



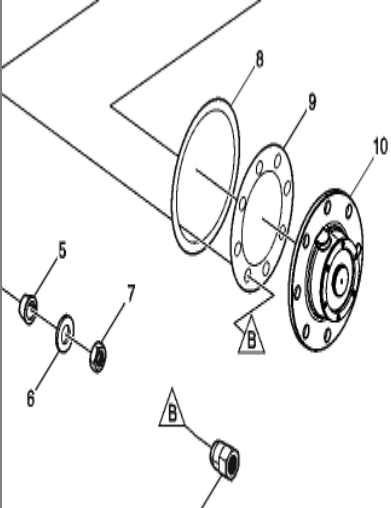
Volvo Chassis - Pre-Delivery Inspection (PDI) Torque Values

This solution provides the torque specs needed to complete a Pre- Delivery Inspection (PDI).

NOTE: When verifying the component torque **DO NOT** loosen and retorque. Refer to the torque verification procedure below.

- 1. Using a torque measuring tool in the tightening direction, begin to slowly apply force to the tool until the first movement in the fastener is noted.
- 2. The reading recorded is a good indication of the original torque applied to the joint.
- 3. Tighten until the torque value below is acheived.

Volvo (VNL,VNR,VNX,VAH,VHD)

Component	Torque	Web Link	
Axle Shaft Nuts	3-PC = 224 ± 7 Nm		
	iLOK = 244 ± 24 Nm		

 Live UI

Front Axle U- Bolt	Leaf M20 = 505 Nm		
	Leaf M22 = 600 Nm		
	Air = 350 ± 20 ft. lbs.	Airtek Technical Procedure PDF (Hendrickson Website)	
Drive Axle U- Bolts	Maxlite M20 = 500 Nm		
	Maxlite M22 = 575 Nm		
	Single Axle Leaf = 500 Nm		
	Single Leaf Mack Axle = 575 Nm		
	Primaax = 375 ± 25 ft. lbs	Primaax Technical Procedure PDF (Hendrickson website)	
	HAS 7/8" = 425 ± ft. lbs.	HAS Technical Procedure PDF (Hendrickson website)	
	HAS 3/4" = 290 ± 30 ft. lbs.		
Wheel Nuts	475 ± 25 ft. lbs.		



Tags

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