23 14 Electrical fittings

	Type	Thread	Tightening specification	Measure
1AZ Reversing light switch	G / H / I / transmission	M12		16 Nm
2AZ Zero gear sensor to transmission	G / H / I /transmission			5 Nm

	Type	Thread	Tightening specification	Measure
2AZ Transmission to clutch housing	B / C / D / E / F / G / H / I / J-transmission	M12		76 Nm
3AZ Reinforcement plate to transmission	B / C / D / E / F / G / H / I / J-transmission	M8		23 Nm
4AZ Oil drain plug / filler plug	B / C-transmission			50 Nm
	D / E-transmission			52 Nm
	G / H-transmission	M18x1.5 hexagon socket		35 Nm
	H / I-transmission	M12x1.5		25 Nm
	J-transmission			40 Nm
5AZ Transmission extension	g / H transmission	M10		46 Nm

	Type	Thread	Tightening specification	Measure
1AZ Transmission to engine Transmission designations, see 23...				
Hex screws	B / C / D / E / F / G / H / I / J-transmission	M6		9 Nm
	B / C / D / E / F / G / H / I / J-transmission	M8		25 Nm
	B / C / D / E / F / G / H / I / J-transmission	M10		49 Nm
	B / C / D / E / F / G / H / I / J-transmission	M12		74 Nm
Torx bolt	B / C / D / E / F / G / H / I / J-transmission	M6		9 Nm
	B / C / D / E / F / J-transmission	M8		22 Nm
	B / C / D / E / H / I / J transmission	M10		43 Nm
	G transmission	M10		38 Nm
	J-transmission	M10x55 8.8		43 Nm
	J-transmission	M10x42 8.8		42 Nm
Steel screws with Torx head	I / G / H-transmission	M8		19 Nm
Steel screws with Torx head	I / G / H-transmission	M12		66 Nm
2AZ Transmission to N52/N52K/N53/N54 aluminium screws marked blue	I / G / H-transmission			

			Replace screws Jointing torque and angle of rotation must be observed without fail	
	I / G / H-transmission	M10x30	Jointing torque Torque angle	20 Nm 90-110 °
	I / G / H-transmission	M10x85	Jointing torque Torque angle	20 Nm 180-200 °
	I / H / G-transmission	M12	Jointing torque Torque angle	25 Nm 130 °
3AZ Cover plate, transmission	I / H-transmission	M6		8 Nm

	Type	Thread	Tightening specification	Measure
1AZ Transmission housing, rear section/front section	B / C / D / E / F / G / H / I / J-transmission			22 Nm
2AZ Cover with guide tube/transmission case	B / C / D / E / F / G / H / I / J-transmission	M8 x 22		18 Nm
	B / C / D / E / F / G / H / I / J-transmission	M8 x 30		25 Nm
	B / C / D / E / F / G / H / I / J-transmission	M6		10 Nm
3AZ Bearing cap/sealing flange	B / C / D / E / F / G / H / I / J-transmission			10.5 Nm
4AZ Reverse gear wheel axle to intermediate housing	B / C / D / E / F / G / H / I / J-transmission			49 Nm
5AZ Retaining plate for reverse gear wheel axle to intermediate housing	B / C / D / E / F / G / H / I / J-transmission			25 Nm
6AZ Transmission closing plate	B / C / D / E / F / G / H / I / J-transmission	M6		8 Nm

	Type	Thread	Tightening specification	Measure
16AZ Holder to transfer case	265 / Sport	M6		9 Nm
17AZ Retaining plates for bearings on housing	S5D 310Z / S5D 320Z / S5D 200G / S5D 250G	M6		10 Nm
18AZ Retaining plate to housing	S5D 320Z SMG	M6		5.5 Nm

23 14 Electrical fittings

	Type	Thread	Tightening specification	Measure
1AZ Reversing light switch	G / H / I / transmission	M12		16 Nm
2AZ Zero gear sensor to transmission	G / H / I /transmission			5 Nm

	Type	Thread	Tightening specification	Measure
1AZ Output flange	S5D 200G / S5D 250G / S5D260Z / S5D 310Z / S6S 420G		Collar nut installed with bolt cement Pretension Release Tighten down	 190 Nm 120 Nm
	S5D 280Z / S5D 320Z		Collar nut installed with bolt cement Pretension Release Tighten down	 170 Nm 130 Nm
	S5D 390Z		Collar nut installed with bolt cement Pretension Release Tighten down	 200 Nm 145 Nm
	GS6-37BZ / GS6-17BG		Collar nut installed with bolt cement Pretension Release Tighten down	 170 Nm 120 Nm
	GS6-53DZ		Collar nut installed with bolt cement Pretension Release Tighten down	 200 Nm 140 Nm
	GS7S47BG		Collar nut installed with bolt cement	200 Nm

2AZ Gear to countershaft	265 / Sport	M10		60 Nm

23 31 Interior Shift Components

	Type	Thread	Tightening specification	Measure
1AZ Shift arms to transmission case	S5D 310Z			45 Nm
2AZ Sealing cap for locking sleeves of gearshift rods	S6S 420G	M6		10 Nm
3AZ Retaining screw, shift actuator / selector shaft	S5D 320Z / S6S37BZ / S6S53BZ SMG	M6		10 Nm

	Type	Thread	Tightening specification	Measure
1AZ Servomotor / actuator to transmission housing Insert screws with screw securing adhesive	S6S 420G / GS6S37BZ / GS7S47BG / GS6S53BZ SMG transmission	M6		10 Nm
2AZ Switch for gear recognition to servomotor	S6S 420G SMG transmission	M5		6 Nm
3AZ Hydraulic lines to servomotor	S6S 420G SMG transmission	M12x1		17 Nm
4AZ Actuator to transmission casing	S6S 420G SMG transmission	M8		25 Nm
5AZ Reversing light switch	B / C / D / E / F / G / H / I / J-transmission	M12		16 Nm
6AZ Pressure accumulator to valve block	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission			30 Nm
7AZ Protective plate Expansion tank Shift actuator Hydraulic pump Valve block to transmission housing Ground strap to transmission housing	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission	M6		10 Nm
8AZ Protecting plate / valve block to transmission housing /	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission	M8		20 Nm

9AZ Valves to valve block	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission	M4		3.5 Nm
10AZ Pressure sensor to valve block	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission			15 Nm
11AZ Shift/selector sensor to transmission housing	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission	M4		2.8 Nm
12AZ Retaining screw for hydraulic line	GS5S31BZ / GS6S53BZ / GS6S37BZ SMG transmission			18 Nm
13AZ Banjo bolt for hydraulic line	GS5S31BZ SMG transmission			16 Nm
14AZ Heat shield to expansion tank/ pump bracket	GS6S37BZ SMG transmission			6 Nm
15AZ Clutch speed sensor	GS6S53BZ / GS6S37BZ SMG transmission			35 Nm
16AZ Transmission oil cooler to transmission	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission	M6x35		10 Nm
17AZ Transmission oil screen in transmission oil cooler	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission	M18		25 Nm
18AZ Banjo bolt to transmission oil cooler				

	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission	M16x1.5		40 Nm
19AZ Union nut to screwed socket	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			40 Nm
20AZ Oil cooler connection to transmission oil cooler	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			40 Nm
21AZ Oil pump to transmission oil cooler	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission	M6x20		10 Nm
22AZ Speed sensor to transmission	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission	M6x16		10 Nm
23AZ Temperature and pressure sensor to hydraulic unit	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			15 Nm
24AZ Clamp, pressure accumulator to transmission	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			22 Nm
25AZ Pressure accumulator to pump block	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			29 Nm
26AZ Pump block to transmission	E60 / E63 / E64 / E61 / GS7S47BG SMG			22 Nm

27AZ Banjo bolts, pressure lines clutch actuator and pump block	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			25 Nm
28AZ Screws, actuator block	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			25 Nm
29AZ Union nut, hydraulic line, actuator block	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			11 Nm
30AZ Pump to electric motor	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			5 Nm
31AZ Electric motor to pump block	E60 / E63 / E64 / E61 / GS7S47BG SMG transmission			5 Nm

23 71 Transmission mounts

	Type	Thread	Tightening specification	Measure
1AZ Transmission mounts (rubber) to body	B / C / D / E / F / G / H / I / J-transmission	M10		42 Nm
	B / C / D / E / F / G / H / I / J-transmission	M12		73 Nm
2AZ Transmission cross-member to body	B / C / D / E / F / G / H / I / J-transmission	M10		42 Nm
	B / C / D / E / F / G / H / I / J-transmission	M8		19 Nm
	B / C / D / E / F / G / H / I / J-transmission	M8	E83, E85, E86, E46 only	21 Nm
3AZ Mount bracket to transmission	B / C / D / E / F / G / H / I / J-transmission	M8		19 Nm
4AZ Transmission support block to transmission	B / C / D / E / F / G / H / I / J-transmission	M10 ASA screw		38 Nm
	B / C / D / E / F / G / H / I / J-transmission	M10 ISA pan head		48 Nm
5AZ Transmission mount to transmission support bracket/transmission cross-member	B / C / D / E / F / G / H / I / J-transmission	M8		19 Nm