 AS	D 96 B T-D 96 B	D 96 AL
Cylinder head nuts	14-16 (100-116)	14-16 (100-116)	1) 13-20 (130-145) 2) 12-14 (87-101)	1) 13-20 (130-145) 2) 12-14 (87-101)	1) 14-16 (100-116) 2) 8.5-10 (60-70)
Main bearing bolts	14-16 (100-116)	19.5-22 (140-160)	19.5-22 (140-160)	19.5-22 (140-160)	19.5-22 (140-160)
Big-end bearing bolts	14-16 (100-116)	14-16 (100-116)	19.5-22 (140-160)	19.5-22 (140-160)	19.5-22 (140-160)
Flywheel bolts	8.5-10 (60-72)	8.5-10 (60-72)	14-16 (100-116)	14-16 (100-116)	14-16 (100-116)
Injector attaching bolts	2.3-3.0 (17-22)	2.3-3.0 (17-22)	2.3-3.0 (17-22)	2.3-3.0 (17-22)	2.3-3.0 (17-22)
Fuel injection pump delivery valve retainers	6.3 (45)	6.3 (45)	4.5 (32)	4.5 (32)	4.5 (32)
Vibration damper attaching bolts	80-90 (578-650)	80-90 (578-650)	-	80-90 (578-650)	--

1). 14 mm bolts

2). 12 mm bolts