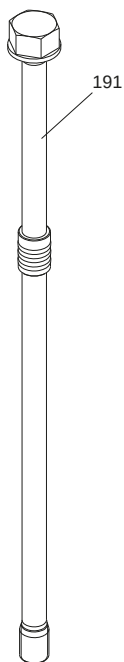


SERVICE DATA

Tightening torques

Ref numbers match the drawing.



Torque wrench or Power wrench size 55

1. Pretighten the tensioning bolts to 500 Nm (369 ft lbf), proceeding in a crosswise fashion,
2. then tighten each tensioning bolt through 120° (2 sides of hexagonal head) in a crosswise fashion,
3. finally tighten each tensioning bolt again through 150° (2.5 sides of hexagonal head) in a crosswise fashion.

Tightening torques

REF	DESCRIPTION	TORQUE	NOTES
22	Allen Screw	240 Nm (177 ft lbf)	Allen key size 22
24	Nut	240 Nm (177 ft lbf)	Socket spanner size 46
104	Allen Screw	380 Nm (280 ft lbf)	Allen key size 17
130	Non-Return Valve	200 Nm (148 ft lbf)	Socket wrench size 27
133	Allen Screw	130 Nm (96 ft lbf)	Allen key size 12
161	Allen Screw	350 Nm (258 ft lbf)	Allen key size 14
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22
182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5
191	Tensioning Bolt		Torque wrench or Power wrench size 55
196	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 30

REF	DESCRIPTION	TORQUE	NOTES
199	Allen Screw	20 Nm (15 ft lbf)	Allen key size 6
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
556	Fitting	50 Nm (37 ft lbf)	Open-end wrench size 17, 22, 27
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
559	Fitting	60 Nm (44 ft lbf)	Open-end wrench size 19, 22, 27
587	Screw	22 Nm (16 ft lbf)	Security bit HATCON