



Hayabusa GSXR

Issue Date 13-12-2013

TORQUE WRENCH SETTINGS

Specifications subject to change without prior notice

Camshaft carrier bolts

Tighten evenly and diagonally

7 lb-ft

Cam carrier oil pipe bolts (x2)

Install washer between bolt and pipe

If larger cam profiles are used pipe may need to be modified to clear

7 lb-ft

Top cam chain guide bolts (x2)

243 Loctite

7 lb-ft

Cam chain guide lower pivot bolt

Wave washer may or may not be used between bolt and guide depending on year of engine – 243 Loctite on thread

7 lb-ft

Oil pump mounting bolts (x3)

243 Loctite – Apply grease to oil pump O-ring

Sharp edge of circlip to face outwards

7 lb-ft

Balancer shaft arm bolt

243 Loctite (SBD wire-loc to cap head bolt)

7 lb-ft

Balancer shaft cover bolt

243 Loctite

7 lb-ft

Standard Rod bolts

Apply Molybdenum paste to thread and under head of bolt

Initial – **25.5 lb-ft**

Final – **48.5 lb-ft**

For Steel rod bolts see separate sheet

Crankcase bolts-(Main bearing bolts)

Tighten in the specified order- Fit copper washers where appropriate

(M9)

Initial – **13 lb-ft**

Final – **23 lb-ft**

Aftermarket Main studs – See correct document

Crankcase bolts

Tighten gradually to equalise pressure-Fit copper washers where appropriate

(M6)

Initial – **4.5 lb-ft**

Final – **8 lb-ft**

(M8)

Initial – **9.5 lb-ft**

Final – **19 lb-ft**

(M9)

Initial – **13 lb-ft**

Final – **23 lb-ft**

(M10)

Initial – **20 lb-ft**

Final – **36 lb-ft**

Upper flexi oil hose bolts (x2)

Ensure washers are fitted either side of union

14.5 lb-ft

Lower rigid oil pipe

Note ensure washers on banjo end are fitted-No Loctite

243 Loctite on upper flange bolts

Oil pipe bolts (M6) – **7 lb-ft**

Oil pipe union bolt (M14) – **20.5 lb-ft**

Generator rotor bolt

Ensure tapered portion of rotor and crankshaft are fully degreased using solvent - Ensure key is fitted in keyway

87 lb-ft

Starter clutch bolt

40 lb-ft

Clutch sleeve hub nut

Once tightened lock the nut with a centre punch

68.5 lb-ft

Clutch spring set bolts (x6)

Tighten diagonally

7 lb-ft

Cylinder head bolts

Apply graphite grease under head of bolt and washer-engine oil on threads

Tighten sequentially and diagonally

Initial – **18 lb-ft**

Final – **37.5 lb-ft**

Engine sprocket nut

243 Loctite

105 lb-ft

Oil cooler hose bolts

7 lb-ft



SBD Motorsport Ltd
Unit 15, Red Lion Business Park, Red Lion Road, Surbiton, Surrey. KT6 7QD
Tel:0208 391 0121
Email:sbdmotorsport@btconnect.com
Website:sbdev.co.uk