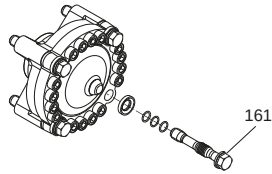


SERVICE DATA

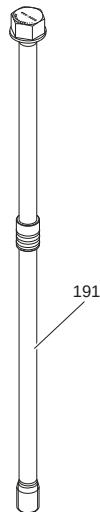
Tightening torques

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 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 180° (3 sides of hexagonal head) in a crosswise fashion.

Tightening torques

REF	DESCRIPTION	TORQUE	NOTES	REF	DESCRIPTION	TORQUE	NOTES
22	Allen Screw	2400 Nm (1770 ft lbf)	Allen key size 24	182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5
24	Nut	2400 Nm (1770 ft lbf)	Open-ended wrench size 55	188	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 24
34	Allen Screw	200 Nm (148 ft lbf)	Allen key size 14	191	Tensioning Bolt		Torque wrench or Power wrench size 55
36	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10	195	Valve	250 Nm (184 ft lbf)	Allen key size 24
44	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10	554	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
104	Allen Screw	380 Nm (280 ft lbf)	Allen key size 17	555	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10
107	Threaded Plug	300 Nm (221 ft lbf)	Allen key size 22	561	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
110	Threaded Plug	300 Nm (221 ft lbf)	Socket spanner size 24	562	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
130	Non-Return Valve	200 Nm (148 ft lbf)	Jaw spanner size 41	566	Fitting	60 Nm (44 ft lbf)	Open-ended wrench size 19, 22, 27
139	Allen Screw	80 Nm (59 ft lbf)	Allen key size 10	567	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
161	Fastening Screw		Socket spanner size 30	568	Fitting	50 Nm (37 ft lbf)	Open-ended wrench size 17, 22, 27
175	Allen Screw	80 Nm (59 ft lbf)	Allen key size 10	569	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22	587	Screw	22 Nm (16 ft lbf)	Security bit HATCON