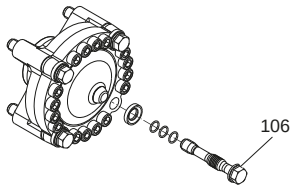
SERVICE DATA

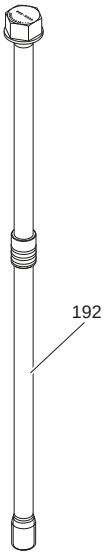
Tightening torques

Ref numbers match the drawing.



Socket spanner size 30

1. Treat the threads and threaded inserts for the fastening screws with an Anti-Seize agent.
2. Treat the surfaces between the fastening screw head, washer, and HP-accumulator cover with Anti-Seize.
3. Place on the HP-accumulator, and tighten the fastening screws by hand in a crosswise fashion.
4. Pretighten the fastening screws to 80 Nm (59 ft lbf), proceeding in a crosswise fashion,
5. then tighten each fastening screw through 30° in a crosswise fashion.
6.finally tighten each fastening screw again through 60° in a crosswise fashion.



Torque wrench or Power wrench size 75

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 180° (3 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 27
24	Nut	240 Nm (177 ft lbf)	Socket spanner size 55
33	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
104	Allen Screw	380 Nm (280 ft lbf)	Allen key size 17
106	Fastening Screw		Allen key size 30
116	Allen Screw	80 Nm (59 ft lbf)	Allen key size 10
122	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 30
125	Allen Screw	25 Nm (18 ft lbf)	Allen key size 6
126	Non-Return Valve	200 Nm (148 ft lbf)	Socket wrench size 41
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22

REF	DESCRIPTION	TORQUE	NOTES
182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5
192	Tensioning Bolt		Torque wrench or Power wrench size 75
553	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
561	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
562	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
566	Fitting	60 Nm (44 ft lbf)	Open-end wrench size 19, 22, 27
567	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
568	Fitting	50 Nm (37 ft lbf)	Open-end wrench size 17, 22, 27
569	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
587	Screw	22 Nm (16 ft lbf)	Security bit HATCON