PRECISION TURBO & ENGINE
A Wabtec company

TURBINE HOUSING INSTALLATION

**** All torque values are in conjunction with a copper based anti-seize lubricant ****

Flat strap style turbine housing mounting clamp installation.

Lay turbine housing flat with the turbine housing mounting bolt hole locations facing up.
Carefully install turbo into the turbine housing.
Place the turbine housing mounting clamps onto the turbine housing and line up the bolt holes in the clamps with the bolt holes in the turbine housing.
Apply anti-seize to the bolt threads and install bolts into the turbine housing.
Rotate the turbo to the desired position and tighten the turbine housing clamp bolts in a crisscross pattern.
Torque 5/16 -18 Bolt to 20 - 25 ft-lbs. / 240 - 300 in-lbs.
Torque M8 x 1.25 Bolt to 20 - 23 ft-lbs. / 240 - 276 in-lbs.

V-Band style turbine housing mounting clamp installation.

Lay turbine housing flat with the discharge facing down and the turbo mounting flange facing up.
Carefully remove the nut from the v-band clamp and set nut aside.
Carefully stretch the v-band clamp over the mounting flange on the turbine housing.
Now carefully install the turbo into the turbine housing.
Move the v-band clamp into position and slide the bolt back into the v-band clamp.
Apply anti-seize onto the v-band bolt threads and install the nut.
Rotate the turbo to the desired position and tighten the v-band clamp nut.
Torque 1/4 - 28 Nut for V-Band clamp to 8 - 9 ft.-lbs. / 96 - 108 in-lbs.