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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 | | |