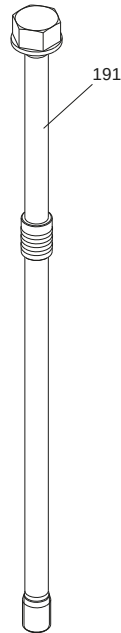


## SERVICE DATA

# 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 150° (2.5 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                          | 554 | Allen Screw    | 85 Nm (63 ft lbf)   | Allen key size 10                 |
| 24  | Nut              | 240 Nm (177 ft lbf) | Socket spanner size 46                     | 561 | Hydraulic Hose | 42 Nm (31 ft lbf)   | Open-ended wrench size 19         |
| 38  | Allen Screw      | 85 Nm (63 ft lbf)   | Allen key size 10                          | 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 |
| 309 | Threaded Plug    | 100 Nm (74 ft lbf)  | Allen key size 12                          | 567 | Fitting        | 55 Nm (41 ft lbf)   | Open-ended wrench size 19, 22     |
| 312 | 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 |
| 318 | Threaded Plug    | 300 Nm (221 ft lbf) | Allen key size 22                          | 569 | Fitting        | 45 Nm (33 ft lbf)   | Open-ended wrench size 17, 19, 22 |
| 320 | 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                 |