

SERVICE DATA

Tightening torques

Ref numbers match the callouts on the parts diagram.

Tightening torques							
REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
11	Screw HATCON	22 Nm (16 ft lbf)		618	Hex Head Screw	270 + 10 Nm (199 + 7 ft lbf)	
17	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)		620	Threaded Plug	25 + 5 Nm (18 + 4 ft lbf)	
19	Hex Head Screw	650 + 50 Nm (479 + 37 ft lbf)		621	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)	
26	Allen Screw	44 + 5 Nm (32 + 4 ft lbf)		623	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)	
32	Screw HATCON	22 Nm (16 ft lbf)		628	Screw HATCON	22 Nm (16 ft lbf)	
405	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		630	Hex Head Screw	75 + 10 Nm (55 + 7 ft lbf)	
423	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		633	Allen Screw	44 + 5 Nm (32 + 4 ft lbf)	
430	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)		703	Allen Screw	44 + 5 Nm (32 + 4 ft lbf)	
463	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		757	Screw HATCON	22 Nm (16 ft lbf)	
470	Hex Head Screw	530 + 30 Nm (391 + 22 ft lbf)		805	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)	
505	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		823	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)	
523	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		830	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
563	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		832	Grease Nipple	8 + 2 Nm (6 + 1 ft lbf)	
607	Fitting	70 + 5 Nm (52 + 4 ft lbf)		836	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
608	Fitting	150 + 20 Nm (111 + 15 ft lbf)		863	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)	
609	Fitting	70 + 5 Nm (52 + 4 ft lbf)		870	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
614	Allen Screw	75 Nm (18 ft lbf)	fix with Loctite 243	872	Grease Nipple	8 + 2 Nm (6 + 1 ft lbf)	
616	Screw HATCON	22 Nm (16 ft lbf)		876	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	