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despatch to all dealers:

SERVICE BULLETIN NO. 277

November 15, 1968

FROM: Walter Brown, Service Manager

SUBJECT: B44 VICTOR MODEL- TORQUE WRENCH SETTINGS (DRY)

The following are the recommended torque wrench settings for critical nuts and bolts used on B44 Victor Models for 1969, which replace those quoted on Page H.1 of the Victor workshop manual. Attention to these details will ensure longer working life of the parts and greater safety.

<u>APPLICATION</u>	<u>THREAD DIA AND TYPE</u>	<u>T.P.I.</u>	<u>HEX.AF</u>	<u>TORQUE lb/ft</u>
Carbureter flange nuts (SL)	0.3125" BSC	26	0.525"	10
Clutch center nut	0.500" BSC	20	0.820"	60/65
Crankpin nuts	0.875" WF	20	1.480"	200
Crankshaft pinion nut	0.625" BSF	20	0.919"	35/40
Cylinder Barrel nut	0.4375" UNF	20	0.6875"	30/33
Cylinder head stud nuts	0.3125" BSC	26	0.525"	18/20
Kickstart ratchet nut	0.500" BSC	20	0.705"	50/55
Oil pump stud nuts	0.250" UNF	28	0.437"	5/7
Rotor mounting nut	0.625" BSC	20	1.010"	60
Rocker box nuts	0.3125" BSC	26	0.525"	10
Rocker box nuts	0.250" BSC	26	0.440"	5/7
Front fork cap nuts	1.0625" WF	20	1.300"	50/55
Front fork bottom yoke nuts	0.375" UNF	24	0.562"	23/25
Stator mounting nuts	0.25" UNF	28	0.437"	5/7

ABBREVIATIONS

T.P.I.	Threads Per Inch	BSF	British Standard Fine
Hex. AF	Hexagon Across Flats	UNF	Unified Fine
SL	Self-locking	WF	Whitworth Form
BSC	British Standard Cycle	LHT	Left-hand Thread