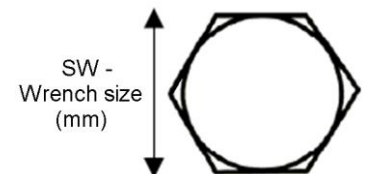


Appendix 2 - Tightening torques (Nm)

	DK K	DL, DLH L, LH	D2S	D2D 2D	D3S, D3D 3D	D4S, D4D	D6S, D6D D6T, 6T	D8S, D8D 8D	D8SK
Suction shut-off valve	5/16"-18 UNC 30 - 37 Nm SW 12.7	1/2"-13 UNC 46 - 56 Nm SW 19	1/2"-13 UNC 69 - 85 Nm SW 19		1/2"-13 UNC 53 - 84 Nm SW 19 5/8"-11 UNC 104 - 164 Nm SW 23.8		5/8"-11 UNC 104 - 164 Nm SW 23.8		
Discharge shut-off valve ¹⁾	5/16"-18 UNC 30 - 37 Nm SW 12.7		5/16"-18 UNC 33 - 39 Nm SW 12.7	1/2"-13 UNC 53 - 84 Nm SW 19		1/2"-13 UNC 53 - 84 Nm SW 19			5/8"-11 UNC 104 - 164 Nm SW 23.8
Rotalock nut	---	---	1 1/4"-12 UNF 30-40 Nm SW 36	1 3/4"-12 UNF 41- 54 Nm SW 50		1 3/4"-12 UNF 41 - 54 Nm SW 50		---	
Plug 3, 6, 7, 8 (DK only)	1/8"-27 NPTF 19 - 30 Nm SW 12.7		1/8"-27 NPTF 19 - 30 Nm SW 12.7			1/8"-27 NPTF 19 - 30 Nm SW 12.7			
Plug 4, 8, 16	---	1/4"-18 NPTF 27 - 50 Nm SW 17.5	1/4"-18 NPTF 27 - 50 Nm SW 17.5			1/4"-18 NPTF 27 - 50 Nm SW 17.5			
Plug 17	---	---	1/2" - 14 NPTF 57 - 80 Nm SW 27.0		3/8" - 18 NPTF 33 - 66 Nm SW 27.0		---		
Plug 18 (crankcase heater)	---	---	---			---	1/2"-14 NPTF 45 - 57 Nm SW 17.5		
Oil sight glass	1 1/8"-12 UNF 4.5 - 6 Nm ---		1 1/8"-12 UNF 4.5 - 6 Nm SW 11		1/4"-20 UNC 4.5 - 6 Nm SW 11				
Blind flange for oil screen	---	---	5/16"-18 UNC 26 - 32 Nm SW 12.7		---	---	---		
Blind flange for oil sight glass	---	---	---	1/4"-20 UNC 13-17 Nm SW 11.1		---	---	---	
Oil pump	---	5/16"-18 UNC 31 - 37 Nm SW 6.4	5/16"-18 UNC 31 - 37 Nm SW 6.4		SW 12.6	5/16"-18 UNC 31 - 37 Nm SW 12.7			
Oil pressure switch - OPS2	---	60 - 75 Nm	60 - 75 Nm			60 - 75 Nm			

¹⁾ Rotalock adapter with the exception of LH compressors

The ranges of torque values given in this specification are assembly torque. Torque after joint relaxation must be within 15% of the minimum assembly torque unless re-torque is called for and must not be above 10% of the maximum assembly torque.

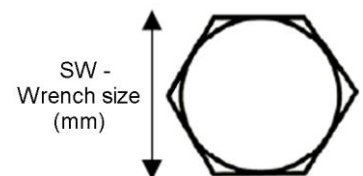


	DK K	DL, DLH L, LH	D2S	D2D 2D	D3S, D3D 3D	D4S, D4D	D6S, D6D D6T, 6T	D8S, D8D 8D
Magnetic plug ²⁾	1/8" - 27 NPTF 19 - 30 Nm SW 12.7		1/8" - 27 NPTF 26 - 32 Nm SW 12.7		1" - 16 UNC 87 - 149 Nm SW 25.4			
Cylinder head	5/16"-18 UNC 29 - 34 Nm SW 12.7	3/8"-16 UNC 57 - 68 Nm SW 14.2	3/8"-16 UNC 57-68 Nm SW 14.2		3/8"-16 UNC 57 - 68 Nm SW 14.2			
Bottom plate	5/16"-18 UNC 30 - 36 Nm SW 12.7	3/8"-16 UNC 57 - 68 Nm SW 14.2	3/8"-16 UNC 57-68 Nm SW 14.2		3/8"-16 UNC 57 - 68 Nm SW 14.2			
Mounting foot	5/16"-18 UNC 30 - 36 Nm SW 12.7	3/8"-16 UNC 57 - 68 Nm SW 14.2	3/8"-16 UNC 57-68 Nm SW 14.2		3/8"-16 UNC 57 - 68 Nm SW 14.2			
Stator cover	5/16"-18 UNC 30 - 36 Nm SW 12.7	3/8"-16 UNC 57-68 Nm SW 14.2	3/8"-16 UNC 57-68 Nm SW 14.2		1/2"-13 UNC 68-79 Nm SW 18			
Housing cover	5/16"-18 UNC 29 - 30 Nm SW 12.7	3/8"-16 UNC 57 - 68 Nm SW 14.2	3/8"-16 UNC 57 - 68 Nm SW 14.2		3/8"-16 UNC 57 - 68 Nm SW 14.2			
Mounting plate for terminals	---	---	---	5/16"-18 UNC 32 - 40 Nm SW 12.7		3/8"-16 UNC 57 - 68 Nm SW 14.2		
Terminal stud	1/4"-20 UNC 5-6.5 Nm SW 10			1/4"-28 UNF 5-6.5 Nm SW 10		1/4"-28 UNF 5-6.5 Nm SW 10		
Terminal stud thermistors	10 - 32 UNF 3.4 - 4 Nm SW 9			10 - 32 UNF 3.4 - 4 Nm SW 9		10 - 32 UNF 3.4 - 4 Nm SW 9		
Bolt for the connecting rod ³⁾	---	---	1/4"-28 UNF 15 - 18 Nm "Torx"-screw		1/4"-28 UNF 15 - 18 Nm "Torx"-screw			

²⁾ On LH compressors: 3/8" - 18 NPTF / 22-25 Nm / SW 12.7.

³⁾ In case of replacement of the piston con-rod assemblies, clean the Torx screws and apply Loctite 2701.

The ranges of torque values given in this specification are assembly torque. Torque after joint relaxation must be within 15% of the minimum assembly torque unless re-torque is called for and must not be above 10% of the maximum assembly torque.



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