

## Tightening torques-protractor (angle) tightening



Tightening using both a torque setting and a protractor angle requires that the recommended torque is applied using a torque wrench and then the recommended angle is added according to the protractor scale. Example: a 90° protractor tightening means that the joint is tightened a further 90° 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 bolt head. A high number indicates stronger material, for example a bolt marked 10.9 indicates a higher tolerance than one marked 8.8. It is therefore important that bolts removed during the dismantling of a locked joint must be reinstalled in their original position when assembling the joint. 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 joint 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 in 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 lock-tight 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 cap 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 thermobar housing and the exhaust flange.

The 401, 403, 405 and 406 have a displacement of 400 cm<sup>3</sup> (24.2 cu in.).

The 400 engines use a mechanical electronic ignition system.



# Volvo Penta Aq 434 Manual

**O García**



## **Volvo Penta Aq 434 Manual:**

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## **Table of Contents Volvo Penta Aq 434 Manual**

1. Understanding the eBook Volvo Penta Aq 434 Manual
  - The Rise of Digital Reading Volvo Penta Aq 434 Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Volvo Penta Aq 434 Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Volvo Penta Aq 434 Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Volvo Penta Aq 434 Manual
  - Personalized Recommendations
  - Volvo Penta Aq 434 Manual User Reviews and Ratings
  - Volvo Penta Aq 434 Manual and Bestseller Lists
5. Accessing Volvo Penta Aq 434 Manual Free and Paid eBooks

- Volvo Penta Aq 434 Manual Public Domain eBooks
  - Volvo Penta Aq 434 Manual eBook Subscription Services
  - Volvo Penta Aq 434 Manual Budget-Friendly Options
6. Navigating Volvo Penta Aq 434 Manual eBook Formats
- ePub, PDF, MOBI, and More
  - Volvo Penta Aq 434 Manual Compatibility with Devices
  - Volvo Penta Aq 434 Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
- Adjustable Fonts and Text Sizes of Volvo Penta Aq 434 Manual
  - Highlighting and Note-Taking Volvo Penta Aq 434 Manual
  - Interactive Elements Volvo Penta Aq 434 Manual
8. Staying Engaged with Volvo Penta Aq 434 Manual
- Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Volvo Penta Aq 434 Manual
9. Balancing eBooks and Physical Books Volvo Penta Aq 434 Manual
- Benefits of a Digital Library
  - Creating a Diverse Reading Collection Volvo Penta Aq 434 Manual
10. Overcoming Reading Challenges
- Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Volvo Penta Aq 434 Manual
- Setting Reading Goals Volvo Penta Aq 434 Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Volvo Penta Aq 434 Manual
- Fact-Checking eBook Content of Volvo Penta Aq 434 Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development

- Exploring Educational eBooks

#### 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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