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