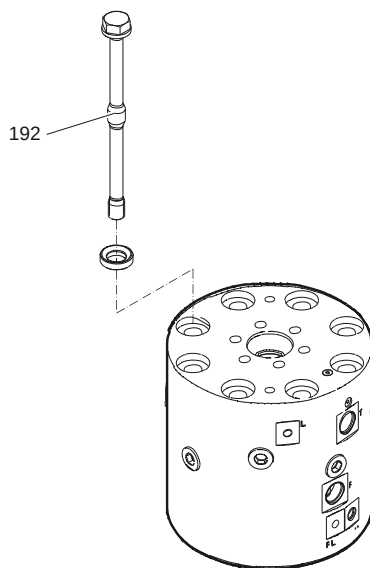


SERVICE DATA

Tightening torques

Ref numbers match the drawing.



Torque wrench or Power wrench size 41

1. Pretighten the bolts to 100 Nm (74 ft lbf), proceeding in a crosswise fashion,
2. pre-tighten the bolts to 100 Nm (74 ft lbf) again, proceeding in a crosswise fashion,
3. retighten each bolt through 60° (1 side of hexagonal head) in a crosswise fashion,
4. retighten each bolt through 90° (1.5 side of hexagonal head) in a crosswise fashion.

Tightening torques

REF	DESCRIPTION	TORQUE	NOTES
35	Allen Screw	10 Nm (7 ft lbf)	Allen key size 10
108	Allen Screw	200 Nm (148 ft lbf)	Allen key size 14
109	Fitting	330 Nm (243 ft lbf)	Open-end wrench size 46
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22
182	Plug	20 Nm (15 ft lbf)	Allen key size 5
192	Bolt		Torque wrench or Power wrench size 41
387	Non-Return Valve	200 Nm (148 ft lbf)	Socket wrench size 27

REF	DESCRIPTION	TORQUE	NOTES
553	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
554	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
555	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
557	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
558	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
587	Screw	22 Nm (16 ft lbf)	Security bit HATCON