

SERVICE DATA

Tightening torques

Ref numbers match the callouts on the parts diagram.

Tightening torques							
REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
5	Allen Screw	44 + 5 Nm (32 + 4 ft lbf)		660	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)	
6	Hex Head Bolt	180 + 20 Nm (133 + 15 ft lbf)		663	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)	
7	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)		666	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)	
8	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		669	Fitting	150 + 20 Nm (111 + 15 ft lbf)	
9	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		670	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
10	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)		674	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
19	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		677	Allen Screw	75 Nm (18 ft lbf)	
23	Threaded Plug	80 + 20 Nm (59 + 15 ft lbf)		686	Plug	70 + 10 Nm (52 + 7 ft lbf)	
28	Allen Screw	100 + 10 Nm (74 + 7 ft lbf)		688	Hex Head Bolt	75 + 10 Nm (55 + 7 ft lbf)	
38	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)		689	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
49	Allen Screw	1850 + 50 Nm (1364 + 37 ft lbf)		706	Allen Screw	25 Nm (18 ft lbf)	
56	Allen Screw	250 + 20 Nm (184 + 15 ft lbf)		757	Screw HATCON	22 Nm (16 ft lbf)	
110	Hexagonal Nut	530 + 30 Nm (391 + 22 ft lbf)		931	Allen Screw	1850 + 50 Nm (1364 + 37 ft lbf)	
113	Hex Head Bolt	1300 + 50 Nm (959 + 37 ft lbf)		932	Allen Screw	100 + 10 Nm (74 + 7 ft lbf)	
653	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		933	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)	
657	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)					