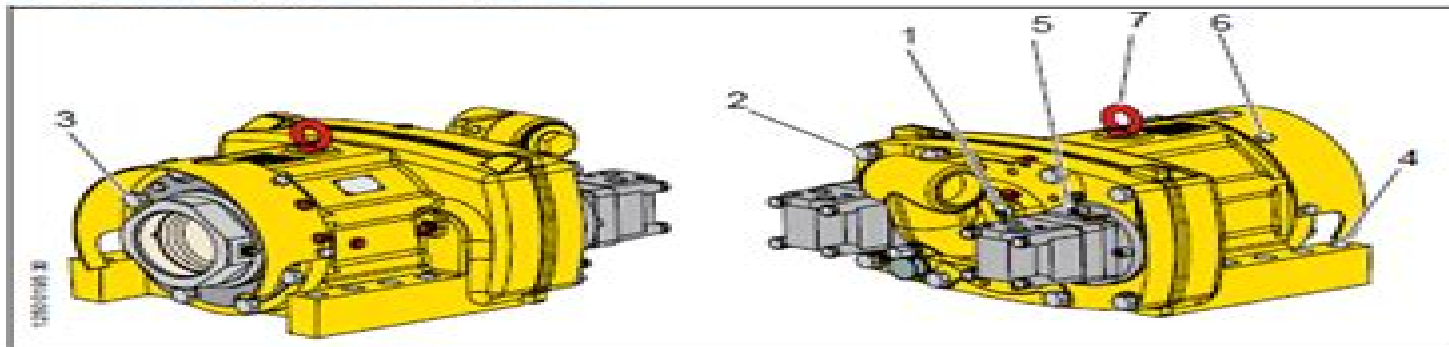


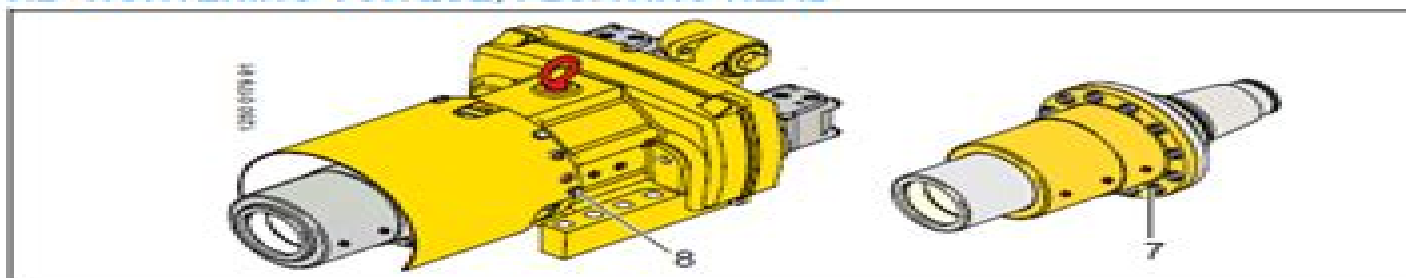
9. TIGHTENING TORQUES



9.1 TIGHTENING TORQUE, ROTATION UNIT

Ref. No.	Check point/Procedure Threaded unions	Tightening torques			
		Nm	Kpm	lbf.ft	Quantity
1	Air connection	79	8	58	4
2	Cover - Gear housing	171	17	126	8
3	Cover - Gear housing	171	17	126	8
4	Rotation unit - Cradle	350-400	35-40	258-295	8
5	Hydraulic motor - Cover	79	8	58	8
6	The protection's bolt				
7	Lifting eye	97	10	72	1
8	Lifting eye	57	6	42	1

9.2 TIGHTENING TORQUE, FLOATING HEAD



Ref. No.	Check point	Nm	Quantity
7	Adapter house screw	171*	12
8	The protection's bolt (hexagon head)	47	4

NB! Apply oil under the bolt's head and on the nut's threads. No oil may enter in between the flange surfaces.

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