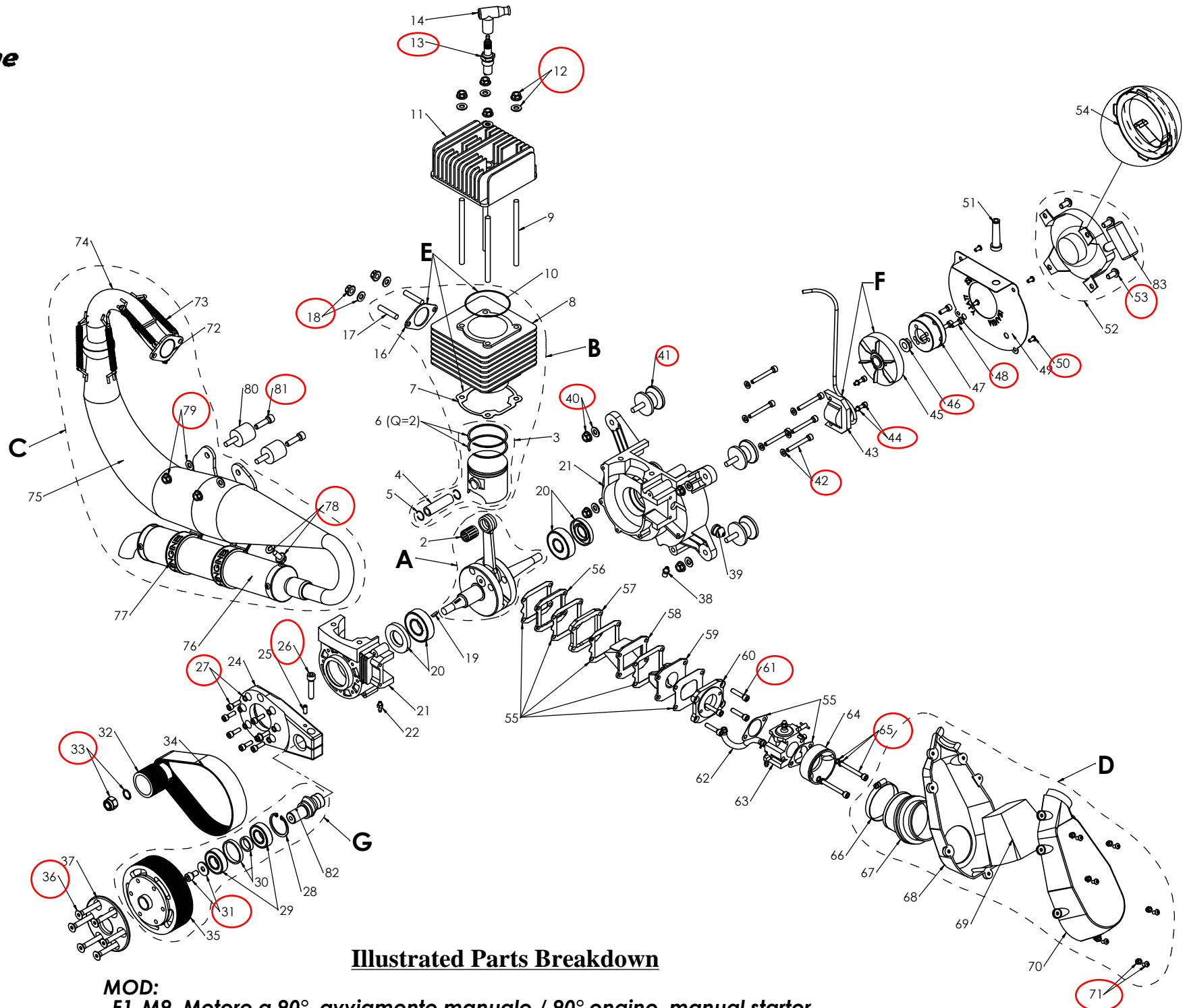


Minari F1-M9 180/200 Torque Table
by Frank Hoffmann
1/14/2017

Illustrated Parts Breakdown Ident Number (Page 2)	Fastener Description	Specifications	Fastening Tool	Threadlocker	Torque Value	
					Nm	/ inch-lb
12	Cylinder Head Nuts	M8	13mm Socket	-None-	20	177
13	Spark Plug	NGK BR8ES (cold conditions) NGK BR9ES (hot conditions)	13/16" Spark Plug Socket	Red on Terminal threads -None on main threads-	20	177
18	Exhaust Manifold Nuts	M8	13mm Socket	Blue	20	177
26	Re-Drive Clamping Screw	M8 x 40mm	6mm Hex Bit	Blue	20	177
27*	Drive Bolts	M6 x 25mm	5 mm Hex Bit	Blue	10	89
31	Secondary Drive Pulley Locking Bolt	M8 x 16mm	6mm Hex Bit	-None-	20	177
33*	Primary Drive Nut	M12	19mm Socket	-None-	40	354 = 30 ft-lb
36	Propeller Bolts	M8 x 50mm	5mm Hex Bit	Blue	10	88
40	Motor Mount Nuts	M8	13mm Socket	Blue	20	177
Inserted into 41	Miniplane Motor Mount Locking Bolts	M8 x 10mm	5mm Hex Bit	Blue	8	71
42	Crankcase Bolts	M6 x 50mm	5mm Hex Bit	Blue	10	89
44	Ignition Coil Bolts	M5 x 20mm	4mm Hex Bit	Blue	4	35
46	Flywheel Nut	M12	17mm Socket	-None-	40	354 = 30 ft-lb
48	Starter Bell Bolts	M6 x 18mm	5mm Hex Bit	Blue	10	89
50	Flywheel Cover Bolts	M5 x 12mm	3mm Hex Bit	Blue	Snug	
53	Manual Starter Bolts	M8 x 20mm	5mm Hex Bit	Blue	8	71
61	Reed Valve Bolts	M6 x 30mm	5mm Hex Bit	Blue	8	71
65	Airbox Flange and Carburetor Bolts	M6 x 55mm	5mm Hex Bit	Blue	3	25
71	Airbox Locking Bolts	M5 x 12mm	3mm Hex Bit	-None-	Snug	
78	Exhaust Clamp Bolts	M8 x 20mm	13mm Socket	Blue	15	132
79	Muffler Mount Nuts	M8	13mm Socket	Blue	15	132
81	Exhaust Mount Locking Bolts	M8 x 30mm	6mm Hex Bit	Blue	20	177

* Does not exist on clutched system



Illustrated Parts Breakdown

MOD:
-F1-M9 Motore a 90°, avviamento manuale / 90° engine, manual starter

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