



Mack - 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 achieved.

Mack Conventional (AN,GR,PI)

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.		

Mack Cab Over (LR,TE)

Component	Torque
Axle Shaft Nuts	3-PC = 224 ± 7 Nm
	iLOK = 244 ± 24 Nm
Front Axle U- Bolts	3/4" = 447 ± 13 Nm
	7/8" = 576 ± 34 Nm
Drive Axle U- Bolts	Single Axle Leaf = 500 Nm
	Single Leaf Mack Axle 575 Nm
Wheel Nuts	475 ± 25 ft. lbs

Mack Medium Duty (MD)

Component	Torque
Front Axle U-Bolts	525 + 25 Nm
Drive Axle U-Bolts	Leaf = 460 + 25 Nm
	Air = 575 + 50 Nm
Wheel Nuts	475 + 25 ft. lbs

Axle Flange

Figure 5.83

Table P: Shaft-to-Hub Torque Fastener Chart — Non-Tapered Dowel Applications

Fastener	Thread Size	Torque Value — Grade 8 Nuts lb-ft (N•m)	
		Plain Nut	Locknut
Stud Nut, Axle Shaft	0.62-18	150-230 (244-312)	130-190 (203-258)
	0.75-16	310-400 (420-542)	270-350 (366-475)
Studs	All	Install the coarse thread end of the stud into the hub and tighten to the last thread.	

Table Q: Shaft-to-Hub Torque Fastener Chart — Tapered Dowel Applications

Fastener	Thread Size	Torque Value — Grade 8 Nuts lb-ft (N·m)	
		Plain Nut	Locknut
Stud Nut, Axle Shaft	0.44-20	50-75 (81-102)	40-65 (67-88)
	0.50-20	75-115 (115-156)	65-100 (102-136)
	0.56-18	110-165 (176-224)	100-145 (149-197)
	0.62-18	150-230 (244-312)	130-190 (203-258)
Studs	All	Install the coarse thread end of the stud into the hub and tighten to the last thread.	

 Tags

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