

# Torques for EVAC KF Chain Clamps 30.1xx.xxx

08.09.99

Torques [Nm]

Chain Clamp	Recommended		Max
	Seal--> Elastomer	Alu	
30.111.216	1	N/A	2.5
30.111.225	1.5	N/A	2.5
30.111.240	2	N/A	2.5
30.111.250	2.5	N/A	2.5
30.111.263	2.5	N/A	2.5
30.111.516	1	N/A	2.5
30.111.525	1.5	N/A	2.5
30.111.540	2	N/A	2.5
30.111.550	2.5	N/A	2.5
30.111.563	2.5	N/A	2.5
30.114.216	1	N/A	2.5
30.114.225	1.5	N/A	2.5
30.114.240	2	N/A	2.5
30.114.250	2.5	N/A	2.5
30.114.263	2.5	N/A	2.5
30.114.516	1	N/A	2.5
30.114.525	1.5	N/A	2.5
30.114.540	2	N/A	2.5
30.114.550	2.5	N/A	2.5
30.114.563	2.5	N/A	2.5
30.111.716	1	N/A	2.5
30.111.725	1.5	N/A	2.5
30.111.740	2	N/A	2.5
30.111.750	2.5	N/A	2.5
30.111.763	2.5	N/A	2.5
30.111.816	1	N/A	2.5
30.111.825	1.5	N/A	2.5
30.111.840	2	N/A	2.5
30.111.850	2.5	N/A	2.5
30.111.863	2.5	N/A	2.5
30.131.816	1	N/A	2.5
30.131.825	1.5	N/A	2.5
30.131.840	2	N/A	2.5
30.131.850	2	N/A	2.5
30.131.916	1	N/A	2.5
30.131.925	1.5	N/A	2.5
30.131.940	2	N/A	2.5
30.131.950	2	N/A	2.5

Torques [Nm]

Chain Clamp	Recommended		Max
	Seal--> Elastomer	Alu	
30.151.216	1	2.5	5
30.151.225	1.5	3	5
30.151.240	2	4.5	5
30.151.250	2.5	5	5
30.151.263	2.5	5	5
30.151.316			
30.151.325	1	2.5	10
30.151.340	1.5	3	10
30.151.341	2	4.5	10
30.151.350	2.5	5	10
30.151.363	2.5	5	10
30.151.516	1	2.5	5
30.151.525	1.5	3	5
30.151.540	2	4.5	5
30.151.541	2	4.5	5
30.151.550	2.5	5	5
30.151.563	2.5	5	5
30.151.616	1	2.5	10
30.151.625	1.5	3	10
30.151.640	2	4.5	10
30.151.650	2.5	5	10
30.151.663	2.5	5	10
30.159.216	1	2.5	5
30.159.225	1.5	3	5
30.159.240	2	4.5	5
30.159.250	2.5	5	5
30.159.263	2.5	5	5
30.159.516	1	2.5	5
30.159.525	1.5	3	5
30.159.540	2	4.5	5
30.159.550	2.5	5	5
30.159.563	2.5	5	5

## Tightening of the chain clamps

The chains must be tightened with an appropriate torque wrench (with sufficient accuracy +20%).

Limiting the applied torque to the indicated recommended value assures proper sealing of the assembly and protects the chains from mechanical damage. If the listed torque does not make a vacuum seal, check the chain clamp for proper lubrication and or check the flanges.