

TECHNICAL BULLETIN



Subject:
BLOWER FASTENER TORQUE SPECIFICATIONS

Bulletin #:	Rev:	ECR #:	Created by:	Date:
144290	A	123671	LNJ	2025-01-02

Department: Engineering: ___ Production: Service: Sales: ___ Product Lines: Transportation Equipment: ___ Pneumatic Equipment:

To ensure all components are properly positioned, secured, and sealed and that the assembled blower will function properly, the fasteners used to assemble the blower must meet the torque requirements outlined in **Table 1** through **Table 5** for each specific blower model size. Reference **Figure 1** through **Figure 15** for a visual representation of the location of each fastener.

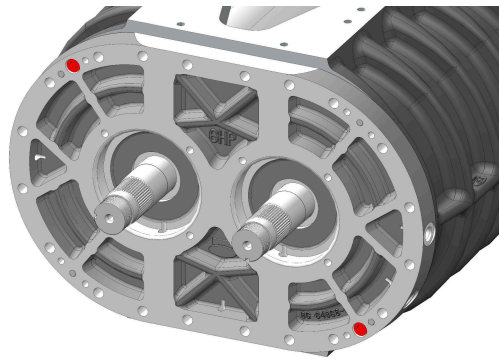


Figure 1: Headplate internal bolts

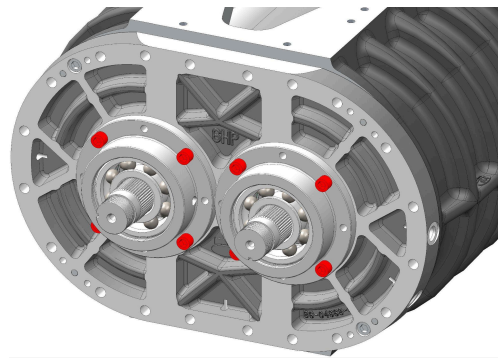


Figure 2a: Bearing cartridge bolts

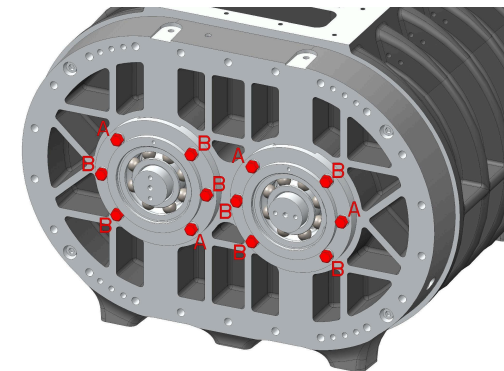


Figure 2b: Bearing cartridge bolts

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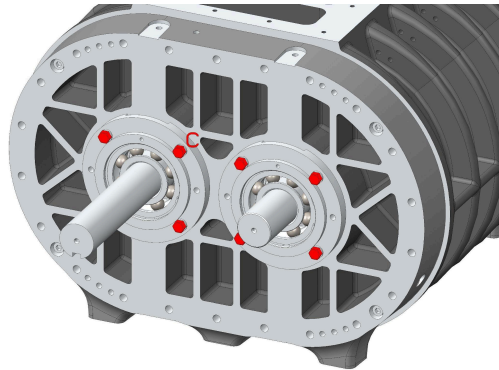


Figure 2c: Bearing cartridge bolts

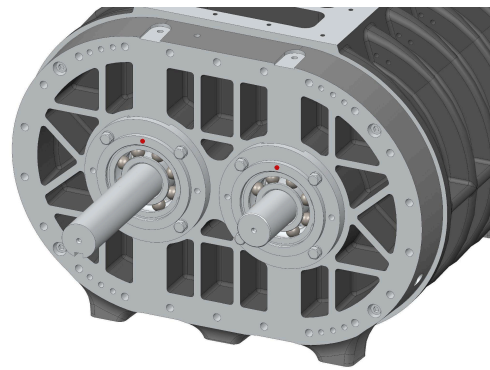


Figure 3: Bearing cartridge set screw

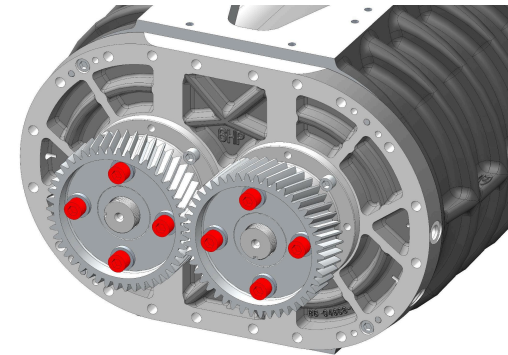


Figure 4a: Timing gear bolts

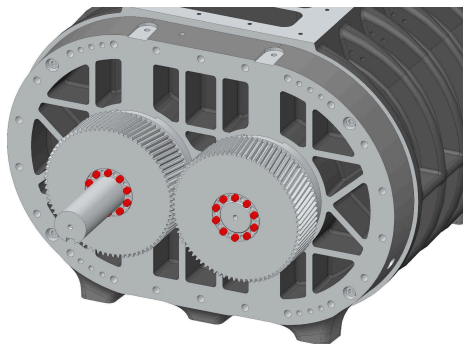


Figure 4b: Timing gear bolts

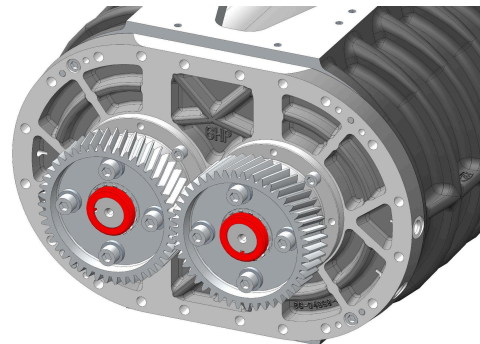


Figure 5: Shaft lock nut

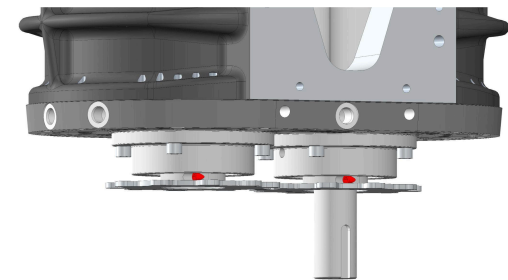


Figure 6: Oil slinger retainer

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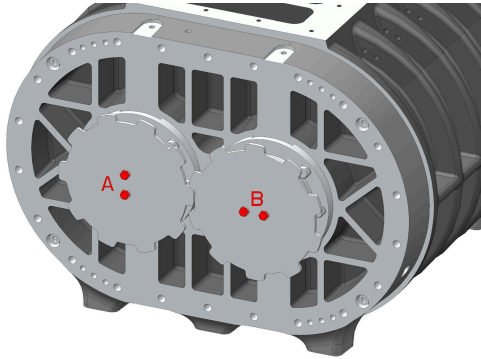


Figure 7: Oil slinger bolts

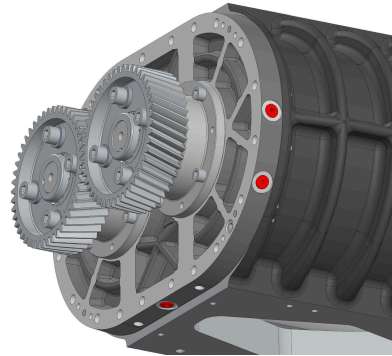


Figure 8: Zero-leak headplate plug

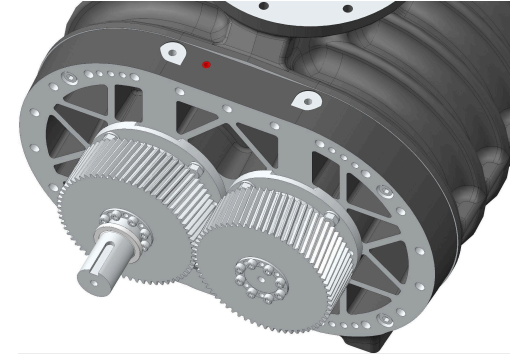


Figure 9: Headplate plug

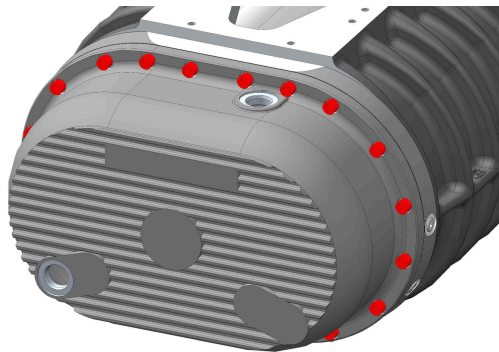


Figure 10: Cover bolts

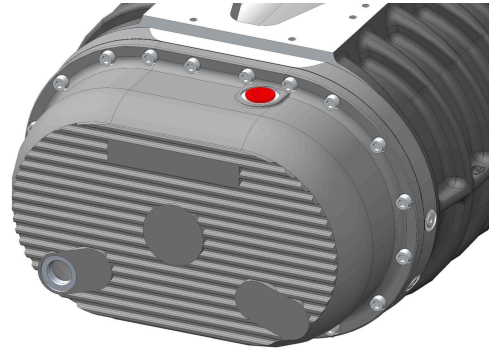


Figure 11: Headplate fill plug



Figure 12: Zero-leak sight glass

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Table 1: 506 blower fastener specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Headplate Internal Bolts	3/8-16-1	94-00179-6	4	Internal 5/16 hex	1/2	51 ft-lb
Fig 2a	Bearing Cartridge Bolts	5/16-18-1	94-00176-6	16	Internal 1/4 hex	1/2	29 ft-lb
Fig 4a	Timing Gear Bolts	3/8-16-1 1/4	94-00180-6	8	Internal 5/16 hex	1/2	51 ft-lb
Fig 5	Shaft Lock Nut	N-06	94-00139-6	2	SKF#TMFS-N6	1/2	230 ft-lb
Fig 6	Oil Slinger Retaining Collar	1/4-28-3/4	43-13540-6	1	Internal 3/16 hex	3/8	14 ft-lb
Fig 8	Zero Leak Plug	6MB	58-80675-6	10	Internal 1/4 hex	3/8	8 ft-lb
Fig 10	Cover Bolts	3/8-16-2 1/4	94-14069-6	32	Internal 5/16 hex	1/2	51 ft-lb
Fig 11	Zero Leak Fill Plug	12MB	58-19689-6	2	Internal 9/16 hex	1/2	8 ft-lb
Fig 12	Zero Leak Sight Glass	12MB	58-19690-6	2	External 5/16 hex	1/2	8 ft-lb

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Table 2: 510 blower fastener specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Headplate Internal Bolts	3/8-16-1	94-00179-6	4	Internal 5/16 hex	1/2	51 ft-lb
Fig 2a	Bearing Cartridge Bolts	5/16-18-1	94-00176-6	16	Internal 1/4 hex	1/2	29 ft-lb
Fig 4a	Timing Gear Bolts	3/8-16-1 1/4	94-00180-6	8	Internal 5/16 hex	1/2	51 ft-lb
Fig 5	Shaft Lock Nut	N-06	94-00139-6	2	SKF#TMFS-N6	1/2	230 ft-lb
Fig 6	Oil Slinger Retaining Collar	1/4-28-3/4	43-13540-6	1	Internal 3/16 hex	3/8	14 ft-lb
Fig 8	Zero Leak Plug	6MB	58-80675-6	10	Internal 1/4 hex	3/8	8 ft-lb
Fig 10	Cover Bolts	3/8-16-2 1/4	94-14069-6	32	Internal 5/16 hex	1/2	51 ft-lb
Fig 11	Zero Leak Fill Plug	12MB	58-19689-6	2	Internal 9/16 hex	1/2	8 ft-lb
Fig 12	Zero Leak Sight Glass	12MB	58-19690-6	2	External 5/16 hex	1/2	8 ft-lb

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Table 3: 614 blower fastener specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Headplate Internal Bolts	3/8-16-1	94-00179-6	4	Internal 5/16 hex	1/2	51 ft-lb
Fig 2a	Bearing Cartridge Bolts	3/8-16-1	94-08494-6	16	Internal 5/16 hex	1/2	51 ft-lb
Fig 4a	Timing Gear Bolts	1/2-13-1 1/2	94-07213-6	8	Internal 3/8 hex	1/2	119 ft-lb
Fig 5	Shaft Lock Nut	N-07	94-07206-6	2	SKF#TMFS-N7	1/2	347 ft-lb
Fig 6	Oil Slinger Retainer	1/4-28	50-96072-6	2	Internal 3/16 hex	3/8	16 ft-lb
Fig 8	Zero Leak Plug	6MB	58-80675-6	8	Internal 1/4 hex	3/8	8 ft-lb
Fig 10	Cover Bolts	3/8-16-2 1/4	94-14069-6	40	Internal 5/16 hex	1/2	51 ft-lb
Fig 11	Zero Leak Fill Plug	12MB	58-19689-6	2	Internal 9/16 hex	1/2	8 ft-lb
Fig 12	Zero Leak Sight Glass	12MB	58-19690-6	2	External 1 1/4 hex	1/2	8 ft-lb

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Table 4: 816 blower fastener specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Headplate Internal Bolts	1/2-13-2 3/4	94-92365-6	8	External 9/16 hex	1/2	90 ft-lb
Fig 2a	Bearing Cartridge Bolts	1/2-13-1 3/4	94-05293-6	16	External 9/16 hex	1/2	90 ft-lb
Fig 3	Bearing Cartridge Set Screw	5/16-18-3/8	94-14258-6	4	Internal 5/32 hex	1/2	13 ft-lb
Fig 4b	Timing Gear Bolts	M8 x 55	97-76962-6	16	Internal 6mm hex	1/2	30 ft-lb
Fig 7	Oil Slinger Bolts	A 3/8-16-2	94-05320-6	2	External 9/16 hex	1/2	44 ft-lb
		B 3/8-16-2 1/2	94-05322-6	2			
Fig 8	Zero Leak Plug	6MB	58-80675-6	4	Internal 1/4 hex	3/8	8 ft-lb
Fig 9	Plug	4MP	58-00167-6	2	Internal 1/4 hex	3/8	8 ft-lb
Fig 10	Cover Bolts	1/2-13-4	94-05297-6	44	External 3/4 hex	1/2	90 ft-lb
Fig 11	Zero Leak Fill Plug	12MB	58-19689-6	4	Internal 9/16 hex	1/2	8 ft-lb
Fig 12	Zero Leak Sight Glass	12MB	58-19690-6	4	External 1 1/4 hex	1/2	8 ft-lb

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Table 5: 1020 blower fastener specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Headplate Internal Bolts	1/2-13-3 1/2	94-67672-6	8	Internal 3/8 hex	1/2	90 ft-lb
Fig 2b Fig 2c	Bearing Cartridge Bolts	A 1/2-13-1	94-05290-6	4	External 3/4 hex	1/2	90 ft-lb
		B 1/2-13-2	94-05294-6	8			
		C 1/2-13-1 3/4	94-05293-6	8			
Fig 3	Bearing Cartridge Set Screw	5/16-18-3/8	94-14258-6	4	Internal 5/32 hex	1/2	13 ft-lb
Fig 4b	Timing Gear Bolts	M8 x 55	50-71579-6	20	Internal 6mm hex	1/2	30 ft-lb
Fig 7	Oil Slinger Bolts	A 3/8-16-2 1/4	94-05321-6	2	External 9/16 hex	1/2	44 ft-lb
		B 3/8-16-2 3/4	94-05323-6	2			
Fig 8	Zero Leak Plug	6MB	58-80675-6	4	Internal 1/4 hex	3/8	8 ft-lb
Fig 9	Plug	4MP	58-13838-6	2	External 5/8 hex	1/2	8 ft-lb
Fig 10	Cover Bolts	1/2-13-4	94-05297-6	44	External 3/4 hex	1/2	90 ft-lb
Fig 11	Zero Leak Fill Plug	12MB	58-19689-6	4	Internal 9/16 hex	1/2	8 ft-lb
Fig 12	Zero Leak Sight Glass	12MB	58-19690-6	4	External 1 1/4 hex	1/2	8 ft-lb