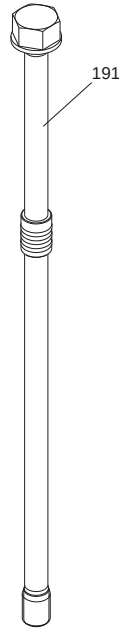


SERVICE DATA

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	REF	DESCRIPTION	TORQUE	NOTES
22	Allen Screw	240 Nm (177 ft lbf)	Allen key size 22	188	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 24
33	Allen Screw	200 Nm (148 ft lbf)	Allen key size 14	191	Tensioning Bolt		Torque wrench or Power wrench size 55
39	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	561	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
107	Threaded Plug	300 Nm (221 ft lbf)	Allen key size 22	562	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
110	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 24	564	Adapter	55 Nm (41 ft lbf)	Open-ended wrench size 19
130	Non-Return Valve	200 Nm (148 ft lbf)	Socket spanner size 41	565	Adapter	45 Nm (33 ft lbf)	Open-ended wrench size 19
139	Allen Screw	80 Nm (59 ft lbf)	Allen key size 10	566	Fitting	60 Nm (44 ft lbf)	Open-ended wrench size 19, 22, 27
150	Valve	250 Nm (184 ft lbf)	Allen key size 24	567	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
161	Fastening Screw	350 Nm (258 ft lbf)	Allen key size 14	568	Fitting	50 Nm (37 ft lbf)	Open-ended wrench size 17, 22, 27
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22	569	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5	587	Screw	22 Nm (16 ft lbf)	Security bit HATCON