

Part to tightened	Part name	Thread size	Q'ty	Tightening torque			Remarks
				Nm	m·kg	ft·lb	
<b>ENGINE:</b>							
Engine unit	Bolt	M8	8	21	2.1	15	
Flywheel	Nut	M20	1	160	16	115	→
Intake manifold	1st	Bolt	M6	8	4	0.4	2.9
	2nd				8	0.8	5.8
Reed valve	Bolt	M3	18	1	0.1	0.7	
Spark plug	Bolt	M14	3	25	2.5	18	
Cylinder head	1st	Bolt	M8	14	15	1.5	11
	2nd				32	3.2	23
Exhaust cover	1st	Bolt	M6	16	3	0.3	2.2
	2nd				8	0.8	5.8
Crank case	1st	Bolt	M8	6	10	1.0	7.2
	2nd				20	2.0	14
	1st		M10	8	20	2.0	14
	2nd				40	4.0	29
<b>LOWER:</b>							
Propeller	Nut	M16	1	30	3.0	22	
Lower unit	Nut	M10	4	40	4.0	29	
Ring nut	Nut	M101.5	1	145	14.5	105	
Pinion nut	Nut	M16	1	95	9.5	68	
<b>BRACKET:</b>							
Main switch	Nut	M20	1	5	0.5	3.6	
Engine stop switch	Nut	M16	1	4	0.4	2.9	
Muffler mounting	Bolt	M8	4	21	2.1	15	
Exhaust manifold	Bolt	M8	3	21	2.1	15	→
Exhaust guide mounting	Bolt	M8	2	21	2.1	15	
Clamp bracket	Nut	M22	1	15	1.5	11	→
Spring hook	Bolt	M6	1	8	0.8	5.8	

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**Scott A. Freeman**

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