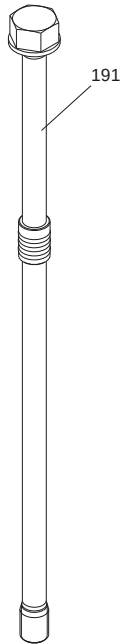


SERVICE DATA

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	561	Hydraulic Hose	42 Nm (31 ft lbf)	Open-ended wrench size 19
24	Nut	240 Nm (177 ft lbf)	Socket spanner size 46	562	Hydraulic Hose	16 Nm (12 ft lbf)	Open-ended wrench size 17
181	Filling Valve	130 Nm (96 ft lbf)	Socket spanner size 22	564	Adapter	55 Nm (41 ft lbf)	Open-ended wrench size 19
182	Threaded Plug	20 Nm (15 ft lbf)	Allen key size 5	565	Adapter	45 Nm (33 ft lbf)	Open-ended wrench size 19
191	Tensioning Bolt		Torque wrench or Power wrench size 55	566	Fitting	60 Nm (44 ft lbf)	Open-ended wrench size 19, 22, 27
314	Threaded Plug	300 Nm (221 ft lbf)	Allen key size 22	567	Fitting	55 Nm (41 ft lbf)	Open-ended wrench size 19, 22
318	Threaded Plug	350 Nm (258 ft lbf)	Allen key size 24	568	Fitting	50 Nm (37 ft lbf)	Open-ended wrench size 17, 22, 27
322	Threaded Plug	100 Nm (74 ft lbf)	Allen key size 12	569	Fitting	45 Nm (33 ft lbf)	Open-ended wrench size 17, 19, 22
330	Non-Return Valve	200 Nm (148 ft lbf)	Socket spanner size 41	587	Screw	22 Nm (16 ft lbf)	Security bit HATCON
396	Fitting	330 Nm (243 ft lbf)	Jaw spanner size 46/50	601	Plug	200 Nm (148 ft lbf)	Allen key size 17
554	Allen Screw	85 Nm (63 ft lbf)	Allen key size 10				