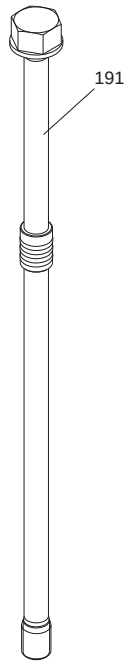


## SERVICE DATA

# Tightening torques

Ref numbers match the drawing.



Torque wrench or Power wrench size 65

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                                 | REF | DESCRIPTION    | TORQUE              | NOTES                             |
|-----|------------------|---------------------|---------------------------------------|-----|----------------|---------------------|-----------------------------------|
| 22  | Allen Screw      | 240 Nm (177 ft lbf) | Allen key size 22                     | 196 | Threaded Plug  | 300 Nm (221 ft lbf) | Socket spanner size 30            |
| 24  | Nut              | 240 Nm (177 ft lbf) | Socket spanner size 46                | 199 | Allen Screw    | 20 Nm (15 ft lbf)   | Allen key size 6                  |
| 33  | Allen Screw      | 85 Nm (63 ft lbf)   | Allen key size 10                     | 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         |
| 139 | Allen Screw      | 80 Nm (59 ft lbf)   | Allen key size 10                     | 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 65 | 587 | Screw          | 22 Nm (16 ft lbf)   | Security bit HATCON               |