

SERVICE DATA

Tightening torques

Ref numbers match the callouts on the parts diagram.

Tightening torques							
REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
8	Screw HATCON	22 Nm (16 ft lbf)		606	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)	
13	Hex Head Screw	650 + 50 Nm (479 + 37 ft lbf)		610	Allen Screw	70 + 5 Nm (52 + 5 ft lbf)	
17	Screw HATCON	22 Nm (16 ft lbf)		611	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)	
27	Allen Screw	170 + 15 Nm (125 + 11 ft lbf)		613	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
28	Allen Screw	1850 + 50 Nm (1364 + 37 ft lbf)		614	Threaded Plug	25 + 5 Nm (18 + 5 ft lbf)	
29	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		615	Threaded Plug	50 + 10 Nm (37 + 7 ft lbf)	
404	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		616	Fitting	70 + 10 Nm (52 + 7 ft lbf)	
423	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		624	Fitting	180 + 20 Nm (133 + 15 ft lbf)	
430	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)		625	Allen Screw	1850 + 50 Nm (1364 + 37 ft lbf)	
463	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		629	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)	
470	Hex Head Screw	920 + 30 Nm (679 + 22 ft lbf)		634	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)	
505	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		639	Allen Screw	170 + 15 Nm (125 + 11 ft lbf)	
526	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		641	Allen Screw	170 + 15 Nm (125 + 11 ft lbf)	
566	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		706	Allen Screw	25 Nm (18 ft lbf)	
567	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		757	Screw HATCON	22 Nm (16 ft lbf)	
604	Screw HATCON	22 Nm (16 ft lbf)					