

Tightening Torques					
			Nm	ft/lb	
Bearing housing / pump BA80 up to BA180	Impeller bolt	M8	23	16.9	
		M10	44	32.4	
		M12	77	56.8	
		M16	190	140.1	
		M20	370	272.9	
	Pump housing / suction flange side			60	44.2
	Pump housing / bearing housing side			60	44.2
	Pump housing / pump support			60	44.2
	Seal plate			30	22.1
	Bearing cover pump side			60	44.2
	Bearing cover engine side			30	22.1
	Adapter / engine side			100	73.8
	Inspection cover			80	59
	Suction unit / pump housing side			60	44.2
Suction unit / float box			60	44.2	
Float box	Valve guide		20	14.7	
	Valve holder		30	22.1	
	Float box cover square		60	44.2	
	Float box aluminium		23	16.9	
Vacuum pump MP50 / MP100	Bearing cover		23	16.9	
	Diaphragm bottom plate		35	25.8	
	Diaphragm cover		20	14.7	
	Diaphragm holder bolt		90	66.4	
	Valve rubber bolt		45	33.2	
	Diaphragm seat		20	14.7	
General information tightening torques	Grade 8.8				
		M5	7	5.2	
		M6	11,8	8.7	
		M8	28,8	21.2	
		M10	57,3	42.3	
		M12	99,8	77.6	
		M16	248	182.9	
		M20	500	368.8	
		M24	865	637.9	
		M30	1719	1267.9	