

SERVICE DATA

Tightening torques

Ref numbers match the callouts on the parts diagram.

Tightening torques							
REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
13	Hex Head Screw	650 + 50 Nm (479 + 37 ft lbf)		663	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)	
27	Hex Head Screw	530 + 30 Nm (391 + 22 ft lbf)		666	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)	
28	Allen Screw	44 + 5 Nm (32 + 4 ft lbf)		669	Fitting	150 + 20 Nm (111 + 15 ft lbf)	
29	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		670	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
30	Allen Screw	75 + 5 Nm (55 + 4 ft lbf)		671	Threaded Plug	25 + 5 Nm (18 + 4 ft lbf)	
31	Screw HATCON	22 Nm (16 ft lbf)		674	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
34	Screw HATCON	22 Nm (16 ft lbf)		677	Allen Screw	75 Nm (18 ft lbf)	fix with Loctite 243
404	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		688	Hex Head Screw	75 + 10 Nm (55 + 7 ft lbf)	
423	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		706	Allen Screw	25 Nm (18 ft lbf)	
430	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)		757	Screw HATCON	22 Nm (16 ft lbf)	
463	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		805	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)	
470	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)		823	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)	
505	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		830	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
523	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		836	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
563	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		863	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)	
653	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		870	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
657	Screw HATCON	22 Nm (16 ft lbf)		876	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)	
660	Screw HATCON	22 Nm (16 ft lbf)					