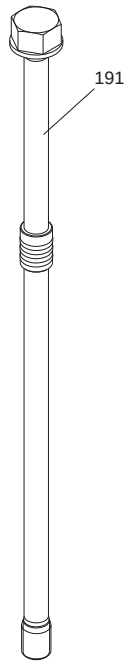


SERVICE DATA

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 120° (2 sides of hexagonal head) in a crosswise fashion.

Tightening torques

REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
22	Allen Screw	240 Nm (177 ft lbf)	Allen key size 22	199	Allen Screw	20 Nm (15 ft lbf)	Allen key size 6
24	Nut	240 Nm (177 ft lbf)	Socket spanner size 46	553	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
104	Allen Screw	380 Nm (280 ft lbf)	Allen key size 17	554	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
130	Non-Return Valve	200 Nm (148 ft lbf)	Socket wrench size 41	555	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
133	Allen Screw	130 Nm (96 ft lbf)	Allen key size 12	556	Fitting	50 Nm (37 ft lbf)	Open-end wrench size 17, 22, 27
161	Allen Screw	350 Nm (258 ft lbf)	Allen key size 14	557	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22	558	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5	559	Fitting	60 Nm (44 ft lbf)	Open-end wrench size 19, 22, 27
191	Tensioning Bolt		Torque wrench or Power wrench size 55	587	Screw	22 Nm (16 ft lbf)	Security bit HATCON
196	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 30				