

Tightening torques-protractor (angle) tightening



Tightening using both a torque setting and a protractor angle ensures that the recommended torque is applied using a torque wrench and that the recommended angle is added according to the protractor scale. Example: a 90° protractor tightening means that the nut is tightened a further 180 turn in one direction after the stated tightening torque has been applied.

Locknuts

Do not reuse lock nuts that have been removed during dismantling as they have reduced service life when reused - use new nuts when assembling or reassembling. For lock nuts with a plastic insert such as **Hydrotuf** the tightening torque stated in the table is reduced if the **Hydrotuf** nut has the same head height as a standard hexagonal nut without plastic insert. Reduce the tightening torque by 25% for lock size 8 mm or larger. **Hydrotuf** nuts are higher or of the same height as a standard hexagonal nut, the tightening torques given in the table apply.

Tolerance classes

Screws and nuts are divided into different strength classes, the class is indicated by the number on the lock head. A high number indicates stronger material, for example a lock marked 10.9 indicates a higher tolerance than one marked 8.8. It is therefore important that bolts removed during the disassembly of a locked part must be reinstalled in their original position when assembling the part. If a bolt must be replaced check in the replacement parts catalogue to make sure the correct bolt is used.

Sealants

A number of sealants and locking liquids are used in the engines. The agents have varying properties and are used for different types of joints, strengths, operating temperature ranges, resistance to oil and other chemicals and for the different materials and gap sizes in the engines.

To ensure service work is correctly carried out it is important that the correct sealant and locking fluid type is used on the part where the agents are required.

In the Volvo Penta Service Manual the user will find that each section where these agents are applied in production states which type will be used on the engine. During service operations use the same agent or an alternative from a different manufacturer.

Make sure that mating surfaces are dry and free from oil, grease, paint and anti-rust agent before applying sealant or locking fluid. Always follow the manufacturer's instructions for use regarding temperature range, curing time and any other instructions for the product.

Two different basic types of agent are used on the engine and these are:

RTV agent (Room temperature vulcanizing). Use for gaskets, sealing gasket joints or coating gaskets. RTV agent is clearly visible when a component has been dismantled and RTV must be removed before the part is reassembled.

The following RTV agents are mentioned in the Service Manual: Loctite® 574, Volvo Penta 840374-1, Permatex® No. 3, Volvo Penta P/N 1101009-5, Permatex® No. 77. Oil resistant can be removed using methylated spirits in all cases.

Anaerobic agents. These agents cure in an absence of air. They are used when nut, bolt, pins, for example cast components, are installed head-to-head without a gasket. They are also commonly used to secure plugs, threads in cast parts, valves, oil pressure switches and so on. The cured material is glass-like and it is therefore colored to make it visible. Cured anaerobic agents are extremely resistant to solvents and the old agent cannot be removed. When dismantling the part is carefully degreased and then new sealant is applied.

The following anaerobic agents are mentioned in the Service Manual: Loctite® 572 (white), Loctite® 541 (blue).

NOTE: Loctite® is the registered trademark of Loctite Corporation, Permatex® is the registered trademark of the Permatex Corporation.

Presentation



The oil filler point is located at the rear of the engine block on the port side as seen from the front. Engines fitted before 1999 must have the pipe secured on the starboard side.

The engine is a 4-cylinder, wet sump, water-cooled, gasoline engine. The thermodynamically controlled cooling system is supplied with sea water from a seawater pump and impeller pump. A separate circulation pump forces cooling water through the engine block to maintain an even operating temperature. The cooling water also circulates through the exhaust system to keep it cool. The 4004, 4011, 4014 and 4016 models and the 4018, 4019, 4024, 4026 have a modified cooling system with a different cooling water flow through the thermobaric housing and the exhaust lines.

The 401, 403, 405 and 406 have a displacement of 400 cm³ (24.45 cu in.).

The 400 engines use a traditional electronic ignition system.



Volvo Penta Aq 434 Manual

Hussin A.Rothana



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[illegible]