



## **Threaded Fastener Replacement on 2017-2018 GM 6.6L Duramax L5P Diesel Engines**

The AERA Technical Committee offers the following information on selective bolt replacement on 2017-2018 GM 6.6L, L5P Duramax diesel engines. This information should be referenced anytime the engine is worked on. It is GM's recommendation to replace certain engine bolts anytime they've been removed.

On the following page is a chart of engine fasteners should not be reused during engine assembly for these Duramax diesel engines. The appropriate torque values are also supplied.



**Single Use Threaded Fastener/Component Tightening Specifications**

<b>Note:</b> All fasteners/components listed in this table MUST BE DISCARDED and replaced with NEW after removal.	
<b>Application</b>	<b>Specification</b>
	<b>Metric (English)</b>
Camshaft Gear Bolt	235 Nm (173 lb ft)
Connecting Rod Bolt	
● First Pass:	64 Nm (47 lb ft)
● Final Pass:	30 degrees
Crankshaft Balancer Bolt	
● First Pass:	100 Nm (74 lb ft)
● Final Pass:	90 degrees
Crankshaft Bearing Cap Bolt	
● First Pass:	98 Nm (72 lb ft)
Second Pass:	132 Nm (97 lb ft)
● Final Pass:	60 degrees
Crankshaft Bearing Cap Bolt - Side	70 Nm (52 lb ft)
Cylinder Head Bolt M12	
● First Pass:	80 Nm (59 lb ft)
● Final Pass:	120 degrees
Cylinder Head Bolt M8	32 Nm (24 lb ft)
Engine Flywheel Bolt	
● First Pass:	79 Nm (58 lb ft)
Second Pass:	60 degrees
● Final Pass:	60 degrees
Fuel High Pressure Pipe	32.5 Nm (24 lb ft)
Fuel Injection Fuel Rail Bracket Bolt	
● First Pass:	10 Nm (89 lb in)
● Final Pass:	90 degrees
Fuel Injection Pump Bolt (1-2)	
● First Pass:	8 Nm (71 lb in)
● Final Pass:	25 Nm (18 lb ft)
Fuel Injection Pump Bolt (3)	
● First Pass:	4 Nm (35 lb in)
● Final Pass:	15 Nm (11 lb ft)
Fuel Injection Pump Nut	78 Nm (58 lb ft)
Glow Plug	17 Nm (13 lb ft)
Oil Filter	
● 3/4 to 1 full turn after gasket makes contact with the sealing surface on the filter mounting flange	
Valve Rocker Arm Cover Bolt	
● First Pass:	10 Nm (89 lb in)
● Final Pass:	90 degrees

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