

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	600 + 30 Nm (443 + 22 ft lbf)		610	Hex Head Bolt	255 + 30 Nm (188 + 22 ft lbf)	
9	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)		612	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)	
19	Allen Screw	255 + 30 Nm (188 + 22 ft lbf)		617	Hex Head Screw	70 + 5 Nm (52 + 4 ft lbf)	
20	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)		619	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)	
23	Hex Head Bolt	180 + 20 Nm (133 + 15 ft lbf)		620	Fitting	70 + 5 Nm (52 + 4 ft lbf)	
26	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		621	Fitting	70 + 5 Nm (52 + 4 ft lbf)	
35	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)		624	Fitting	150 + 20 Nm (111 + 15 ft lbf)	
46	Allen Screw	75 + 10 Nm (55 + 7 ft lbf)		627	Threaded Plug	25 + 5 Nm (18 + 4 ft lbf)	
108	Allen Screw	530 + 30 Nm (391 + 22 ft lbf)		632	Hex Head Screw	75 + 10 Nm (55 + 7 ft lbf)	
110	Allen Screw	600 + 30 Nm (443 + 22 ft lbf)		633	Threaded Plug		40 + 5 (30 + 4 ft lbf)
114	Hex Head Bolt	75 + 10 Nm (55 + 7 ft lbf)		706	Allen Screw	75 Nm (18 ft lbf)	
607	Allen Screw	180 + 20 Nm (133 + 15 ft lbf)		757	Screw HATCON	22 Nm (16 ft lbf)	fix with Loctite 243
608	Allen Screw	19 + 5 Nm (14 + 4 ft lbf)					