

Technical Information:

Date: Aug 06 2004
Subject: Liquid End Bolt / Screw Torque Settings
Product: Pump Liquid Ends
Category: Solenoid & Motor Driven Pumps
Pages : 2

Set stroke length to 100%

Tighten screws in a cross pattern

Tightening should be rechecked after 24 Hours operation and checked every 3 months.

GALA / Beta 4 / Beta 5

Liquid Ends 70 mm	2.3 – 3.0 Nm	1000, 1601, 1602
Liquid Ends 90 mm	4.5 – 5.0 Nm	1005, 0708, 0413, 0220
Liquid Ends 110 mm	4.5 – 5.0 Nm	0232

Sigma Pumps

Sigma 3 S3Ca and S3Ba	7.5 Nm +/- 0.5 Nm
Sigma 2 S2Ca and S2Ba	7.5 Nm +/- 0.5 Nm
SiCa / SiBa	7.5 Nm +/- 0.5 Nm
Sigma 1 S1Ca and S1Ba	4.5 Nm +/- 0.5 Nm

Vario Pumps

VAMa and VAMb	4.5 – 5.0 Nm
Vario C	4.5 – 5.0 Nm

Alpha

ALPa and ALPb	4.5 – 5.0 Nm
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Hydro Pumps

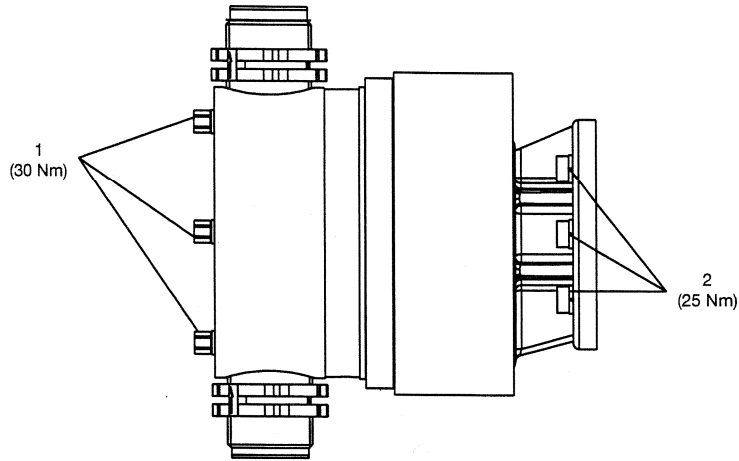
Liquid End Bolts	20 Nm
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Extronic Pump

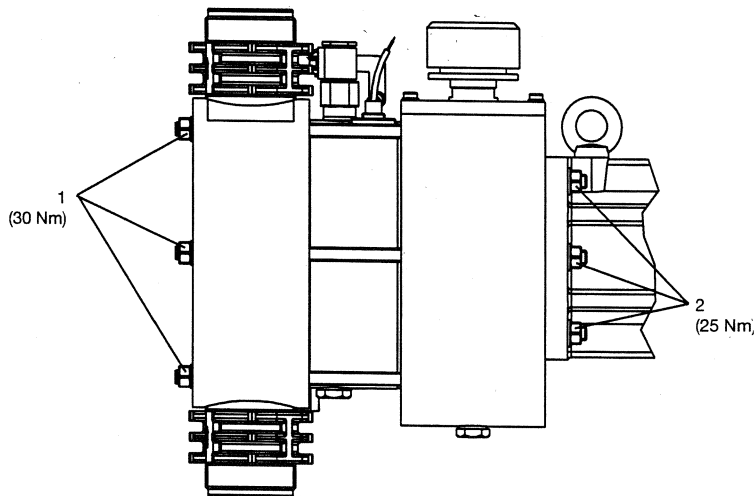
M4 Screws	2.5 – 3.0 Nm	Model 1000, 1601, 1201, 0803
M5 Screws	4.5 – 5.0 Nm	Model 1002, 0308, 2502, 1006, 0613, 0417, 2505, 1310, 0814, 0430, 0260

Makro

Makro TZ HM (1) Liquid End Bolts 30 Nm (2) Flange Bolts 25 Nm



Makro TZ HHM (1) Liquid End Bolts 30 Nm (2) Flange Bolts 25 Nm



Makro TZ HK (1) Liquid End Bolts 15Nm (2) Flange Bolts 25 Nm

