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EASTERN STATES DISTRIBUTOR FOR BSA MOTORCYCLES / A SUBSIDIARY OF THE BIRMINGHAM SMALL ARMS COMPANY, LTD. OF ENGLAND

## despatch to all dealers:

SERVICE BULLETIN NO. 278

November 15, 1968

FROM: Walter Brown, Service Manager

SUBJECT: B25 MODEL TORQUE WRENCH SETTINGS (DRY)

Listed below are the recommended torque wrench settings for critical bolts and nuts. Over-tightening or non-uniform tightening of the cylinder head and barrel nuts for instance, can cause distortion, resulting in loss of compression, increased engine wear and poor fuel economy.

<u>APPLICATION</u>	<u>THREAD DIA. AND FORM</u>	<u>T.P.I.</u>	<u>HEX.AF</u>	<u>TORQUE lb/ft</u>
Carburetor flange nuts (SL)	0.3125" BSC	26	0.525"	10
Clutch center nut	0.50" BSC	20	0.820"	60/65
Conn. rod end cap nuts (SL)	0.3125" BSC	26	0.525"	25/27
Crankshaft pinion nut	0.625" BSF	20	0.919"	35/40
Cylinder barrel nuts	0.375" UNF	24	0.558"	26/28
Cylinder head stud nuts	0.3125" BSC	26	0.525"	18/20
Fork leg cap nuts	1.0625" UNF	28	1.500"	50/55
Fork leg pinch bolts	0.375" UNF	24	0.562"	18/20
Kickstart ratchet nut	0.50" BSC	20	0.705"	50/55
Oil pump stud nuts (SL)	0.25" 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	0.25" BSC	26	0.440"	5/7
Stator mounting nuts	0.25" UNF	28	0.437"	5/7

### ABBREVIATIONS

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