



Bolt Fixing Standard

KES T – D208

(EST) 1988-04-30

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1. Purpose

This shall be for the purpose of making a development test efficient by setting a standard for a bolt fixing.

2. Scope of Application

This shall apply to a gasoline (F series and B series engine) and LPG engine.

3. Unit and Terminology

(1) Follow the clause (5) of a technical standard formulation regulation (ES-M1-0001) for a unit.

4. Engine Bolt Fixing Standard

(1) "F" series bolt fixing standard (See the additional table 1~4)

(2) "B" series bolt fixing standard (See the additional table 5~7)

Additional table 1

ENG, "F" Series

No	Assembling position	Fixing torque (kg.cm)			Bolt specification	Sub No.
		Specification	Set value	Control value		
1	Earth Wire Bolt	80 – 120			M6 x P1.0	99794 0616
2	EGR. VAL. B/K	350 – 450			M24 x P1.5	
3	EGR. VAL. fixing bolt	80 – 120		90 – 130	M6 x P1.0	99796 0620
4	EGR. Modylator B/K Bolt	190 – 310			M8 x P1.25	99794 0816
5	In. Mani fixing stud	80 – 120			M8 x P1.25	99851 0825 A
6	In. Mani CPT fixing bolt, nut	190 – 310		200 – 330	M8 x P1.25	Bolt 99796 0825 Nut 99840 0801
7	Water inlet pipe stay fixing bolt	190 – 260	230		M8 x P1.25	99796 08
8	Water inlet pipe stay fixing bolt	380 – 540	460		M10 x P1.25	99796 1060 ²⁵ ₂₀
9	Water Thermo S/W (Thermo Cover)	50 – 100	70		M16 x P1.5	
10	Water bypass pipe stay fixing bolt	380 – 640			M10 x P1.25	99796 1016
11	Water Hose Clip	20 – 30			M6 x P1.0	99282 4300
12	Water pump CPT fixing bolt	190 – 260	220	180 – 280	M8 x P1.25	99784 0820
13	Water Thermo S/W (In. Mani)	250 – 400	260		PT 3/8	
14	Water Temp. Sensor	250 – 400	300		M12 x P1.5	
15	Water Bypass Hose Clip(+Carbu)	20 – 30			M4 x P0.7	99282 1301 99282 1601
16	AAV B/K fixing bolt	190 - 310			M8 x P1.25	99794 0816
17	Air Cleaner fixing stud	35 – 50			M6 x P1.0	
18	Air Pipe B/K	350 – 450			M26 x P1.5	
19	Air Pipe B/K Nipple	240 – 360			M14 x P1.5	
20	Air pipe fixing bolt	80 – 120			M6 x P1.0	99940 0602
21	Ex. Mani fixing bolt	220 – 290		220 – 310	M8 x P1.25	
22	Ex. Mani fixing bolt	80 – 120			M8 x P1.25	99851 0825 A
23	ENG. Hanger fixing bolt	190 - 310		200 – 340	M8 x P1.25	99794 0816