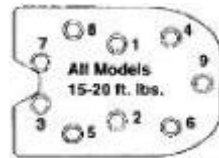


## Magnum - Twin Cylinder Torque Values & Sequences for Fasteners

- [Magnum Values & Sequences](#)
- [Crankcase](#)
- [Oil Pan](#)
- [Cylinder Barrel](#)
- [Closure Plate](#)

Model (Horsepower)		MV16 (16) M18 & MV18 (18) M20 & MV20 (20)
Connecting Rods <sup>1,2</sup>	New	140 in. lbs.
	Used	100 in. lbs.
Spark Plugs		10-15 ft. lbs.
Cylinder Head <sup>1</sup>		
Flywheel <sup>5</sup>	Screw <sup>1</sup>	40 ft. lbs.
	Fan	115 in. lbs.
Manifold Screw/Nut		150 in. lbs.
Non Metallic Fuel Pump Mounting Screws		37-45 in. lbs.
Ignition Module		32 in. lbs.
Oil Filter		Snug Plus 1/2 Turn ( 50/80 in. lbs.)
Remote Oil Filter	Lines	65-80 in. lbs.
	Oil Line Flared Nuts	100-120 in. lbs.
	Adapter	125 in. lbs.
	Adapter Fittings	100-120 in. lbs.

## Magnum - Twin Cylinder Torque Values & Sequences for Fasteners

Adapter fittings	50-150 in. lbs.
Cover Plate	125 in. lbs.

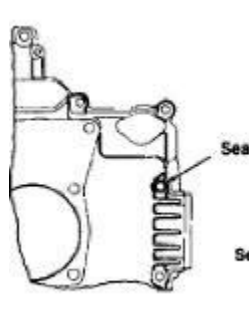

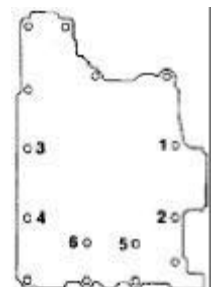
<sup>1</sup>Lubricate fastener threads with engine oil.

<sup>2</sup>DO NOT overtorque

<sup>5</sup>Flywheel and crankshaft tapers must be clean and dry.

NEW - Component directly from stock.

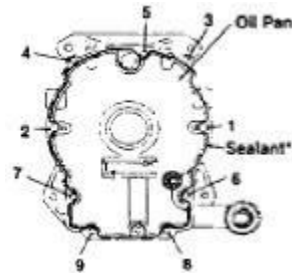
USED - Component that was in a running engine.

Crankcase: Twin Cylinder Engines									
#2 Side Crankcase Half Exterior	#2 Side Crankcase Half Interior								
									
	<table><tr><th>Bolt No.</th><th>Torque</th></tr><tr><td>1-4</td><td>260 in. lbs.</td></tr><tr><td>5-6</td><td>200 in. lbs.</td></tr><tr><td>Torque remaining bolts in most expedient sequence to</td><td>200 in. lbs.</td></tr></table>	Bolt No.	Torque	1-4	260 in. lbs.	5-6	200 in. lbs.	Torque remaining bolts in most expedient sequence to	200 in. lbs.
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Magnum - Twin Cylinder Torque Values & Sequences for Fasteners

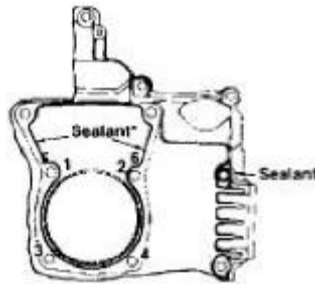
**Oil Pan (MV16, MV18, MV20)**

150 in. lbs.



NOTE: Do not use gasket on MV oil pans.

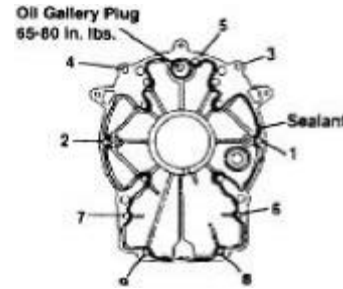
**Cylinder Barrel (All)**



Apply sealant to crankcase.\*  
Preliminary Torque - 100 in. lbs.  
Final Torque - 200 in. lbs.  
(Engines with 5/16-18 studs)  
Final Torque - 360 in. lbs.  
(Engines with 3/8-16 studs)

Magnum - Twin Cylinder Torque Values & Sequences for Fasteners

**Closure Plate (M18 & M20) 150 in. lbs.**



\*Use a gasket or sealant as necessary: When reinstalling a closure plate or cylinder barrels originally installed with a gasket, use a new gasket. When reinstalling a closure plate or cylinder barrels originally installed with sealant, use new sealant. When installing a service replacement closure plate or cylinder barrels, use new sealant.