	Type	Thread	Tightening specification	Measure
1AZ Transmission to engine				
Hex screws	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M8		24 Nm
Hex screws	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M10		45 Nm

Hex screws

	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M12		82 Nm
Torx bolts	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R	M8		21 Nm
Torx bolts	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R	M10		42 Nm
Torx bolts	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R	M12		72 Nm
Torx bolts	GA6HP19Z / GA6HP26Z	M6		9 Nm

Steel Torx screws	GA6HP19Z / GA6L26Z / GA6L45R	M8		19 Nm
Steel Torx screws	GA6HP19Z / GA6HP26Z / GA6L45R	M12		66 Nm
2AZ Transmission to engine N51/N52/N54/N53/N52K Aluminium screws are marked blue	GA6HP19Z / GA6HP26Z / GA6L45R		Replace screws Jointing torque and angle of rotation must be observed without fail	
	GA6HP19Z / GA6L45R	M10x30	Jointing torque Torque angle	20 Nm 90-110 °
	GA6HP19Z	M10x85	Jointing torque Torque angle	20 Nm 180-200 °
	GA6HP19Z / GA6L45R	M12	Jointing torque Torque angle	25 Nm 130 °
3AZ Reinforcement shell to transmission/extension	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R/A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M8		23 Nm
4AZ Cover plate for transmission	GA6HP19Z / GA6L45R	M6		9 Nm
5AZ Heat shield, oil sump	GA6L45R	M6		8 Nm

	Type	Thread	Tightening specification	Measure
8AZ Oil filler pipe	3HP-22			105 Nm
	4HP-22 / 4HP-24 / A5S 310Z			98 Nm
9AZ Plug	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M18		43 Nm
10AZ Oil duct screw plugs	A5S 300J			8 Nm
	A5S 310Z / A5S 560Z			15 Nm
11AZ Damper cover on transmission case	A5S 300J	M6		10 Nm
12AZ Radial shaft seal to converter housing	A4S 270R / A4S 310R / A5S 360R / A4S 360R	M4		3 Nm
13AZ Intermediate plate on intermediate housing	A4S 270R / A4S 310R	5/16 inch		25 Nm

24 11 Transmission housing, transmission oil sump

	Type	Thread	Tightening specification	Measure
1AZ Transmission extension	A4s 200R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M8		25 Nm
	A4S 270R / A4S 310R	5/16 inch		32 Nm
	A5S 360R / A4S 360R	M8		22 Nm
2AZ Guard	A4s 200R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		9 Nm
3AZ Converter housing	A4s 200R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M8		25 Nm
	4HP-22 / 4HP-24	M10		46 Nm

	A4S 270R / A4S 310R	1/2"		42 Nm
4AZ Screw plug to intermediate plate	A4s 200R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M10		16 Nm
	4HP-22 / 4HP-24	M14		40 Nm
	4HP-22 / 4HP-24	M20		50 Nm
	A5S 440Z	M12		23 Nm

	Type	Thread	Tightening specification	Measure
5AZ Transmission oil sump	4HP-22 / 4HP-24 / A5S 310Z / A5S 325Z	M6		6 Nm
	A5S 560Z / A5S 440Z	M6		10 Nm
	A4S 270R / A4S 310R	M6		12 Nm
	A5S 360R / A4S 360R	M6		10 Nm
	A5S 300J			9 Nm
	GA6HP26Z / GA6HP19Z / GA6L45R / GA6HP32Z	M6		10 Nm
6AZ Oil drain plug	A4S 200R / A5S 310Z /	M10		16 Nm
	A5S 325Z			35 Nm
	A5S 440Z	M16x1.5		30 Nm
	A5S 560Z			50 Nm
	A5S 360R / A5S 390R	M14		18 Nm
	A4S 270R / A4S 310R			25 Nm
	A5S 300J			35 Nm
	GA6L45R	M12x1.75		14 Nm
	GA6HP19Z / GA6HP26Z / GA6HP32Z	M10x1	Metal oil sump	12 Nm
	GA6HP19Z / GA6HP26Z / GA6HP32Z	M16x1.5 M24x1	Plastic oil sump	8 Nm
7AZ Oil filler plug	A5S 325Z			30 Nm

	A5S 310Z / A5S 560Z			100 Nm
	A5S 440Z	M18x1.5		35 Nm
	A4S 270R / A4S 310R			33 Nm
	A5S 360R / A4S 360R	M14		18 Nm
	A5S 300J			40 Nm
	GA6HP26Z / GA6HP32Z	M30x1.5		80 Nm
	GA6HP19Z / GA6HP26Z / GA6HP32Z	M18x1.5		35 Nm
	GA6L45R	M18x1.5		19 Nm

	Type	Thread	Tightening specification	Measure
1AZ Slotted nut/output flange	A5S 310Z / A5S 440Z / A5S 560Z / A5S 325Z			120 Nm
2AZ Double hexagon nut/output flange	GA6HP26Z / GA6HP19Z			80 Nm
3AZ Output shaft nut to output flange	GA6L45R	22x1.5		55 Nm

	Type	Thread	Tightening specification	Measure
1AZ Position switch on transmission	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		10 Nm

	Type	Thread	Tightening specification	Measure
1AZ Flange nut, output flange	A5S 300J			225 Nm
Flange nut, output flange without spring washer	A5S 360R			30 Nm
Flange nut, output flange, with spring washer	A5S 360R / A5S 390R / A4S 200R			60 Nm
	A4S 270R / A4S 310R			100 Nm

	Type	thread	tightening specification	Measure
1AZ Brake coupling D/G on gear box housing	A5S 310Z / A5S 560Z	M10	Insert all screws until contact is made with screw head in each case	
			center bolt	30 Nm
			both outer screws	15 Nm
			center bolt	63 Nm
			both outer screws	30 Nm
			both outer screws	63 Nm

	Type	thread	tightening specification	Measure
1AZ Torx screws for F clutch on transmission case	4HP-22 / 4HP-24	M6		10 Nm
	/ A5S 560Z	M8		23 Nm
2AZ Brake band adjusting screw	A 4 S 270 R / A 4 S 310 R	5/16"		5 Nm
3AZ Lock nut of brake band adjusting screw	A 4 S 270 R / A 4 S 310 R	5/16"		21 Nm

	Type	Thread	Tightening specification	Measure
1AZ Valve body to transmission	3HP-22	M6		11 Nm
	4HP-22 / 4HP-24 / A5S 310Z / A5S 440Z / A5S 300J / A5S 325Z / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		8 Nm
	A4S 270R / A4S 310R	5/16 inch		20 Nm
	A5S 360R / A4S 360R	M6		11 Nm
	A5S 560Z	M6 x 12		6 Nm
	A5S 560Z	M6 x 55		8 Nm
	GA6L45R	M5 Torx		8 Nm
2AZ Valve housing to valve body	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 310Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		5 Nm
3AZ Adapter plate on shift unit	A4S 270R / A4S 310R			13 Nm
4AZ Input and output speed sensors to mechatronics		M6		12 Nm

	Type	Thread	Tightening specification	Measure
1AZ Governor flange to transmission	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M8		16 Nm
2AZ Threaded pin to centrifugal governor	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		3 Nm
3AZ Hexagon nut to threaded pin	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z			10 Nm

4AZ Hexagon head screw on centrifugal governor	A4S 200R / A4S 270R / A4S 310R / A5S 300J / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6HP32Z	M6		11 Nm
5AZ Governor housing to hub	4HP-22H	M6		11 Nm

	Type	thread	tightening specification	Measure
7AZ Pulse generator, output speed	A5S 325Z			6 Nm
8AZ Pulse generator, turbine speed	A5S 325Z			8 Nm
9AZ Plug	A5S 325Z			20 Nm

	Type	Thread	Tightening specification	Measure
1AZ Pressure regulator to valve housing	4HP-22EH / 4HP-24EH / A5S 310Z	M6		5 Nm
	A4S 270R / A4S 310R			10 Nm
2AZ Solenoid valve to valve housing	4HP-22EH / 4HP-24EH / A5S 310Z	M6		5 Nm
	A4S 270R / A4S 310R			10 Nm
	A5S 560Z			6 Nm
	A5S 300J	M5		3 Nm
	A5S 300J	M6		8 Nm
3AZ Guide Plate / Parking Lock Mechanism	A5S 310Z			10 Nm
	A5S 325Z			10 Nm
	A5S 560Z			23 Nm
	A5S 360R / A4S 360R	M6		21 Nm
	A5S 440Z	M6		10 Nm
4AZ Pulse sender	A5S 310Z / A5S 440Z	M5		5 Nm
	A5S 560Z	M5		6 Nm
		M8		23 Nm
	A5S 360R / A4S 360R	M6		11 Nm
	A5S 300J	M5		6 Nm
5AZ Cover for servo piston on shift unit	A4S 270R / A4S 310R	5/16 inch		25 Nm
6AZ Retaining plate for solenoid valves and pressure regulator on shift unit	A5S 440Z	M5		5 Nm

	A5S 325Z			6 Nm
7AZ Retaining plate for solenoid valves and EDS valves to hydraulic unit	GA6HP19Z / GA6HP26Z			5 Nm
8AZ Electronic module to hydraulic unit	GA6HP19Z / GA6HP26Z			8 Nm

	Type	thread	tightening specification	Measure
1AZ Transmission socket to case	4HP-22 EH / 4 HP-24EH / A5S 310Z	M26		12 Nm
	A4S 270R / A4S 310R	M26		14 Nm

	Type	Thread	Tightening specification	Measure
1AZ Torque converter to flywheel		M8		26 Nm
	A4S 270R / A4S 310R / A5S 310Z / A5S 300J / A5S 440Z / A5S 560Z / A5S 325Z / A4S 200R / GA6HP26Z / GA6HP19Z	M10 8.8		45 Nm
	A5S360/390R	M10		45 Nm
	A5S360/390R / GA6HP19Z / GA6HP26Z / GA6HP32Z / GA6L45R	M10 10.9		56 Nm

24 51 External shift linkage

	Type	Thread	Tightening specification	Measure
1AZ Selector lever on transmission	A4S 200R / A4S 270R / A4S 310R / A5S 310Z / A5S 325Z / A5S 440Z / A5S 560Z / A5S 360R / A5S 390R / GA6HP19Z / GA6HP26Z / GA6 HP32Z / GA6L45R	M8x1		10 Nm
	A5S 300J	M8		15 Nm

24 52 Interior Shift Elements

	Type	Thread	Tightening specification	Measure
1AZ Shift segment to shaft	A4S 270R / A4S 310R			22 Nm
	A5S 300J	M14x1.5		35 Nm
2AZ Detent spring on shift unit	A4S 270R / A4S 310R	5/16"		25 Nm

24 71 Transmission mounts

	Type	Thread	Tightening specification	Measure
1AZ Cross member to body	E36 / E38 / E39 / E46 / E53 / E85 / E86 / E83			21 Nm
	E60 / E61 / E63 / E64 / E66 / E67 / E68 / E65 / E83 / E81 / E87 / E93 / E92 / E91 / E90 / E88 / E82	M8		19 Nm
2AZ Rubber mounts to cross member or transmission	E36 / E38 / E39 / E46 / E53			21 Nm
	E81 / E60 / E61 / E63 / E64 / E65 / E66 / E87 / E93 / E92 / E91 / E90 / E87 / E86 / E85 / E68 / E67 / E88 / E82			19 Nm
	E83			73 Nm
3AZ Support tube to engine subframe	E36			42 Nm
4AZ Rubber mounts to carrier pipe	E36			21 Nm
5AZ Carrier plate	E36			21 Nm
6AZ Transmission support block to transmission				

	E60 / E61 / E63 / E64 / E87 / E85 / E86 / E87 / E90 / E91 / E92 / E93 / E81 / E82 / E88		ASA screw	38 Nm
	E60 / E61 / E63 / E64 / E87 / E85 / E86 / E87 / E90 / E91 / E92 / E93 / E81 / E82 / E88	M10	M10 ISA pan-head screw	48 Nm
7AZ Transmission mount to transmission support bracket/transmission cross-member	E60 / E61 / E63 / E64 / E87 / E90 / E91 / E92 / E93 / E81 / E82 / E88			19 Nm