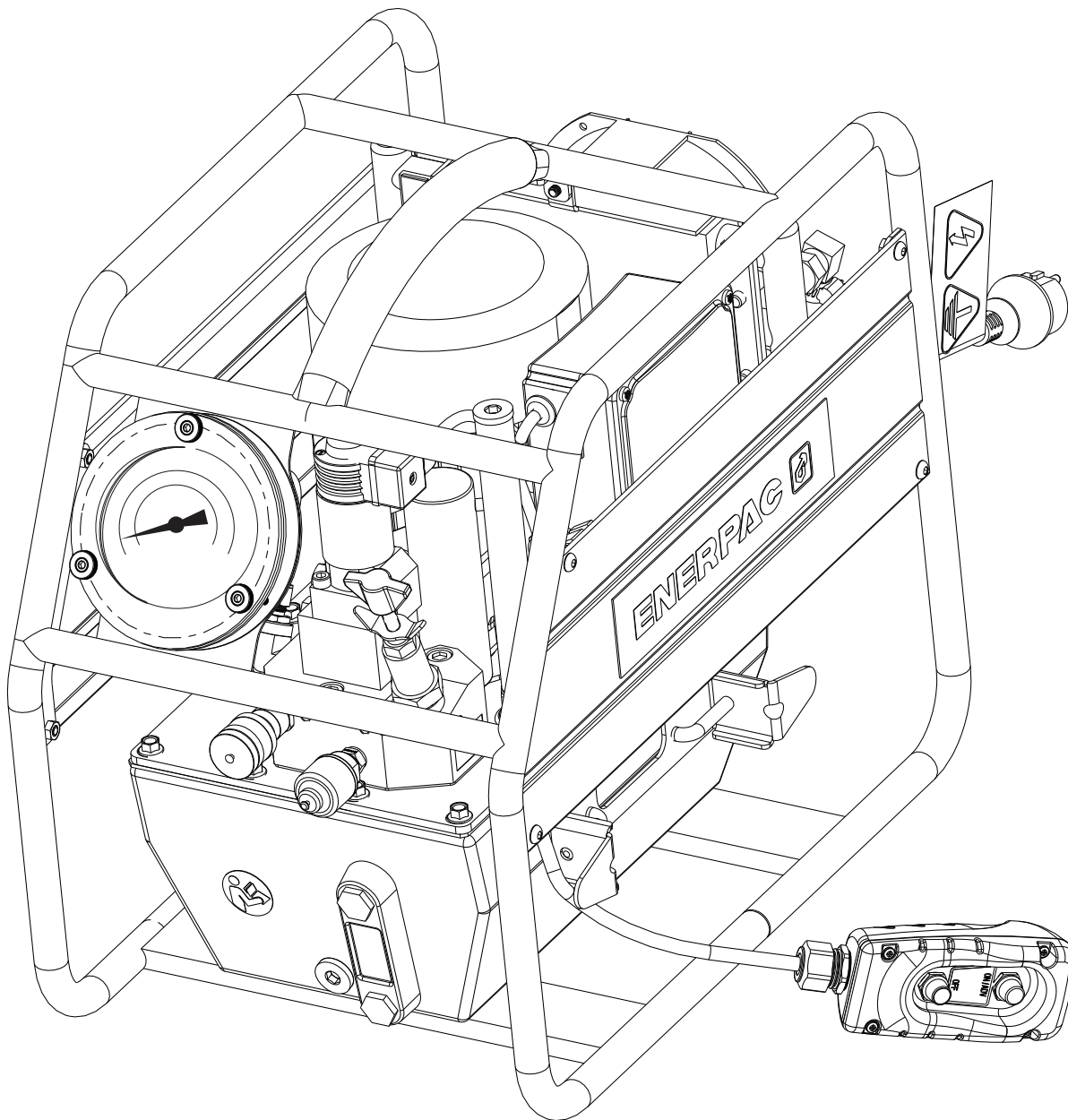


**TQ-700 Classic Bolting Pump
700 Bar [10000 psi]**

Document Number	Document Revision	Document Revision Date	Product Date Code Beginning With
L4071	F	08/2018	B



IMPORTANT: To maintain your warranty:

- Use only Enerpac Oil.
- Have your products inspected and repaired by an Enerpac Authorized Service Center.



WARNING: Disconnect electrical power and hydraulic hoses before beginning any maintenance or repairs. Standard safety procedures are to be followed during disassembly and reassembly to minimize any possibility of injury.

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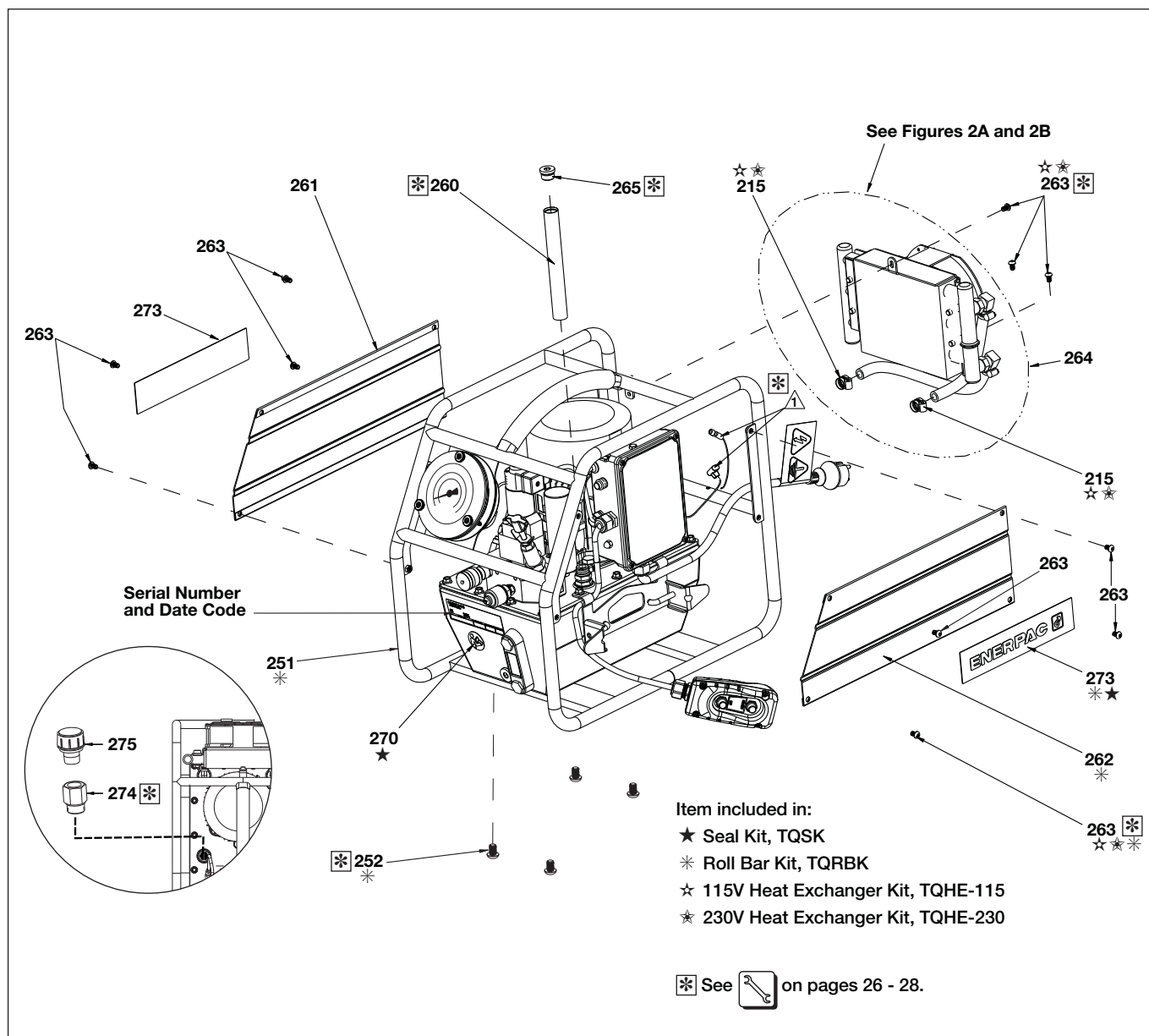


Figure 1, Pump Main Assembly

Repair Parts List (Refer to Figure 1)						L4071	
Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
215	☆☆ DC9639299	2	Hose Clamp, Steel	264	(See Figures 2A and 2B)	1	Heat Exchanger
251	* DD2630201	1	Roll Bar	265	B1006016	1	Plug, Socket SAE
252	* CBE813028-1E	4	BHCS, M8 x 8 Zinc	270	★ DC9920026	2	Decal, Read Manual
260	DD2633268	1	Tube, Oil Fill	273	*★ G426026	2	Decal, Enerpac
261	* DD2656111	1	Side Panel, Left	274	F100096-38	1	Fitting, Adapter
262	* DD2662111	1	Side Panel, Right	275	DC8250006	1	Breather Plug, 3/8 NPTF
263	☆☆* CBE615028-1E	11	BHCS, M6 x 10mm Zinc				

IMPORTANT: Shaded items are available only in kits (not sold separately).

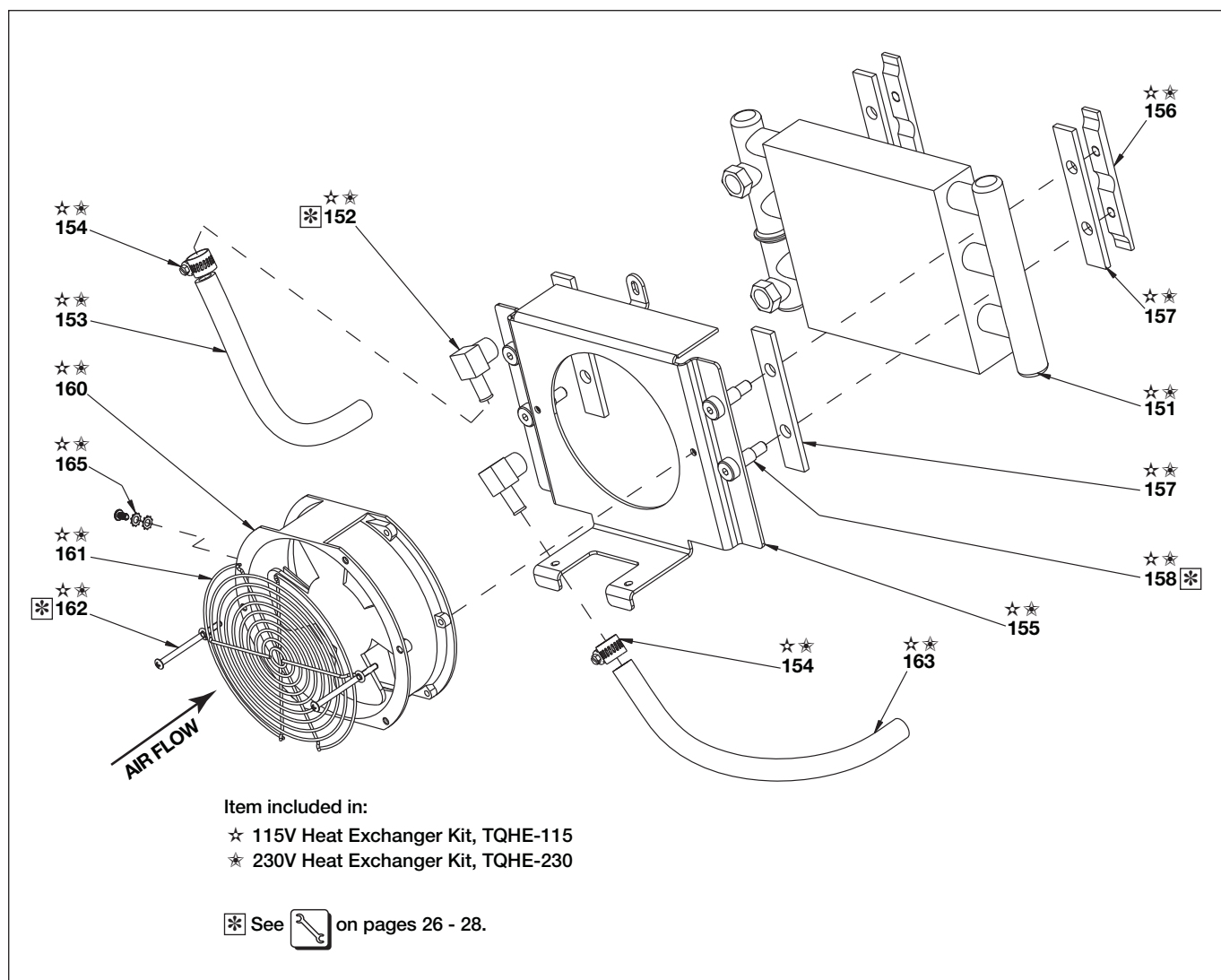


Figure 2A, Oil Cooler Assembly

Repair Parts List (Refer to Figure 2A)			L4071
Item	Part Number	Qty.	Description
151	☆☆ DC9546471	1	Heat Exchanger
152	☆☆ PA2029097	2	Hose Barb, Beaded
153	☆☆ DC9335646	1	Hose, Bypass, 8"
154	☆☆ DC9639299	2	Hose Clamp, Steel
155	☆☆ DD2632111	1	Bracket, Heat Exchanger
156	☆☆ DC9555471	2	Bracket, HX Mount
157	☆☆ DC9554037	4	Gasket, HX Mount
158	☆☆ DC9576242	4	Shoulder Bolt
160	☆ DC8276470	1	Fan, 115V
	☆ DC8277470	1	Fan, 230V
161	☆☆ DC3227689	1	Guard, Fan
162	☆☆ DC9575628	2	Bolt, 8-32 x 2"
163	☆☆ DC9643646	1	Hose, Bypass
165	☆☆ DA15066	2	Lockwasher
IMPORTANT: Shaded items are available only in kits (not sold separately).			

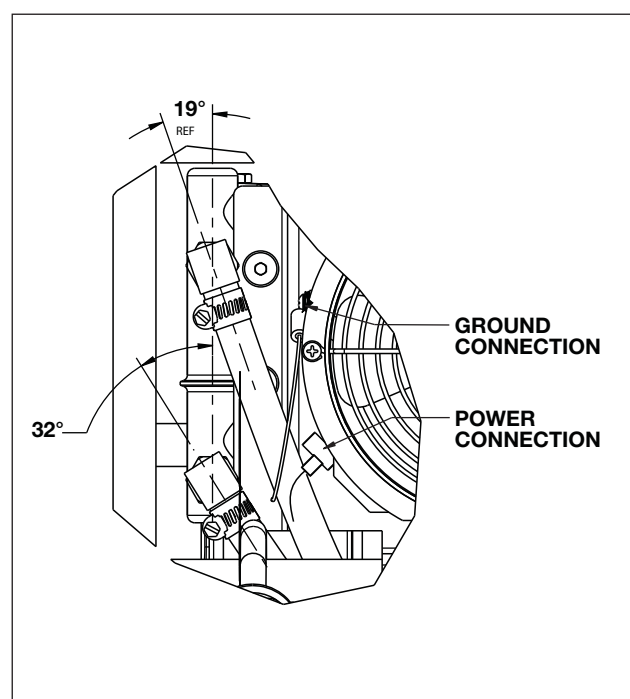


Figure 2B, Oil Cooler Wiring Details

Item included in:

✱ Pressure Gauge Repair Kit, TQPGRK

✱ See  on pages 26 - 28.

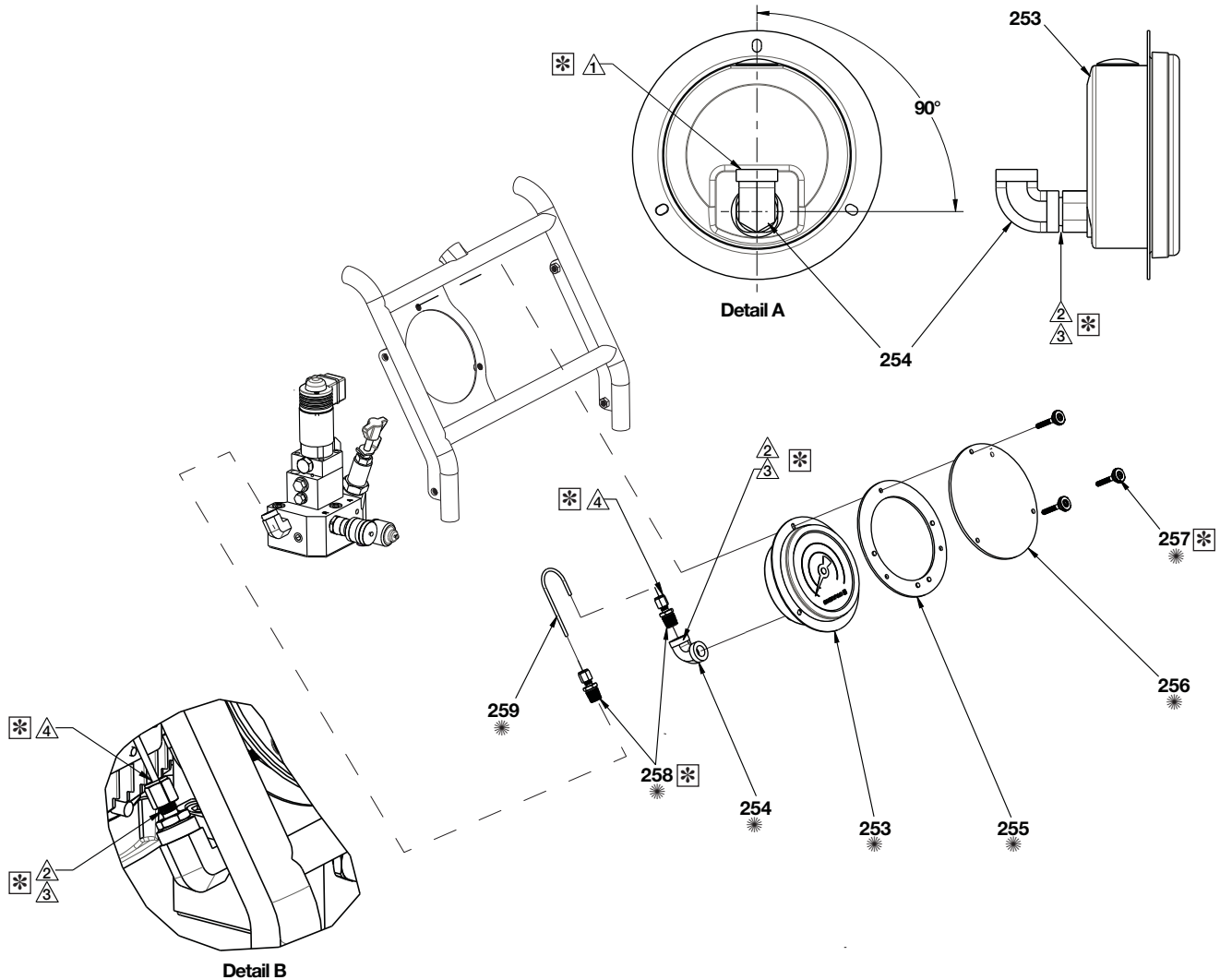


Figure 3, Pressure Gauge Assembly

Repair Parts List (Refer to Figure 3)							L4071
Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
253	✱ DC3760900	1	Pressure Gauge	257	✱ DD2659147	3	Knob, 10-32 Screw
254	✱ CK908241	1	Elbow, F-F, 1/4" NPTF	258	✱ 46293	2	Ftg, M 1/4 NPT to 1/8 Tube
255	✱ DC2926004	1	Flange	259	✱ DD3654268	1	Tube, Gauge TQ700 II
256	✱ DD2627689	1	Guard, Gauge				

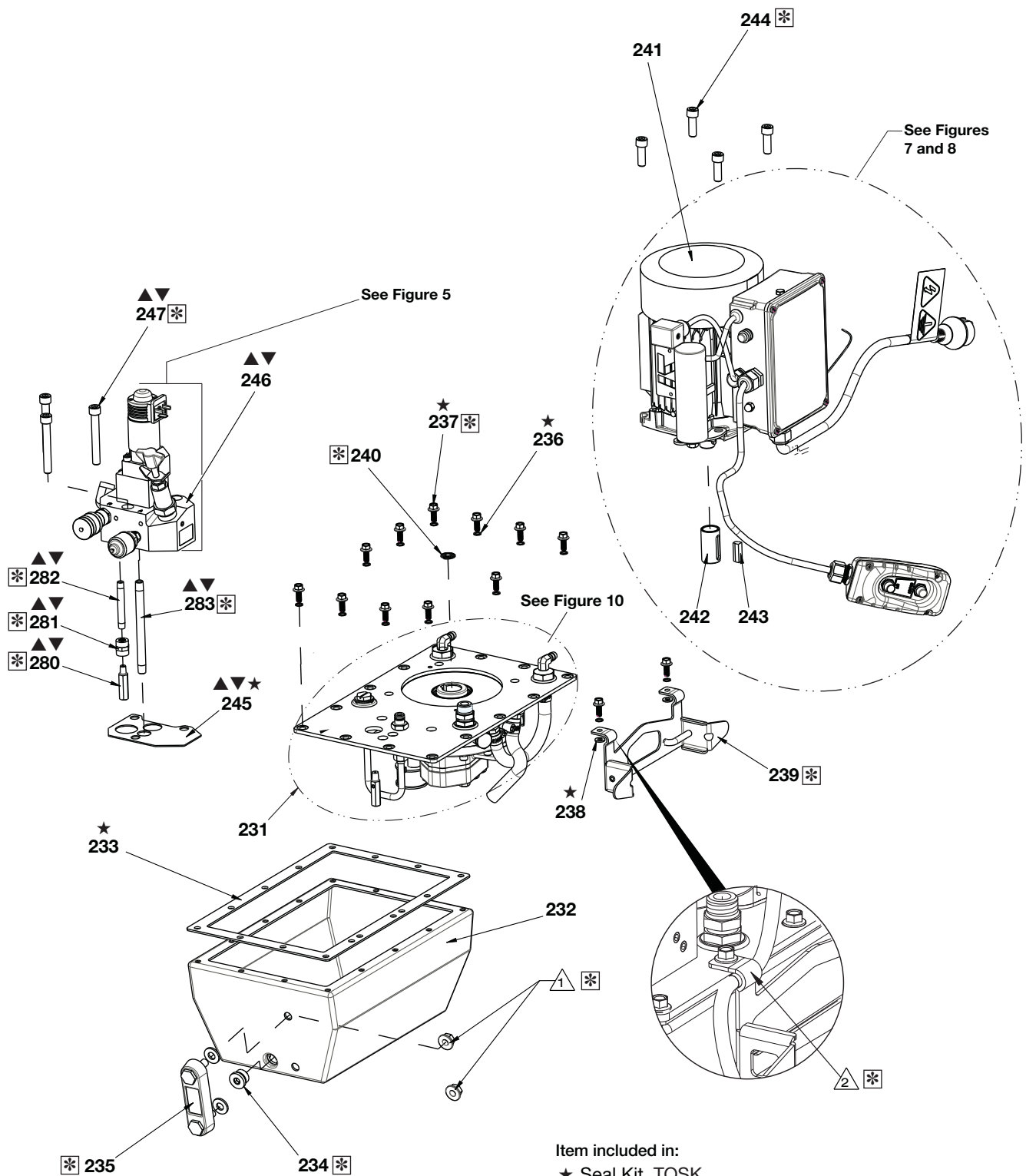


Figure 4, Pump Major Components and Subassemblies

Repair Parts List (Refer to Figure 4)			L4071
Item	Part Number	Qty.	Description
231	(See Figure 10)	1	Pump and Cover Plate
232	DD2629025SR	1	Reservoir, 1 Gallon
233	★ 85469E	1	Gasket, Reservoir
234	DC8249006	1	Plug, Threaded, Magnetic
235	DC2621223	1	Sight Glass Assembly
236	★ S3037	14	Gasket, Copper
237	★ B2007046	14	Screw, 1/4-20 x 3/4"
238	★ DD2655037	2	Gasket, Cord MG
239	DD2692111	1	Bracket, Cord MA
240	BSS5509D	1	Spring
241	(See Figures 7 and 8)	1	Motor and Pendant
242	DD3931038	1	Sleeve (modified)
243	DC8091251	1	Key
244	CBE1027028-1A	4	SHCS, M10 x 35mm
243	DC8091251	1	Key
244	CBE1027028-1A	4	SHCS, M10 x 35mm
245	▲▼★ DD4021037	1	Gasket, Valve
246	▲ DD3852900	1	Valve Assembly, 115V
	▼ DD3853900	1	Valve Assembly, 230V
247	▲▼ 99921E	3	SHCS, 3/8-16 x 2"
280	▲▼ DD4250900	1	Relief Valve, 1/8" NPTF 1750 PSI
281	▲▼ 68918	1	Pipe Coupling
282	▲▼ 68917	1	Pipe Nipple, 1/8"
283	▲▼ F100431-5	1	Tube, Return-to-Tank
IMPORTANT: Shaded items are available only in kits (not sold separately)			

- Item included in:
- ▲ Replacement Valve Assembly, TQVRK-115
 - ▼ Replacement Valve Assembly, TQVRK-230
 - + Valve Manifold Repair Kit, DD3846190SR
 - ▷ Valve Manifold Parts Kit, TQVSLK

* See  on pages 26 - 28.

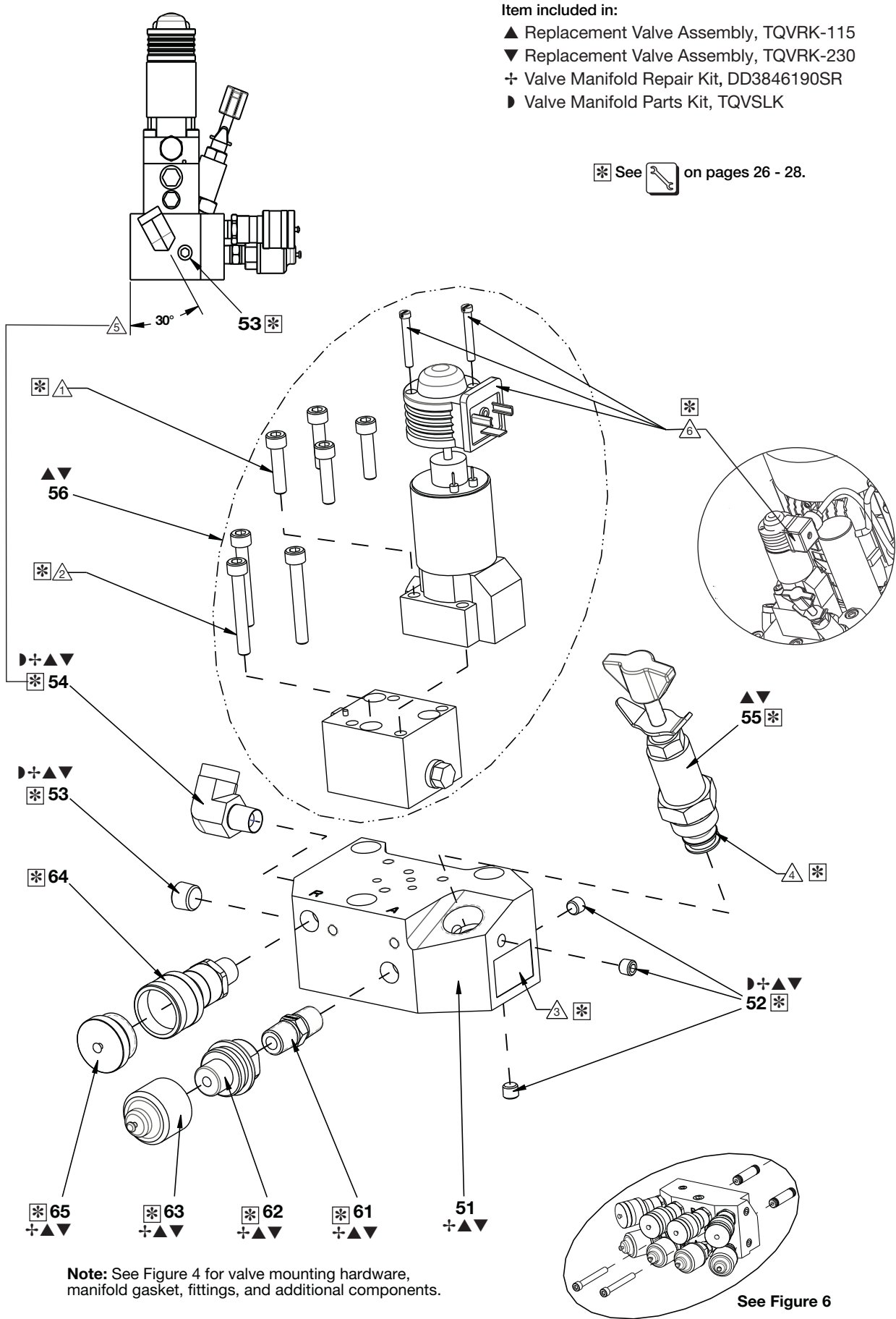


Figure 5, Control Valve Assembly

Repair Parts List (Refer to Figure 5)			L4071
Item	Part Number	Qty.	Description
51	⬢▲▼ DD3846190	1	Manifold, Valve
52	⬢ ⬢▲▼ DC6792245	3	Plug, Flush PTF-SAE 1/16"
53	⬢ ⬢▲▼ DC6794245	1	Plug, Flush PTF-SAE 1/4"
54	⬢ ⬢▲▼ F100095-7	1	Street Elbow, 0.25"
55	▲▼ 45423SR	1	Cartridge, Relief
56	▲ 45424E	1	Assy, Solenoid Valve 115V
	▼ 45429E	1	Assy, Solenoid Valve 230V
61	⬢▲▼ FZ1608	1	Nipple, 1/4"
62	⬢▲▼ TH630	1	Coupler
63	⬢▲▼ DC6187234	1	Dust Cap, Metal
64	⬢▲▼ TR630	1	Coupler, Female
65	⬢▲▼ DC6629020	1	Dust Cap, Metal
IMPORTANT: Shaded items are available only in kits (not sold separately)			

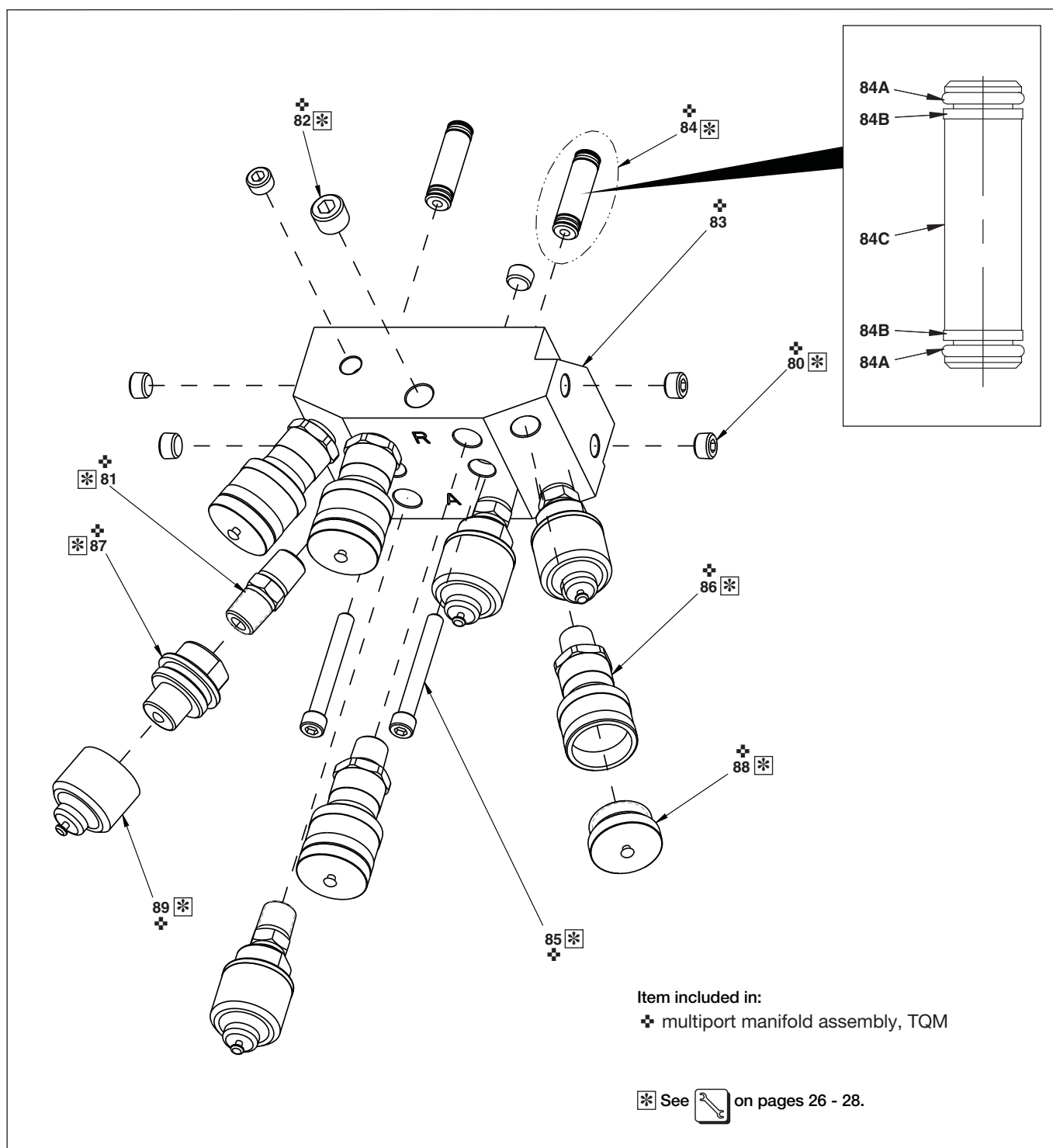


Figure 6, TQM Multi Port Manifold Assembly (optional)

Repair Parts List (Refer to Figure 6)							L4071
Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
80	✦ A1016245	5	Plug, 1/4" Flush	84B	✦ 45641	2	Ring, Backup
81	✦ FZ1608	4	Nipple, 1/4"	84C	✦ 45621	2	Adapter
82	✦ DC6793245	1	Plug, Flush, PTF-SAE	85	✦ 81907E	2	SHCS, 1/4-20 x 2"
83	✦ 45620E	1	Multiport Adapter	86	✦ TR630	4	Coupler, Female
84	✦ 45622E	2	Valve Adapter (includes items 84A, 84B & 84C)	87	✦ TH630	4	Coupler
84A	✦ 45640	2	O-Ring	88	✦ DC6187234	4	Cap, Dust, Metal
				89	✦ DC6629020	4	Dust Cap, Metal

IMPORTANT: Shaded items are available only in kits (not sold separately)

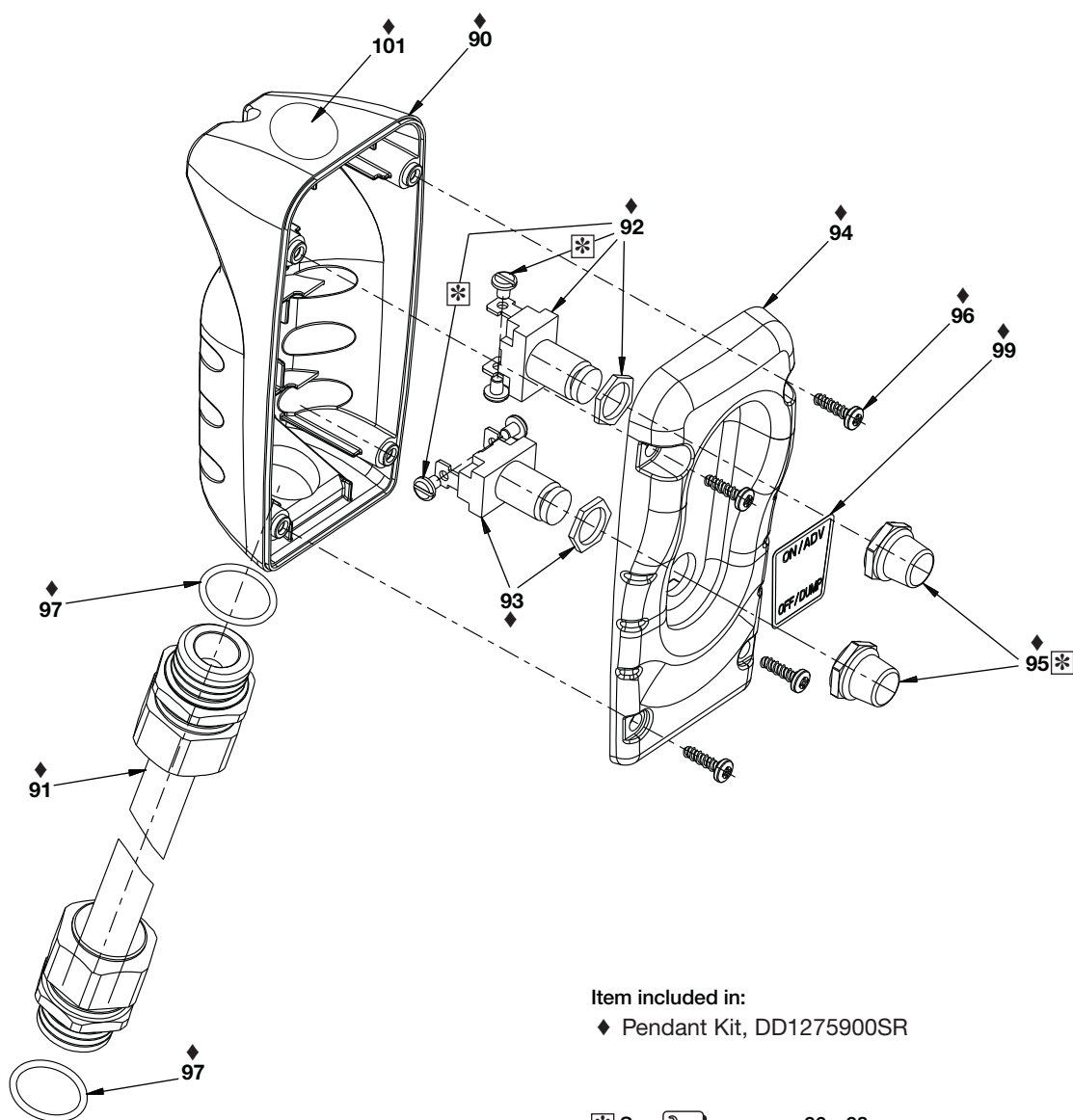


Figure 7, Pendant and Cable Assembly, 2-Button

Repair Parts List (Refer to Figure 7)							L4071
Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
90	♦ DC9425424	1	Enclosure, Lower	95	♦ DC8284379	2	Switch Cover
91	♦ DD1276960	1	Pendant Wire, BTW	96	♦ DC9428008	4	Screw, Hi-Low #8 x 1/2
92	♦ DC8282379	1	Pendant Button, NO	97	♦ B1223503	2	O-Ring
93	♦ DC8283379	1	Pendant Button, NC	99	♦ DC8127026	1	Decal, Pendant
94	♦ DC8122424	1	Enclosure, Upper	101	♦ DD1394026	1	Decal, Pressure Relief
IMPORTANT: Shaded items are available only in kits (not sold separately)							

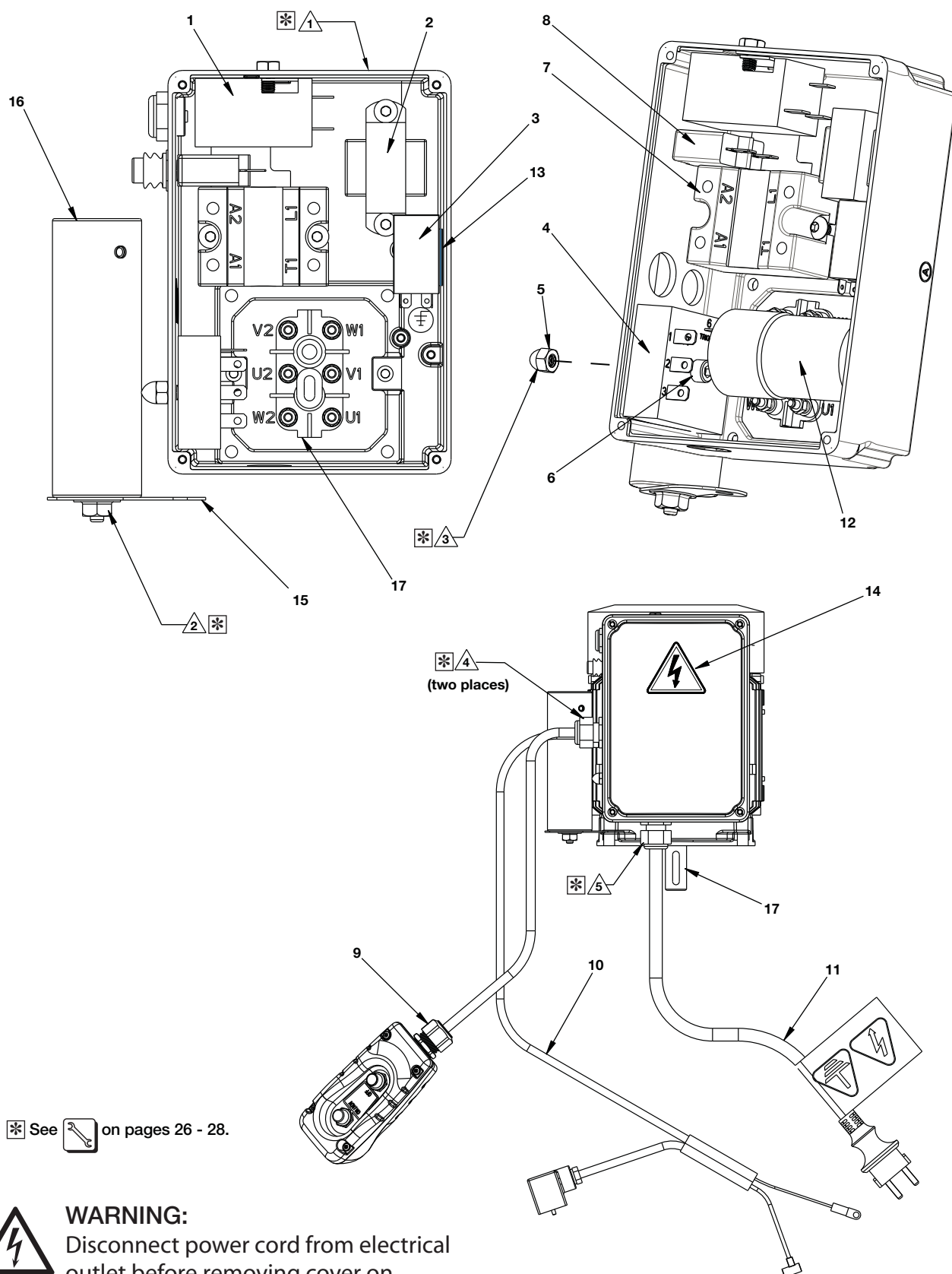


Figure 8, Electrical Box and Motor Assembly

Repair Parts List (Refer to Figure 8)			L4071
Item	Part Number	Qty.	Description
1	DD2677380	1	Relay, Current Operated, 115V (TQ-700B)
	DD2678380	1	Relay, Current Operated, 230V (TQ-700E and TQ-700I)
2	DD2624480	1	Transformer
3	DD2691380	1	Relay
4	DC8281784	1	Timer, SSAC, 15 Seconds
5	CAE1050055-1A	1	Acorn Nut, M5
6	CA525028-1A	1	SHCS, M5 x 30, Zinc
7	DD2211980	1	SSR, AC Fired, 24VAC
8	DD2845380	1	Circuit Breaker, 20A (TQ-700B)
	DD2721380	1	Circuit Breaker, 8A (TQ-700E and TQ-700I)
9	(See Fig. 7)	1	Pendant and Cable Assy.
10	DD2623960	1	Wire Harness, Solenoid and Fan
11	DD2619960	1	Power Cord, 115V 50Hz (TQ-700B)
	DD2621960	1	Power Cord, 230V 50Hz (TQ-700E)
	DD2620960	1	Power Cord, 230V 60Hz (TQ-700I)
12	DD2675380	2	Capacitor, starting, 115V (TQ-700B)
	DD2676380	1	Capacitor, starting, 230V (TQ-700E and TQ-700I)
13	DD4251380	1	Hook and Loop
14	DC9922026	1	Decal, High Voltage
15	DD3927111	1	Bracket, Capacitor Mount
16	DD2673380	1	Running Capacitor, 115V (TQ-700B)
	DD2674380	1	Running Capacitor, 230V (TQ-700E and TQ-700I)
17	DD3843259	1	Motor, 1 HP, 1 PH, 115V 60 Hz (TQ-700B)
	DD3844259	1	Motor, 1 HP, 1 PH, 230V 50/60 Hz (TQ-700E and TQ-700I)

115 Volts or 230 Volts 60 or 50 Hz., AC
Line Voltage In

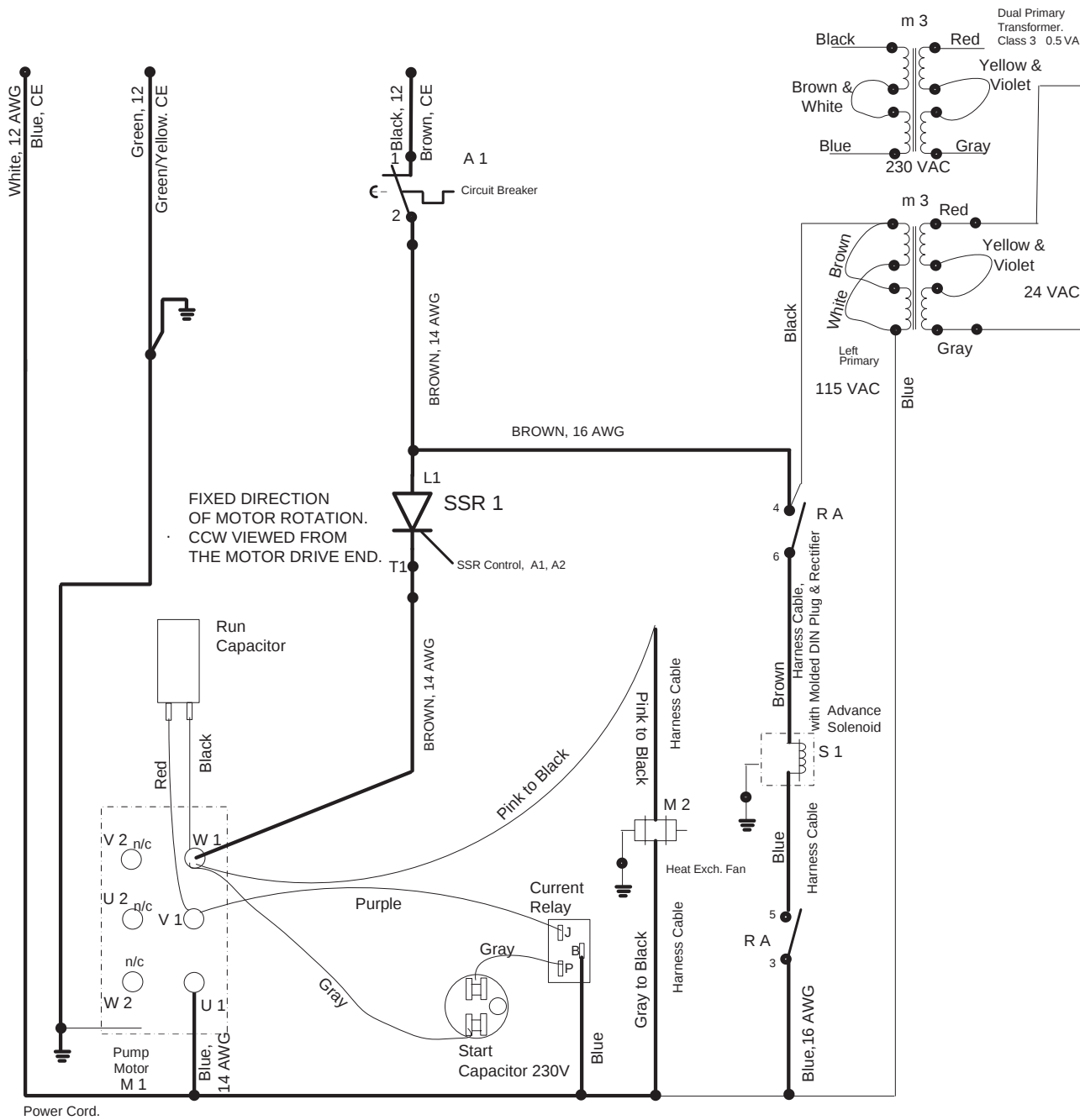
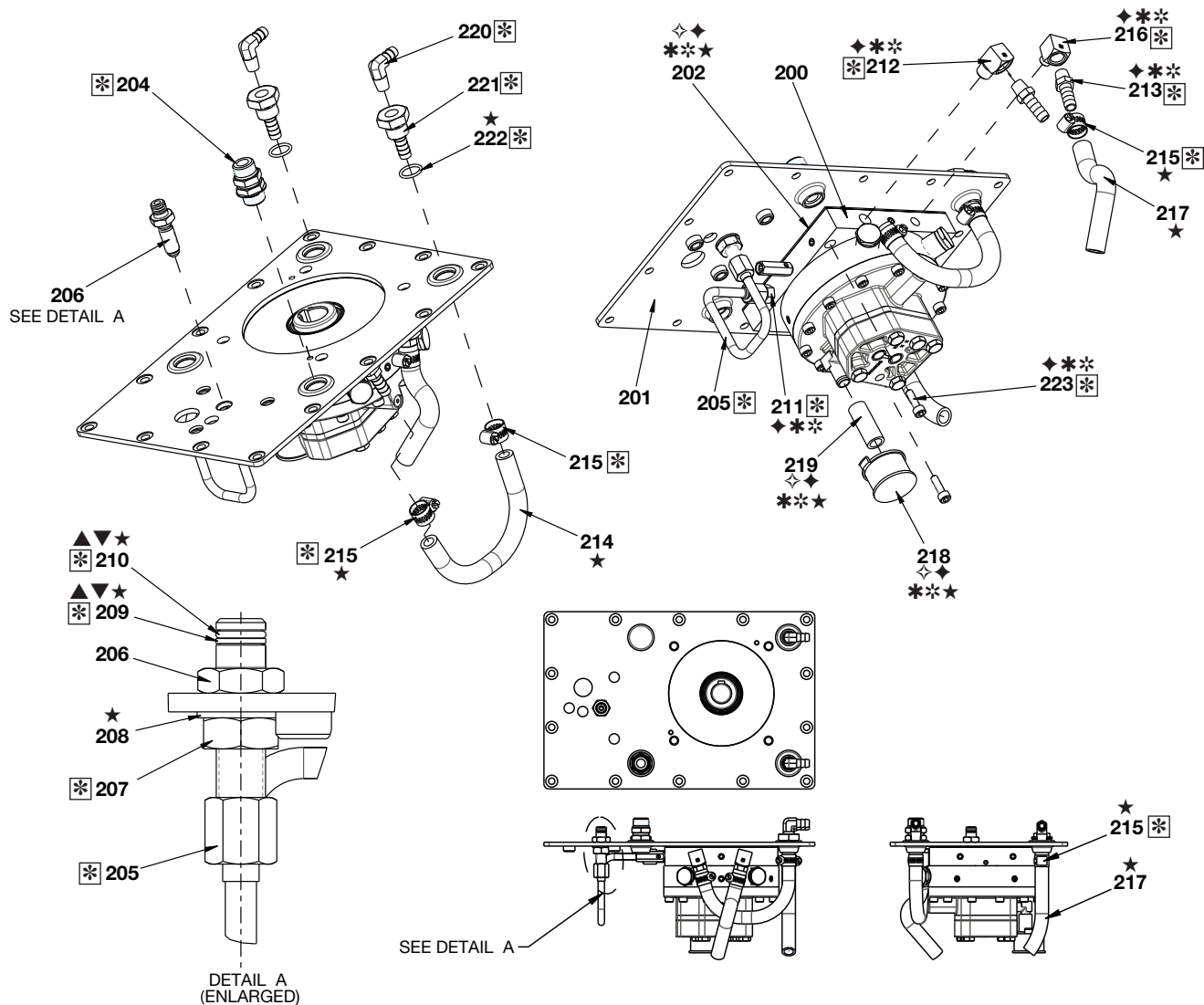


Figure 9, Electrical Diagram, TQ-700 Classic Bolting Pump, Units with Date Code Beginning with "B" (View 1 of 2)





Item included in:

- ★ Seal Kit, TQSK
- * 3-Stage MPE Replacement Kit, DD3850900SR (For TQ-700B/I only)
- * 3-Stage MPE Replacement Kit, DD3851900SR (For TQ-700E only)
- ▲ Replacement Valve Assembly, TQVRK-115
- ▼ Replacement Valve Assembly, TQVRK-230
- ◆ 3-Stage MPE Repair Kit, Z3STGRPK
- ◇ 3-Stage MPE Seal Kit, Z3STGSLK

* See  on pages 26 - 28.

Figure 10, Cover Plate and Pump Element Assembly

Repair Parts List (Refer to Figure 10)				L4071
Item	Part Number	Qty.	Description	
200	DD3850900SR	1	Pump Assy (models TQ-700B and TQ-700I)	
	DD3851900SR	1	Pump Assy (model TQ-700E)	
201	DD4252101	1	Plate, Gear	
202	◆◆***★ DC9548037	1	Gasket, Pump Element	
204	F100096-19	1	Union, SAE #8	
205	DD3499268	1	Assembly, Pressure Tube	
206	DD3845690	1	Fitting, Connector	
207	B1010124	1	Nut	
208	★ DD3849108	1	Washer, Connector Fitting	
209	▲▼★ B1012566	1	Washer, Teflon	
210	▲▼★ B1012803	1	O-Ring, 0.38 x 0.50"	
211	◆*** F100094-246	1	Fitting, Elbow, Outlet Port	
212	◆*** F100097-81	1	Fitting, 1st Stage Bypass	
213	◆*** F100097-16	2	Fitting, Hose, Barbed	
214	★ DC9643646	1	Hose, 13" Long	
215	★ DC9639299	4	Hose Clamp, Steel	
216	◆*** F100097-79	1	Fitting, 2nd Stage Bypass	
217	★ DC9418646	2	Hose, Bypass, 5"	
218	◆◆***★ DC9718118	1	Filter, Intake	
219	◆◆***★ DC9600268	1	Tube, Intake, 1.6"	
220	DC3938096	2	Elbow	
221	DC9273097	2	Fitting Bypass	
222	★ B1908503	2	O-Ring	
223	◆*** CBE621028-1A	2	SHCS, M6 x 20mm, 8.8 Zn	
IMPORTANT: Shaded items are available only in kits (not sold separately).				

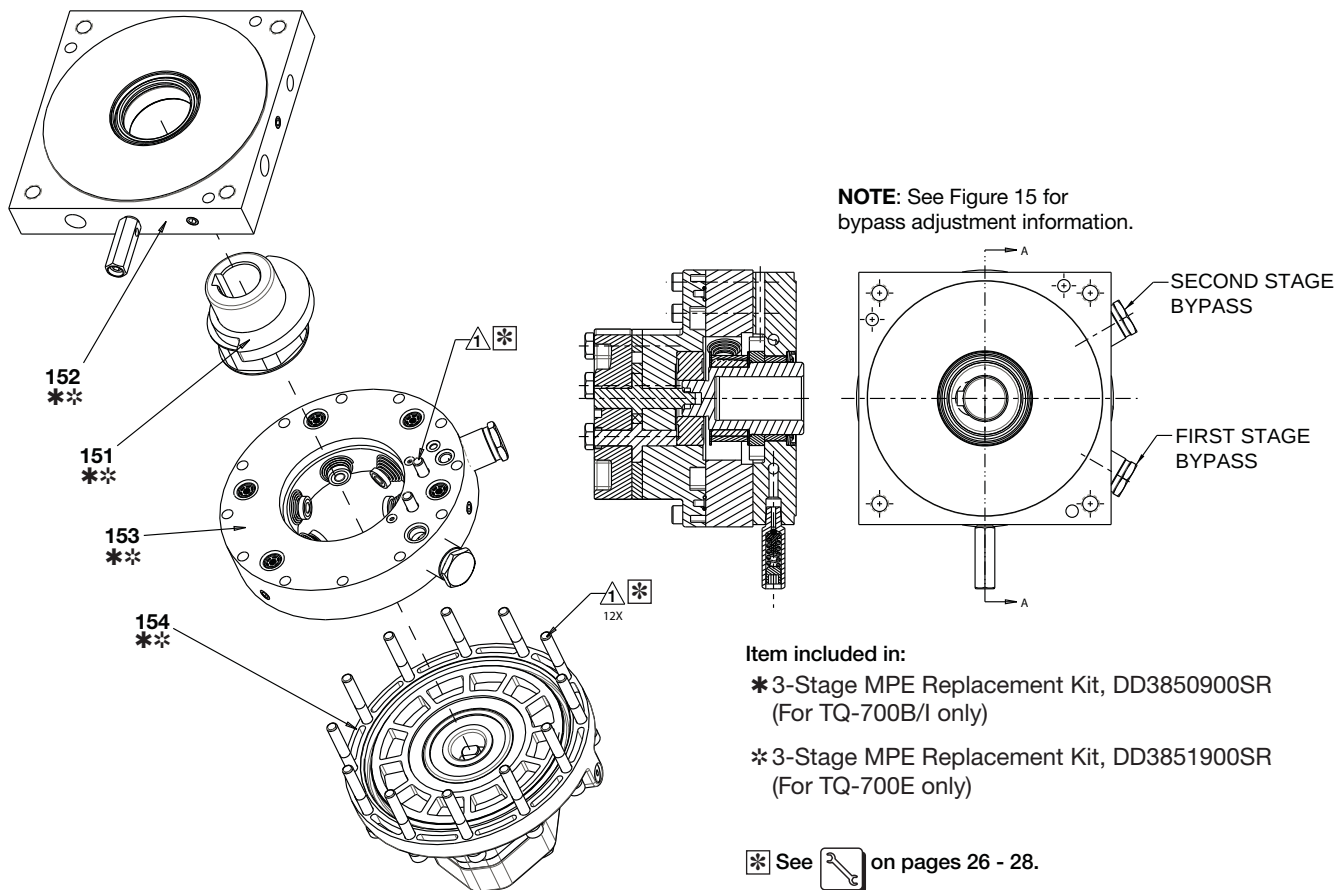


Figure 11, Pump Element Assembly

Repair Parts List (Refer to Figure 11)				L4071
Item	Part Number	Qty.	Description	
151	** DD3826900SR	1	Eccentric Assy, 3-Stage MPE (See Fig. 12)	
152	** DD3824900SR	1	Assembly, Top Plate (See Fig. 13)	
153	** DD3822900SR	1	Assembly, Piston Ring (See Figs. 14 and 15)	
154	** DC9296920SR	1	Gear Pump and O-Rings (See Fig. 18)	

Item included in:

* Eccentric Replacement Kit, DD3826900SR

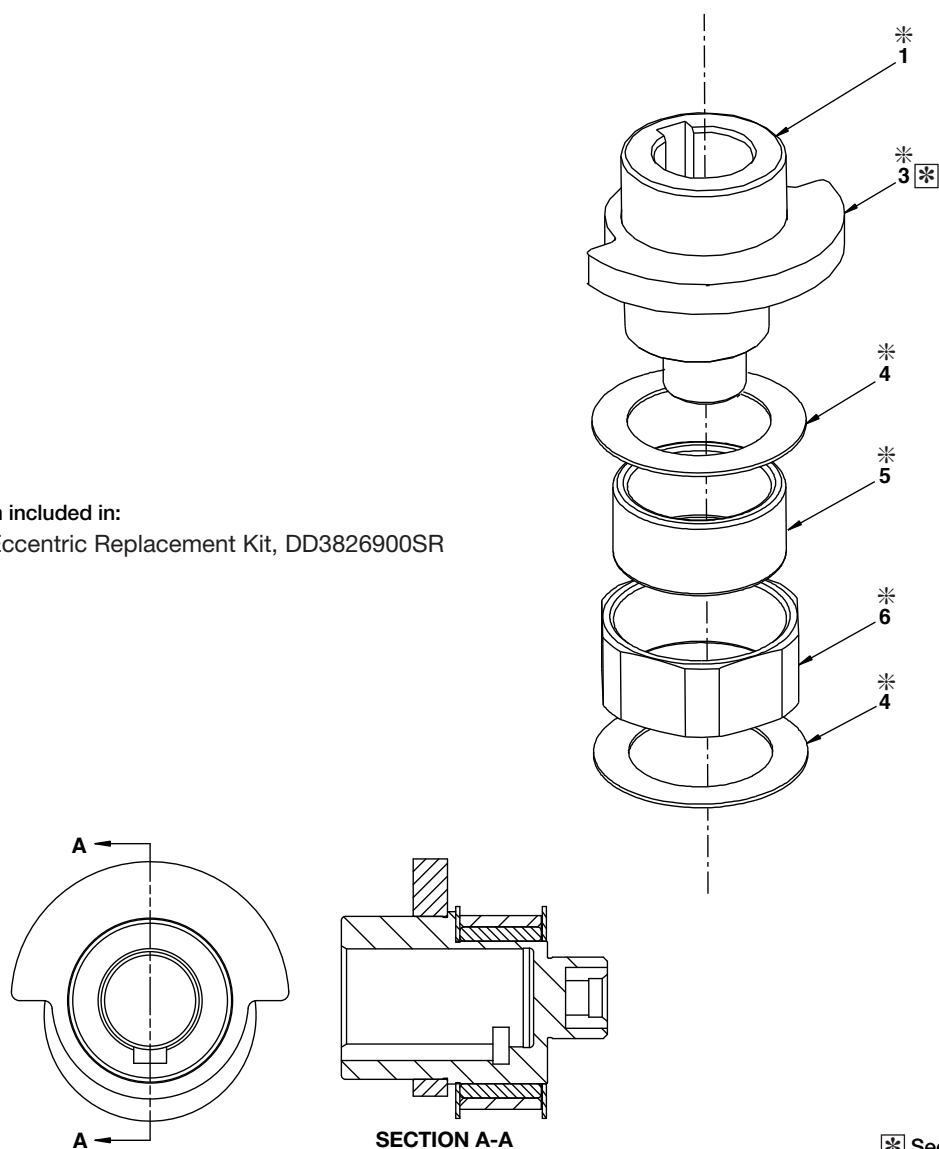


Figure 12, Eccentric Assembly

Repair Parts List (Refer to Figure 12)				L4071
Item	Part Number	Qty.	Description	
1	* DD3653537	1	Eccentric, Induction	
3	* DC9023101	1	Plate, Balance	
4	* BSS4725D	2	Ring	
5	* DC4107155	1	Bearing, Needle	
6	* DC4328350	1	Hex Cam	
IMPORTANT: Shaded items are available only in kits (not sold separately)				

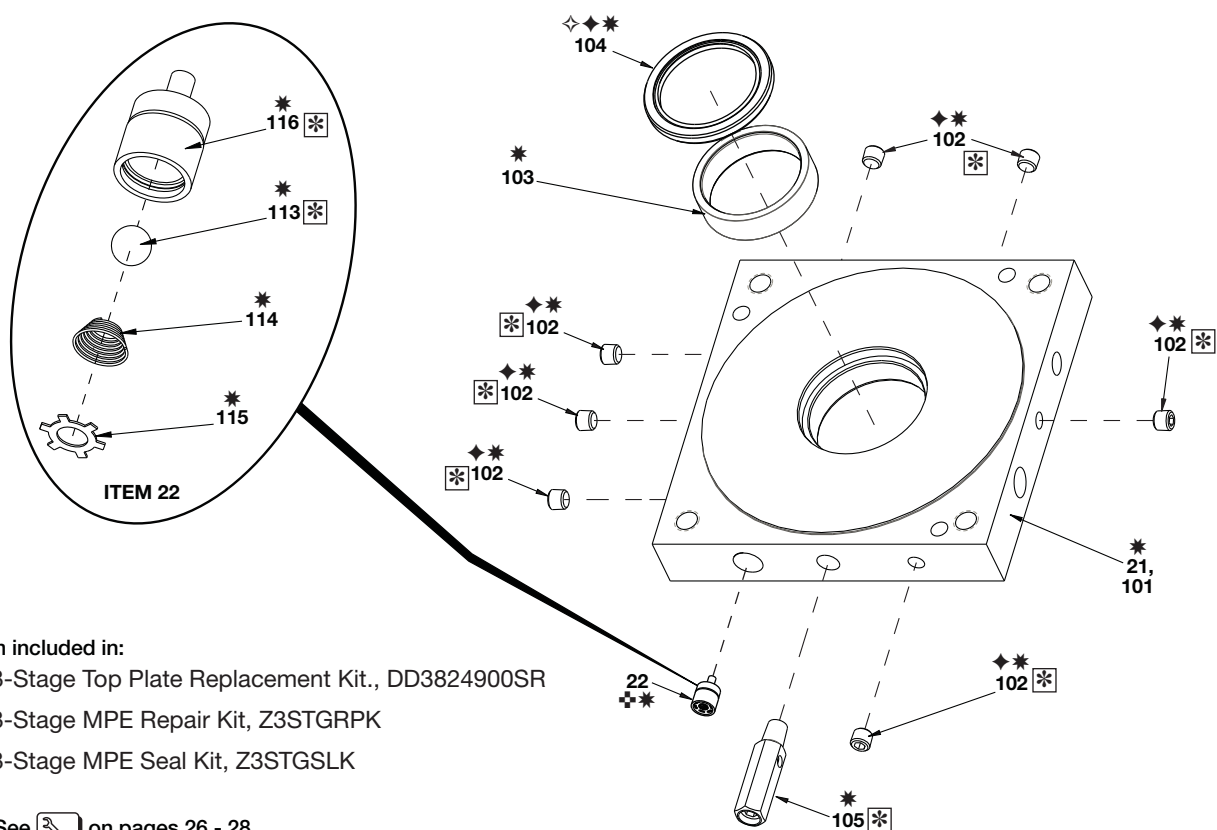


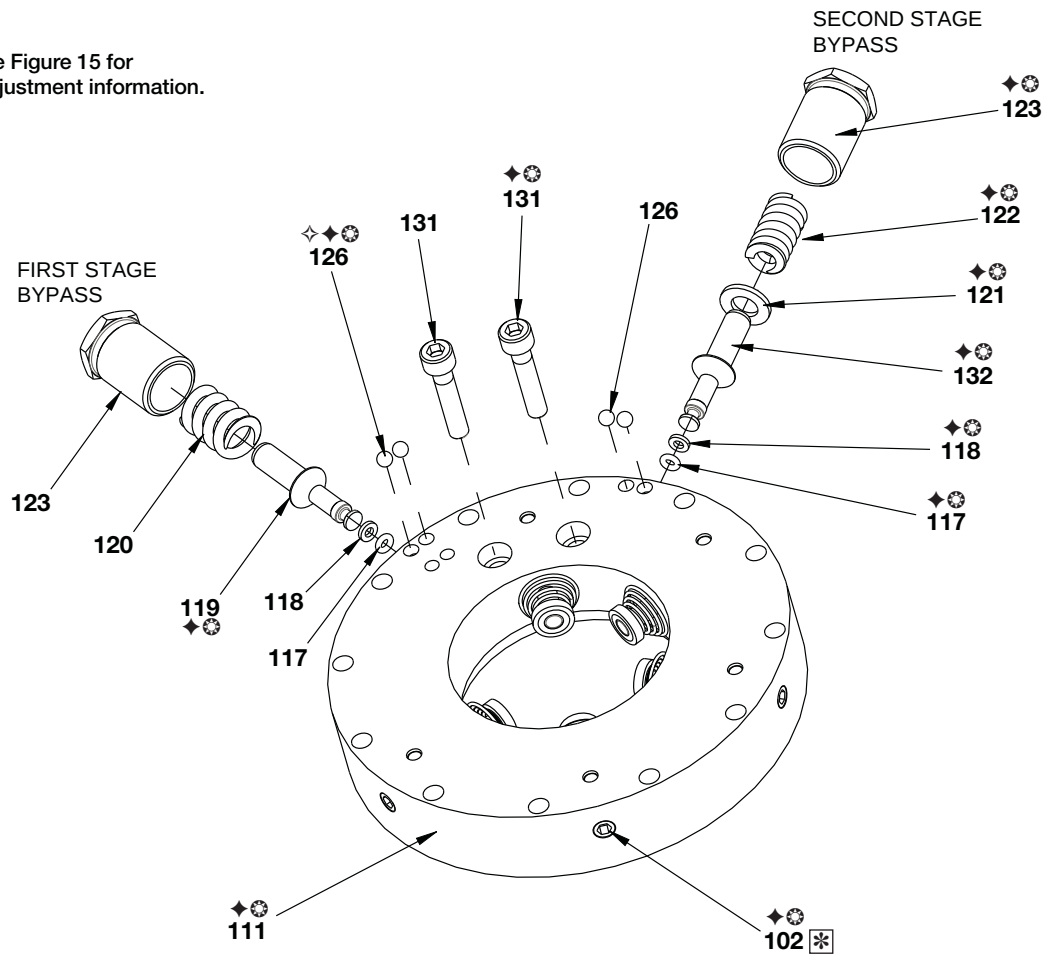
Figure 13, Top Plate Assembly

Repair Parts List (Refer to Figure 13)				L4071
Item	Part Number	Qty.	Description	
21	* DD2802101	1	Top Plate, 3 Stage MPE	
22	◆* DD3825900	1	Subassembly, Check Valve (includes items 113, 114, 115 and 116)	
101	* DD3833900	1	Top Plate with Check Valve assembly (includes items 22 and 101)	
102	◆* A1006245	7	Flush Plug, 1/16"	
103	* DC9026155	1	Bearing, Needle	
104	◇◆* DC9027776	1	Seal, Oil Lip	
105	* DA5999900SR	1	Relief Valve, 1/8" NPT	
113	* B1005016	1	Check Ball, 3/16" Diameter	
114	* BSS5809D	1	Spring, Piston Check Ball	
115	* BSS5356D	1	Ring, Retaining	
116	* BSS5357D	1	Piston Seat, Upper	
IMPORTANT: Shaded items are available only in kits (not sold separately).				

NOTES:

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins or other markings on the paper.

NOTE: See Figure 15 for bypass adjustment information.



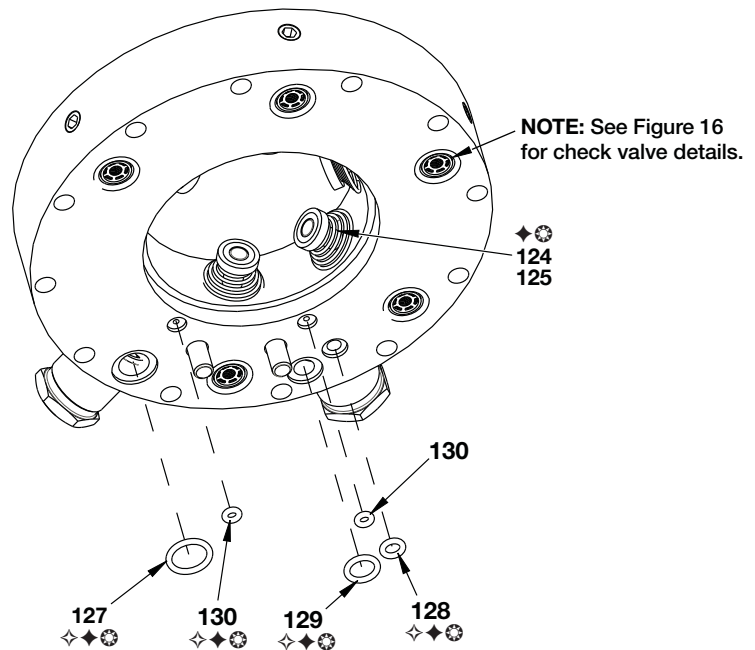
NOTE: Pumps built before week 38 of 2015:

- When making repairs or performing an overhaul, the original second stage bypass spring and piston should be replaced with new redesigned parts, items 122 and 132.
- Both parts must be replaced together, as a set. Do not just replace one part.
- Parts used for the first stage bypass assembly remain unchanged.

Item included in:

- Piston Ring Replacement Kit, DD3822900SR
- 3-Stage MPE Repair Kit, Z3STGRPK
- 3-Stage MPE Seal Kit, Z3STGSLK

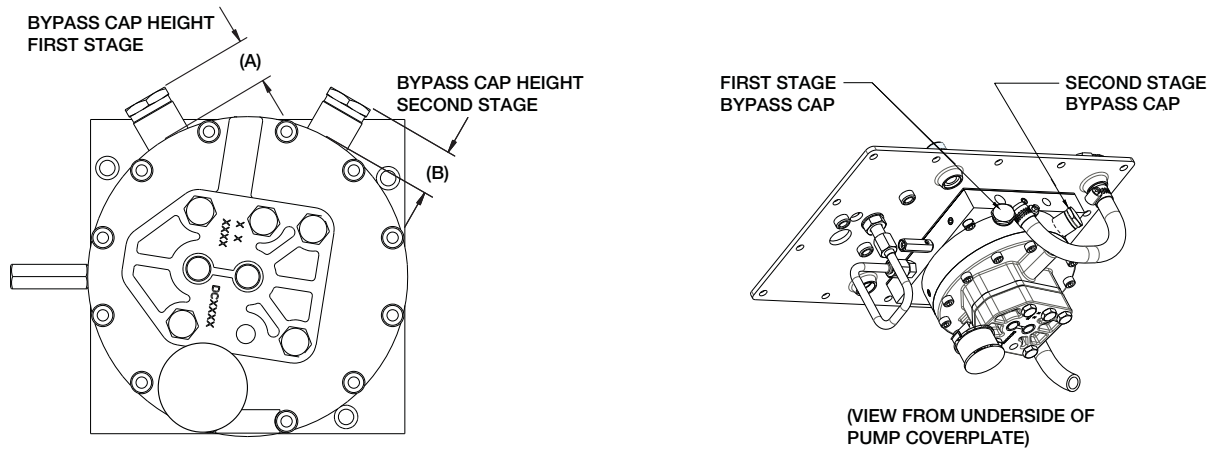
* See  on pages 26 - 28.



NOTE: See Figure 16 for check valve details.

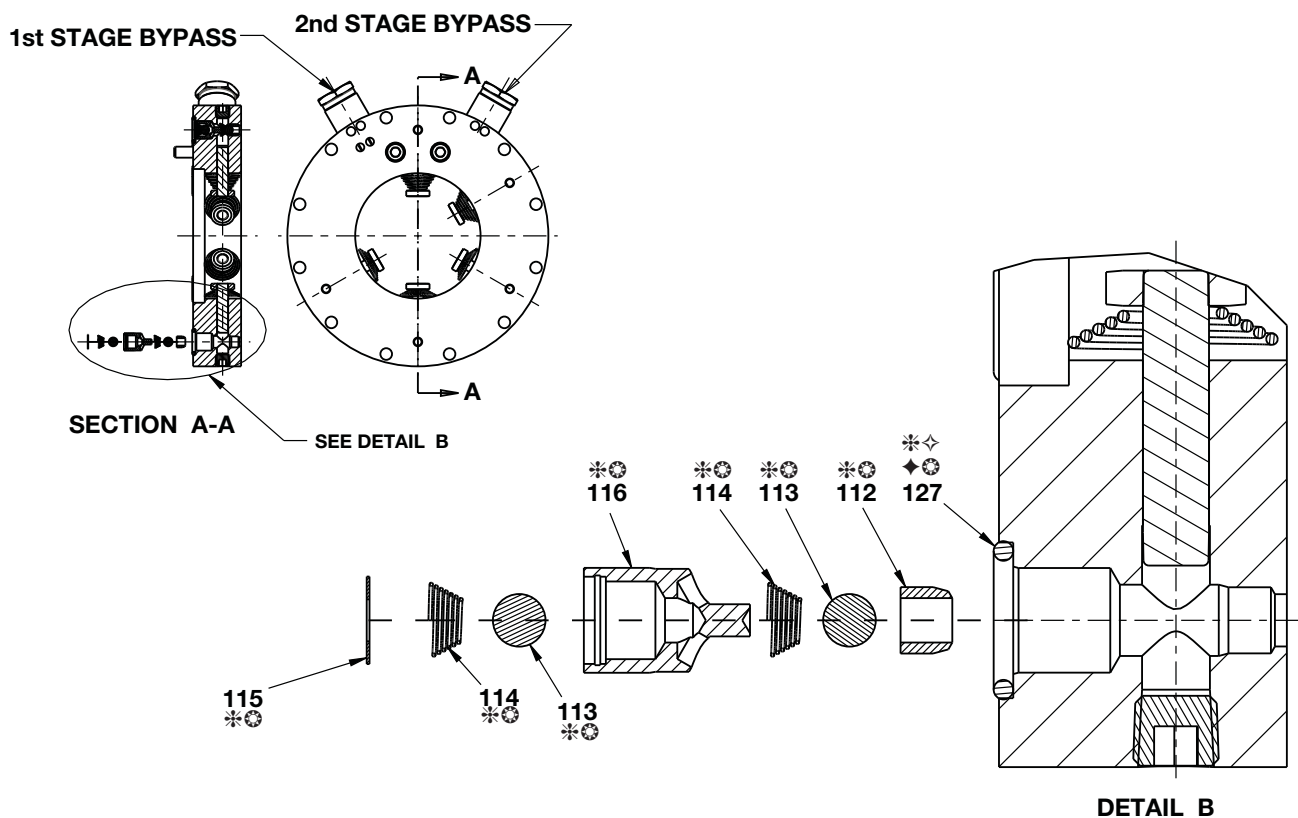
Figure 14, Piston Ring Assembly, 3 Stage

Repair Parts List (Refer to Figure 14)				L4071
Item	Part Number	Qty.	Description	
102	◆ ● A1006245	5	Flush Plug, 1/16"	
111	◆ ● DD2803101	1	Piston Ring, 5-Piston, 3-Stage	
117	◆ ● B1006803	2	O-Ring	
118	◆ ● B1006564	2	Washer, Back-Up	
119	◆ ● DC9292051	1	Piston, 1st Stage Bypass	
120	◆ ● DC394110	1	Spring, 1st Stage Bypass	
121	◆ ● DD4954108	1	Washer, 2nd Stage Bypass, TQ-700 II	
122	◆ ● DD5926110	1	Spring, 2nd Stage Bypass	
123	◆ ● DC9208020	2	End Cap, Bypass	
124	◆ ● BSS5509D	5	Spring	
125	◆ ● DC9244920	5	Piston Assembly, MPE	
126	◇ ◆ ● DC9293016	4	Ball, Nylon 3-1/16"	
127	◇ ◆ ● B1013803	1	O-Ring, Disogrin, -013	
128	◇ ◆ ● B1008803	1	O-Ring, Disogrin, -008	
129	◇ ◆ ● B1011803	1	O-Ring, Disogrin, -011	
130	◇ ◆ ● B1005403	2	O-Ring, Disogrin, -005	
131	◆ ● CCA625028-1A	2	SHCS M6 x 1.0 x 30	
132	◆ ● DD5925051	1	Piston, 2nd Stage Bypass	
IMPORTANT: Shaded items are available only in kits (not sold separately)				



Pump Model Number	Element Model No. (Fig. 10, item 200)	First Stage Bypass Pressure	First Stage Bypass Cap Height (A)	Second Stage Bypass Pressure	Second Stage Bypass Cap Height (B)
TQ-700B	DD3850900SR	1100 - 1150 psi [76 - 79 bar]	0.95 inch [24,1 mm]	3600-3700 psi [249 - 255 bar]	0.98 inch [24,9 mm]
TQ-700I	DD3850900SR	1100-1150 psi [76 - 79 bar]	0.95 inch [24,1 mm]	3600-3700 psi [249 - 255 bar]	0.98 inch [24,9 mm]
TQ-700E	DD3851900SR	1100-1150 psi [76 - 79 bar]	0.95 inch [24,1 mm]	4200-4300 psi [290 - 296 bar]	0.88 inch [22,3 mm]

Figure 15, Bypass Pressure Adjustment



- Item included in:
- ⊗ Piston Ring Replacement Kit., DD3822900SR
 - * Piston Check Kit, ZRKS
 - ◆ 3-Stage MPE Repair Kit, Z3STGRPK
 - ◇ 3-Stage MPE Seal Kit, Z3STGSLK

Figure 16, Check Ball Assemblies

Repair Parts List (Refer to Figure 16)				L4071
Item	Part Number	Qty.	Description	
112	*⊗ BSS5358D	5	Piston Seat, Lower	
113	*⊗ B1005016	10	Ball, 3/16" Diameter	
114	*⊗ BSS5809D	10	Spring, Piston Check	
115	*⊗ BSS5356D	5	Retaining Ring	
116	*⊗ BSS5357D	5	Piston Seat, Upper	
127	*◇◆⊗ B1013803	5	O-Ring, Disogrin, -013	
IMPORTANT: Shaded items are available only in kits (not sold separately)				

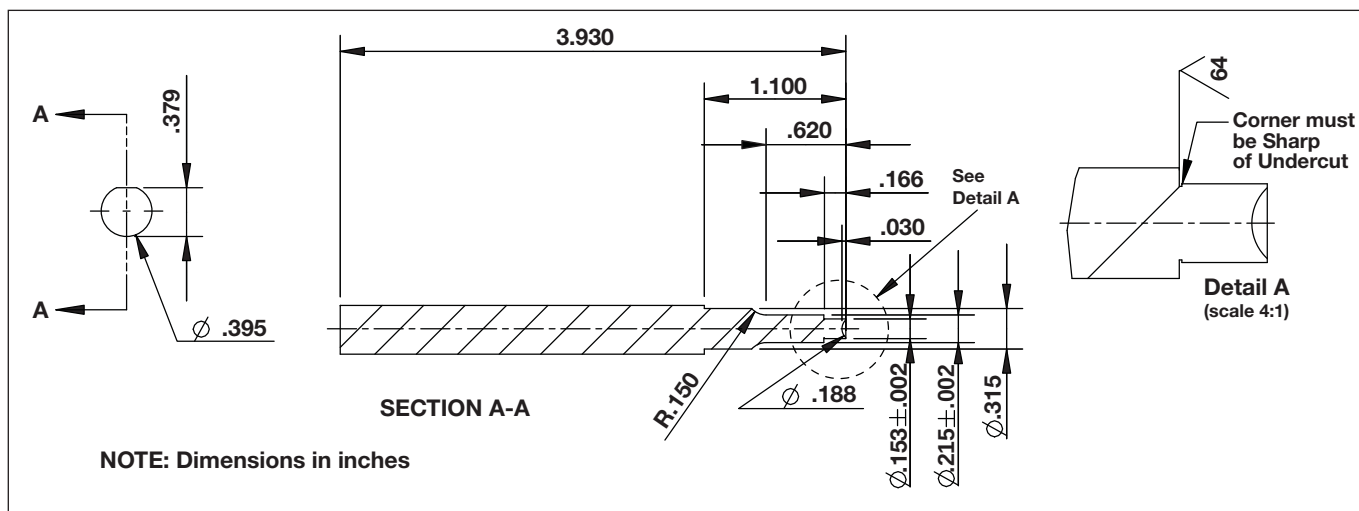


Figure 17, Seat Tool Drawing

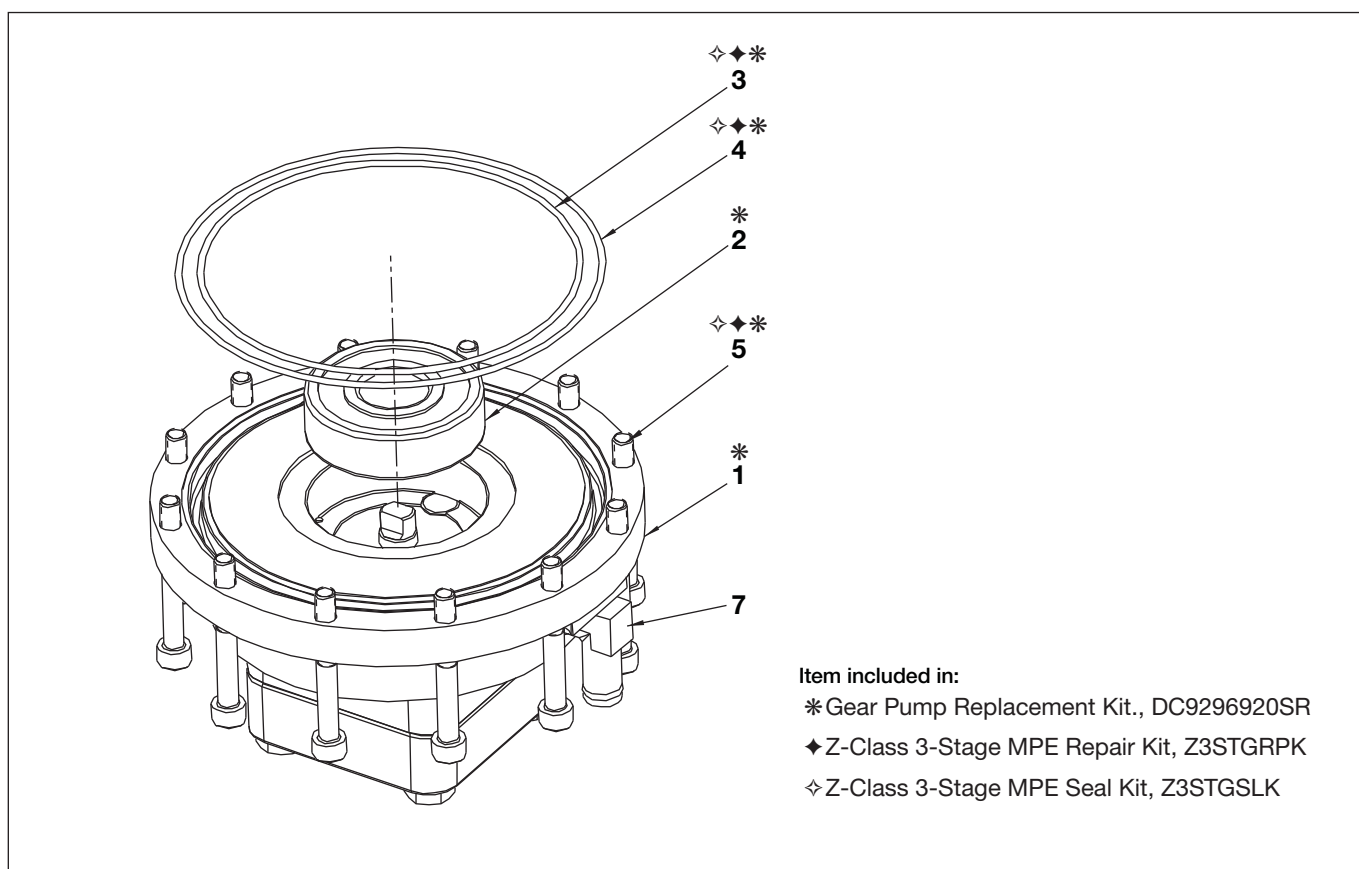


Figure 18, Gear Pump and O-Rings

Repair Parts List (Refer to Figure 18)				L4071
Item	Part Number	Qty.	Description	
1	* DC9296920	1	Gear Pump	
2	* DC9219155	1	Bearing, Ball	
3	♦♦♦ B1400503	1	O-Ring	
4	♦♦♦ B1402503	1	O-Ring	
5	♦♦♦ CCA633028-1A	12	SHCS M6 x 1.0 x 50	
7	DC9642097	1	Intake Elbow	
IMPORTANT: Shaded items are available only in kits (not sold separately)				



✱ Service Information		L4071
Fig.	Item	Torque / notes
1	252	Apply Loctite 243 to threads before installation.
1	252	13,5 - 15,8 Nm [120 - 140 Ft-Lbs]
1	263	Apply Loctite 243 to threads before installation.
1	263	6,8 - 8,1 Nm [60 - 72 In-Lbs]
1	260	Apply Loctite 243 to threads at bottom of tube before installation.
1	260	6,8 - 8,1 Nm [60 - 72 In-Lbs]
1	265	6,8 - 8,1 Nm [60 - 72 In-Lbs]
1	274	0,5 - 0,8 Nm [5 - 7 In-Lbs]
1	Note <u>1</u>	Connect heat exchanger fan power and ground cables.
2A	152	Apply Loctite 592 to threads before installation.
2A	158	6,8 - 8,1 Nm [60 - 72 In-Lbs]
2A	162	Apply Loctite 243 to threads before installation.
3	Note <u>1</u>	Orient as shown.
3	Note <u>2</u>	For pipe thread (NPTF) connection, torque to 43,4 Nm [32 Ft-Lbs] minimum.
3	257	Tighten finger-tight.
3	Note <u>3</u>	Apply Teflon tape to threads before assembly.
3	Note <u>4</u>	Tighten nut finger tight. Then, tighten nut an additional 1/4 turn.
4	234	5,6 - 6,7 Nm [50 - 60 In-Lbs]
4	237	Apply Loctite 243 to threads before installation.
4	237	5,6 - 6,7 Nm [50 - 60 In-Lbs]
4	239 Note <u>2</u>	Loop pendant cable through the left side ear of pendant bracket (item 239) before installing screw (item 237) and gasket (item 236) in this location.
4	240	Install with cone shape pointing upwards.
4	244	Apply Loctite 545 to threads before installation.
4	244	2,3 - 2,8 Nm [20 - 25 In-Lbs]
4	247	Apply Loctite 545 to threads before installation.
4	247	27 - 34 Nm [20 - 25 Ft-Lbs]
4	280	21,6 - 27,1 Nm [16 - 20 Ft-Lbs]
4	280	Set to 120,6 Bar, ± 3 - 4 Bar [1750 Psi, ± 50 Psi]
4	281	21,6 - 27,1 Nm [16 - 20 Ft-Lbs]
4	282	9,5 - 12,2 Nm [84 - 108 In-Lbs]
4	Note <u>1</u>	Assemble sight gauge nuts on inside of reservoir. Install sight gauge O-rings and gaskets on outside of reservoir. TIGHTEN ONLY FROM INSIDE OF RESERVOIR.
4	283	9,5 - 12,2 Nm [84 - 108 In-Lbs]
5	52	Apply Teflon tape to threads before assembly.
5	52	9,5 - 10,8 Nm [7 - 8 Ft-Lbs]
5	53	Apply Teflon tape to threads before assembly.
5	53	43,3 - 52,8 Nm [32 - 39 In-Lbs]
5	54	Apply Teflon tape to threads before assembly.
5	54 Note <u>5</u>	Torque to 43,3 Nm [32 Ft-Lbs] minimum. Orient at 30 degree angle as shown.
5	55	User-Adjustable relief valve assembly contains no serviceable parts. Replace as a complete unit.
5	55	31,2 - 36,6 Nm [23 - 27 ft-lbs]

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* Service Information (Continued)		L4071
5	61	Apply Teflon tape to threads before assembly.
5	61	43,3 - 52,8 Nm [32 - 39 In-Lbs]
5	62	31,2 - 37,9 Nm [23 - 28 Ft-Lbs]
5	63, 65	Attach chains before installing items 61, 62 and 64. Place large retaining ring around threaded side of fitting closest to item #51.
5	64	Apply Teflon tape to threads before assembly.
5	64	43,3 - 52,8 Nm [32 - 39 In-Lbs]
5	Note 1	43,3 - 52,8 Nm [32 - 39 Ft-Lbs]
5	Note 2	9,5 - 12,2 Nm [7 - 9 Ft-Lbs]
5	Note 3	Valve assembly part number and specifications located on side of manifold (item 51).
5	Note 4	Apply grease before installation.
5	Note 6	If connector is not oriented as shown: Remove 2 screws and rotate connector socket 180 degrees. Then, reinstall and tighten screws to 2,8 - 3,3 Nm [25 - 30 Ft-Lbs]. Do not overtighten.
6	80	Apply Teflon tape to threads before assembly.
6	80	21,6 - 27,1 Nm [16 - 20 Ft-Lbs]
6	80	Must be flush.
6	81	Apply Teflon tape to threads before assembly.
6	81	43,3 - 52,8 Nm [32 - 39 Ft-Lbs]
6	82	Apply Teflon tape to threads before assembly.
6	82	43,3 - 52,8 Nm [32 - 39 Ft-Lbs]
6	82	Must be flush.
6	84	Apply grease to seals and backup rings.
6	85	6,7 - 8,1 Nm [60 - 72 In-Lbs]
6	86	Apply Teflon tape to threads before assembly.
6	86	43,3 - 52,8 Nm [32 - 39 Ft-Lbs]
6	87	31,2 - 37,9 Nm [23 - 28 Ft-Lbs]
6	88, 89	Attach chains before installing items 81, 86 and 87. Place large retaining ring around threaded side of fitting closest to item #83.
7	92	0,45 - 0,50 Nm [4.0 - 4.5 In-Lbs]
7	95	1,6 - 1,8 Nm [14 - 16 In-Lbs]
8	Note 1	Apply RTV silicone to exposed threads of component fasteners.
8	Note 2	Apply Loctite 243 to threads before installation.
8	5, Note 3	7,8 - 8,1 Nm [60 - 72 In-Lbs]
8	Note 4	2,4 - 2,5 Nm [21 - 23 In-Lbs]
8	Note 5	4,8 - 5,1 Nm [42 - 46 In-Lbs]
10	204	Apply Loctite 2760 high strength sealant to threads before installation.
10	204	18,9 - 24,4 Nm [14 - 18 Ft-Lbs]
10	205	27,1 - 29,8 Nm [20 - 22 Ft-Lbs]
10	207	18,9 - 24,4 Nm [14 - 18 Ft-Lbs]
10	209	Apply grease before assembly.
10	210	Apply grease before assembly.
10	211	40,6 - 43,3 Nm [30 - 32 Ft-Lbs]

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* Service Information (Continued)		L4071
10	212	Orient fittings as shown.
10	213	18,9 - 24,4 Nm [14 - 18 Ft-Lbs]
10	215	Hand tighten the hose clamp screw to secure the hose.
10	216	Orient fittings as shown.
10	216	18,9 - 24,4 Nm [14 - 18 Ft-Lbs]
10	220	Apply Loctite 545 to threads before installation.
10	220	Orient fittings as shown.
10	220	18,9 - 24,4 Nm [14 - 18 Ft-Lbs]
10	221	54,2 - 61,0 Nm [40 - 45 Ft-Lbs]
10	222	Apply grease before assembly.
10	223	20,3 - 27,1 Nm [15 - 20 Ft-Lbs]
11	Note 	162,6 - 195,2 Nm [120 - 144 In-Lbs]
12	3	Press balance plate (Fig. 12, item 3) onto eccentric shaft (Fig. 12, item 1) using a 101 kN [10 Ton] hydraulic cylinder at 62 Bar [400 Psi] maximum pressure. Be certain that the balance plate is properly oriented to the shaft keyway. Fully seat the balance plate onto the shaft shoulder. See Fig. 12, Section A-A.
13	102	16,3 - 19,0 Nm [144 - 168 In-Lbs]
13	105	Apply Teflon tape to threads before assembly.
13	105	19 - 21 Nm [168 - 192 In-Lbs]
13	105	724 - 751 Nm [10500 - 10900 Psi]
13	113, 116	Use a 10 Ton cylinder pressurized at 48 - 55 Bar [700 - 800 Psi] to coin the seat.
14	102	16,3 - 19,0 Nm [144 - 168 In-Lbs]

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