# Torque Specs

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# 1.1 Helmet Torque Tables

## 1.1.1 SL 17B Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 4 | 530-090 | Screw, Alignment | 40<br>Medium Strength Thread Locker | 4.5<br>Medium Strength Thread Locker |
| 8 | 555-154 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 12 | 530-032 | Screw, Main Exhaust Body | 6<br>RTV Sealant | 0.7<br>RTV Sealant |
| 15 | 530-070 | Screw, Handle | 15<br>RTV Sealant | 1.7<br>RTV Sealant |
| 18 | 530-040 | Screw, Handle | 12 | 1.3 |
| 20 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 23 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 26 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 27 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 28 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 29 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 32 | 550-116 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 43 | 530-019 | Screw, Quad Exhaust | 12 | 1.3 |
| 56 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |
| 62 | 530-070 | Screw, For Mounting Weights And Chin Strap | 35<br>RTV Sealant | 4<br>RTV Sealant |
| 64 | 530-078 | Screw, For Mounting Weights | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 67 | 530-308 | Nut, Communications Posts | *Snug—DO NOT overtighten*<br>RTV Sealant | |
| 84 | 550-038 | Regulator Mount Nut | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |

## 1.1.2 SL 17C Torque Table

| Loc. # | Part # | Description | Torque in inch pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 7 | 555-154 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 11 | 530-070 | Screw, Top Weight | 20 | 2.3 |
| 12 | 530-035 | Screw, Water Dump Body | 6<br>RTV Sealant | 0.7<br>RTV Sealant |
| 13 | 530-070 | Screw, Port Weight | 20 | 2.3 |


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### 1.1.2 SL 17C Torque Table

| Loc. # | Part # | Description | Torque in inch pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 16 | 530-078 | Screw, Top Weight | 20 | 2.3 |
| 17 | 530-040 | Screw, Bracket | 12 | 1.3 |
| 20 | 530-062 | Screw, Rear Handle And Bracket | 35 | 4 |
| 24 | 530-045 | Screw, Handle | 12 | 1.3 |
| 26 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 29 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 32 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 33 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 34 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 35 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 38 | 550-116 | Nose Block Guide | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 44 | 530-015 | Screw, Sealed Pull Pin Assembly | *Medium-strength thread locker for pre-2026 bottom rings ONLY. NOT to be used on current stainless steel bottom rings.* | |
| 46 | 530-032 | Screw, Swing Catch Spring | 12 Medium Strength Thread Locker | 1.3 Medium Strength Thread Locker |
| 47 | 530-059 | Screw, Front Standoff | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 53 | 530-019 | Screw, Water Dump Cover (Exhaust) | 12 | 1.3 |
| 67 | 530-045 | Screw, Kidney Plate | 12 | 1.3 |
| 72 | 530-035 | Screw, Swing Catch | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 77 | 530-045 | Screw, Spring Spacer | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 81 | 530-018 | Screw | 24 Medium Strength Thread Locker | 2.7 Medium Strength Thread Locker |
| 87 | 530-064 | Screw, Neck Pad | *Snug—to no movement of pad* | |

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### 1.1.2 SL 17C Torque Table

| Loc. # | Part # | Description | Torque in inch pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 111 | 550-081 | Nut Regulator Mount | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |
| 115 | 530-018 | Screw, Earphone Retainer & Snaps | 12<br>RTV Sealant | 1.3<br>RTV Sealant |
| 118 | 530-031 | Screw, Chin Strap | 12<br>RTV Sealant | 1.3<br>RTV Sealant |

### 1.1.3 SL 27 Torque Tables

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 5 | 550-024 | Stud | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 7 | 555-154 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 10 | 530-070 | Screw, Port Weight | 20 | 2.3 |
| 13 | 530-078 | Screw, Rear Weight, SL 27 | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 16 | 530-070 | Screw, Handle | 15<br>RTV Sealant | 1.7<br>RTV Sealant |
| 20 | 530-045 | Screw, Handle | 12 | 1.3 |
| 22 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 25 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 28 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 30 | 530-062 | Screw, Port Weight | 15 | 1.7 |
| 31 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 32 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 33 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 36 | 550-116 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 41 | 530-015 | Screw, Sealed Pull Pin Assembly | *Medium-strength thread locker for pre-2026 bottom rings ONLY. NOT to be used on current stainless steel bottom rings.* | |
| 44 | 530-059 | Screw, Front Standoff | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 46 | 530-032 | Screw, Water Dump Body | 6<br>RTV Sealant | 0.7<br>RTV Sealant |
| 65 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |


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### 1.1.3 SL 27 Torque Tables

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 70 | 530-032 | Screw, Swing Catch Spring | 12<br>Medium Strength Thread Locker | 1.3<br>Medium Strength Thread Locker |
| 71 | 530-035 | Screw, Tongue Catch Mount | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 73 | 530-035 | Screw, Swing Catch | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 78 | 530-045 | Screw, Spring Spacer | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 85 | 530-064 | Screw, Neck Pad | *Snug—to no movement of pad* | |
| 102 | 550-081 | Regulator Mount Nut | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |
| 106 | 530-018 | Screw, Earphone Retainer & Snaps | 12<br>RTV Sealant | 1.3<br>RTV Sealant |
| 109 | 530-031 | Screw, Chin Strap | 12<br>RTV Sealant | 1.3<br>RTV Sealant |

### 1.1.4 KM 37 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque Newton Meters |
|---|---|---|---|---|
| 7 | 555-154 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 11 | 530-070 | Screw, Top Weight | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 12 | 530-032 | Screw, Water Dump Body | 6<br>RTV Sealant | 0.7<br>RTV Sealant |
| 13 | 530-070 | Screw, Top Weight (Handle) | 20 | 2.3 |
| 13 | 530-070 | Screw, Port Weight | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 16 | 530-078 | Screw, Top Weight | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 19 | 530-078 | Screw, Top Weight (Outer) | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 23 | 530-045 | Screw, Handle | 12 | 1.3 |
| 25 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 28 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 31 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |

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### 1.1.4 KM 37 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque Newton Meters |
|---|---|---|---|---|
| 33 | 530-062 | Screw, Port Weight | 15 | 1.7 |
| 34 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 35 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 36 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 39 | 550-116 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 44 | 530-015 | Screw, Sealed Pull Pin Assembly | *Medium-strength thread locker for pre-2026 bottom rings ONLY. NOT to be used on current stainless steel bottom rings.* | |
| 47 | 530-059 | Screw, Front Standoff | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 53 | 530-019 | Screw, Quad Exhaust Cover | 12 | 1.3 |
| 67 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |
| 72 | 530-032 | Screw, Swing Catch Spring | 12<br>Medium Strength Thread Locker | 1.3<br>Medium Strength Thread Locker |
| 73 | 530-035 | Screw, Tongue Catch Mount | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 75 | 530-035 | Screw, Swing Catch | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 80 | 530-045 | Screw, Spring Spacer | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 87 | 530-064 | Screw, Neck Pad | *Snug—to no movement of pad* | |
| 104 | 550-081 | Regulator Mount Nut | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |
| 108 | 530-018 | Screw, Earphone Retainer & Snaps | 12<br>RTV Sealant | 1.3<br>RTV Sealant |
| 111 | 530-031 | Screw, Chin Strap | 12<br>RTV Sealant | 1.3<br>RTV Sealant |


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### 1.1.5 KM 37SS Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 6 | 530-058 | Screw, Handle Rear | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 8 | 530-078 | Screw, Handle Grip | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 15 | 530-059 | Screw, Handle Front | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 19 | 530-083 | Screw, Side Block | 20 | 2.3 |
| 23 | 530-317 | Nut, Air Train Assembly | 35 | 4 |
| 25 | 530-059 | Screw, Port Retainer | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 26 | 550-566 | Adaptor, Port Retainer Plug | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 27 | 530-052 | Screw, Port Retainer Plug | 15 | 1.7 |
| 28 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 31 | 550-577 | Nose Block Guide | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 36 | 550-081 | Regulator Mount Nut | 75 Molykote® 111 Lubricate or Equivalent | 8.5 Molykote® 111 Lubricate or Equivalent |
| 64 | 530-070 | Screw, Whisker Kidney Plate/Anode | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 74 | 530-032 | Screw, Swing Catch Spring | 12 Medium Strength Thread Locker | 1.3 Medium Strength Thread Locker |
| 75 | 530-035 | Screw, Swing Catch | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |

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### 1.1.5 KM 37SS Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 82 | 530-045 | Screw, Spring Spacer | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 90 | 530-037 | Screw, Earphone Retainer | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 90 | 530-037 | Screw, Snap Tab | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 94 | 530-059 | Screw, Front Standoff | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 97 | 530-015 | Screw, Sealed Pull Pin Assembly | *Apply Medium Strength Thread Locker to the threads and install the screw until the head is bottomed out, just snug.* | |
| 105 | 550-178 | Stud | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 107 | 555-154 | Bent Tube, Side Block End | 75 | 8.5 |
| not numbered | 530-037 | Screw, Chin Strap Assembly | 6 Medium Strength Thread Locker | 0.7 Medium Strength Thread Locker |

### 1.1.6 KM 47 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 9 | 550-372 | Regulator Mount Nut | 75 Molykote® 111 Lubricate or Equivalent | 8.5 Molykote® 111 Lubricate or Equivalent |
| 14 | 555-167 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 14 | 555-167 | Bent Tube, Regulator End | 40 | 4.5 |
| 18 | 530-070 | Screw, Top Weight | 20 RTV Sealant | 2.3 RTV Sealant |
| 20 | 530-070 | Screw, Handle | 35 | 4 |


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### 1.1.6 KM 47 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 20 | 530-070 | Screw, Port Weight | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 23 | 530-078 | Screw, Top Weight | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 26 | 530-078 | Screw, Top Weight (Outer) | 20<br>RTV Sealant | 2.3<br>RTV Sealant |
| 30 | 530-045 | Screw, Handle | 12 | 1.3 |
| 32 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 35 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 38 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 40 | 530-062 | Screw, Port Weight | 15 | 1.7 |
| 41 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 42 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 43 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 46 | 550-116 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 51 | 530-015 | Screw, Sealed Pull Pin Assembly | *Medium-strength thread locker for pre-2026 bottom rings ONLY. NOT to be used on current stainless steel bottom rings.* | |
| 55 | 530-045 | Screw, Whisker, Kidney Plate | 12 | 1.3 |
| 57 | 530-032 | Screw, Swing Catch Spring | 12<br>Medium Strength Thread Locker | 1.3<br>Medium Strength Thread Locker |
| 58 | 530-059 | Screw, Swing Standoff | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 63 | 530-035 | Screw, Swing Catch | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 68 | 530-045 | Screw, Spring Spacer | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 76 | 550-113 | Screw, Neck Pad | *Snug—to no movement of pad* | |
| 88 | 530-018 | Screw, Earphone Retainer & Snaps | 12<br>RTV Sealant | 1.3<br>RTV Sealant |
| 91 | 530-031 | Screw, Chin Strap | 12<br>RTV Sealant | 1.3<br>RTV Sealant |

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### 1.1.7 KM 57 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque Newton Meters |
|---|---|---|---|---|
| 7 | 555-154 | Bent Tube Assembly, Side Block End | 75 | 8.5 |
| 11 | 530-070 | Screw, Top Weight | 20 RTV Sealant | 2.3 RTV Sealant |
| 12 | 530-032 | Screw, Water Dump Body | 6 RTV Sealant | 0.7 RTV Sealant |
| 13 | 530-070 | Screw, Top Weight (Handle) | 20 | 2.3 |
| 13 | 530-070 | Screw, Port Weight | 20 RTV Sealant | 2.3 RTV Sealant |
| 16 | 530-078 | Screw, Top Weight | 20 RTV Sealant | 2.3 RTV Sealant |
| 19 | 530-078 | Screw, Top Weight (Outer) | 20 RTV Sealant | 2.3 RTV Sealant |
| 23 | 530-045 | Screw, Handle | 12 | 1.3 |
| 25 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 28 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 31 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 33 | 530-062 | Screw, Port Weight | 15 | 1.7 |
| 34 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 35 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 36 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 39 | 550-116 | Nose Block Guide | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 44 | 530-015 | Screw, Sealed Pull Pin Assembly | *Medium-strength thread locker for pre-2026 bottom rings ONLY. NOT to be used on current stainless steel bottom rings.* | |
| 45 | 530-032 | Screw, Swing Catch Spring | 12 Medium Strength Thread Locker | 1.3 Medium Strength Thread Locker |
| 51 | 530-019 | Screw, Quad Exhaust Cover | 12 | 1.3 |
| 66 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |
| 71 | 530-035 | Screw, Swing Catch | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 76 | 530-045 | Screw, Spring Spacer | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 84 | 530-064 | Screw, Neck Pad | *Snug—to no movement of pad* | |


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### 1.1.7 KM 57 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque Newton Meters |
|---|---|---|---|---|
| 99 | 550-081 | Regulator Mount Nut | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |
| 103 | 530-018 | Screw, Earphone Retainer & Snaps | 12<br>RTV Sealant | 1.3<br>RTV Sealant |
| 106 | 530-031 | Screw, Chin Strap | 12<br>RTV Sealant | 1.3<br>RTV Sealant |

### 1.1.8 KM 77 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 6 | 530-058 | Screw, Handle Rear | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 8 | 530-078 | Screw, Handle Grip | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 15 | 530-059 | Screw, Handle Front | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 19 | 530-083 | Screw, Side Block | 20 | 2.3 |
| 23 | 530-317 | Nut, Air Train Assembly | 35 | 4 |
| 25 | 530-059 | Screw, Port Retainer | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 26 | 550-566 | Adapter, Port Retainer Plug | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 27 | 530-052 | Screw, Port Retainer Plug | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 28 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 31 | 550-577 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |

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| | | | | |
|---|---|---|---|---|
| 42 | 550-372 | Regulator Mount Nut | 80<br>Molykote® 111 Lubricate or Equivalent | 9<br>Molykote® 111 Lubricate or Equivalent |
| 57 | 530-070 | Screw, Whisker Kidney Plate/ Anode | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 60 | 530-032 | Screw, Swing Catch Spring | 12<br>Medium Strength Thread Locker | 1.3<br>Medium Strength Thread Locker |
| 61 | 530-035 | Screw, Swing Spacer | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 68 | 530-045 | Screw, Spring Spacer | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 76 | 530-037 | Screw, Earphone Retainer | 10<br>Medium Strength Thread Locker | 1.1<br>Medium Strength Thread Locker |
| 76 | 530-037 | Screw, Snap Tab | 10<br>Medium Strength Thread Locker | 1.1<br>Medium Strength Thread Locker |
| 80 | 530-059 | Screw, Front Standoff | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 83 | 530-015 | Screw, Sealed Pull Pin Assembly | *Apply Medium Strength Thread Locker to the threads and install the screw until the head is bottomed out, just snug.* | |
| 92 | 555-167 | Bent Tube, Side Block End | 75 | 8.5 |
| not numbered | 530-037 | Screw, Chin Strap Assembly | 6<br>Medium Strength Thread Locker | 0.7<br>Medium Strength Thread Locker |

### 1.1.9 KM 97 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 6 | 530-058 | Screw, Handle Rear | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |


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### 1.1.9 KM 97 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 8 | 530-078 | Screw, Handle Grip | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 15 | 530-059 | Screw, Handle Front | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 19 | 530-083 | Screw, Side Block | 20 | 2.3 |
| 23 | 530-317 | Nut, Air Train Assembly | 35 | 4 |
| 25 | 530-059 | Screw, Port Retainer | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 26 | 550-566 | Adapter, Port Retainer Plug | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 27 | 530-052 | Screw, Port Retainer Plug | 15 | 1.7 |
| 28 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 31 | 550-577 | Nose Block Guide | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 42 | 550-081 | Regulator Mount Nut | 75 Molykote® 111 Lubricate or Equivalent | 8.5 Molykote® 111 Lubricate or Equivalent |
| 63 | 530-070 | Screw, Anode | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 73 | 530-032 | Screw, Swing Catch Spring | 12 Medium Strength Thread Locker | 1.3 Medium Strength Thread Locker |
| 74 | 530-035 | Screw, Swing Catch | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 81 | 530-045 | Screw, Spring Spacer | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |

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### 1.1.9 KM 97 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 93 | 530-059 | Screw, Front Standoff | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 89 | 530-037 | Screw, Earphone Retainer | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 89 | 530-037 | Screw, Snap Tab | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 96 | 530-015 | Screw, Sealed Pull Pin Assembly | *Apply Medium Strength Thread Locker to the threads and install the screw until the head is bottomed out, just snug.* | |
| 104 | 550-178 | Stud | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 106 | 555-154 | Bent Tube, Side Block End | 75 | 8.5 |
| not numbered | 530-037 | Screw, Chin Strap Assembly | 6 Medium Strength Thread Locker | 0.7 Medium Strength Thread Locker |

### 1.1.10 KM Diamond Torque Tables

#### 1.1.10.1 500-710/500-711 KM Diamond

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 9 | 530-058 | Screw, Handle Rear | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 11 | 530-078 | Screw, Handle Grip | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |
| 18 | 530-059 | Screw, Handle Front | 15 Medium Strength Thread Locker | 1.7 Medium Strength Thread Locker |


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## 1.1.10 KM Diamond Torque Tables

### 1.1.10.1 500-710/500-711 KM Diamond

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 23 | 530-059 | Screw, Port Retainer | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 24 | 550-566 | Adapter, Port Retainer Plug | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 25 | 530-052 | Screw, Port Retainer Plug | 15 | 1.7 |
| 29 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 32 | 550-577 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 35 | 530-074 | Screw, SBV | 30<br>Medium Strength Thread Locker | 3.4<br>Medium Strength Thread Locker |
| 38 | 530-059 | Screw, SBV Bracket | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |
| 41 | 530-076 | Screw, SBV Bracket | 30<br>Medium Strength Thread Locker | 3.4<br>Medium Strength Thread Locker |
| 45 | 530-317 | Nut, Air Train Assembly | 35 | 4 |
| 46 | 530-083 | Screw, Side Block | 20 | 2.3 |
| 50 | 530-032 | Screw, Swing Catch Spring | 12<br>Medium Strength Thread Locker | 1.3<br>Medium Strength Thread Locker |
| 52 | 530-059 | Screw, Front Standoff | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |
| 58 | 830-015 | Screw, Oral Nasal Mount | 10<br>RTV Sealant | 1.1<br>RTV Sealant |
| 89 | 550-050 | Jam Nut | 40 | 4.5 |
| 92 | 530-059 | Screw, Pod Mounting (Inside) | 30 | 3.4 |
| 94 | 530-035 | Screw, Swing Catch | 20<br>Medium Strength Thread Locker | 2.3<br>Medium Strength Thread Locker |

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## 1.1.10 KM Diamond Torque Tables

### 1.1.10.1 500-710/500-711 KM Diamond

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 99 | 530-045 | Screw, Spring Spacer | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 102 | 530-037 | Screw, Earphone Retainer | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 102 | 530-037 | Screw, Snap Tab | 10 Medium Strength Thread Locker | 1.1 Medium Strength Thread Locker |
| 123 | 530-015 | Screw, Sealed Pull Pin Assembly | *Apply Medium Strength Thread Locker to the threads and install the screw until the head is bottomed out, just snug.* | |
| 135 | 550-178 | Stud | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 138 | 555-074 | Bent Tube, Side Block End | 75 | 8.5 |
| not numbered | 530-037 | Screw, Chin Strap Assembly | 6 Medium Strength Thread Locker | 0.7 Medium Strength Thread Locker |

### 1.1.10.2 505-373 Regulator Cover Assembly

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 27 | 530-099 | Cover Retainer Screw | 18 | 2 |
| 28 | 550-074 | Bishop Pin | 20 | 2.3 |

### 1.1.10.3 505-375 Surface Bypass Valve Assembly

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 550-616 | Hose Fitting Adapter ½" NPT | 80 | 9 |
| 24 | 550-617 | Adapter Nipple | 60 | 6.8 |


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### 1.1.10.4 505-400 Diamond Exhaust Assembly

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 2 | 830-015 | Screw, Split Retainer | *Tighten the hex screws until the top of each screw is just barely below the outer surface of the knob.* | |
| 22 | 530-309 | Cap Screw | 20 | 2.3 |
| 23 | 550-618 | Adapter Outlet | 60 | 6.8 |

### 1.1.10.5 505-752 Diamond Main Tube

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 14 | 550-567 | Adjustment packing Nut | 60 | 6.8 |
| 88 | 550-533 | Bent Tube Adapter | 60 | 6.8 |

## 1.2 BandMask® Torque Tables

### 1.2.1 KMB 18 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 7 | 550-081 | Regulator Mount Nut | 75<br>Molykote® 111 Lubricate or Equivalent | 8.5<br>Molykote® 111 Lubricate or Equivalent |
| 11<br>*See note 2* | 530-097 | Screw, Band Adjustment, Bronze | 26<br>*See note 2* | 2.9<br>*See note 2* |
| 15 | 530-060 | Comfort Insert Screw | 6 | 0.7 |
| 18 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 20 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 24 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 25 | 530-062 | Screw, Band Keeper | 14 | 1.6 |
| 28 | 530-073 | Screw,Band Keeper | 12 | 1.3 |
| 33 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 34 | 530-073 | Screw,Band Keeper | 12 | 1.3 |
| 37 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 39 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 42 | 550-116 | Nose Block Guide | 15<br>Medium Strength Thread Locker | 1.7<br>Medium Strength Thread Locker |

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### 1.2.1 KMB 18 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 43 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |
| 61 | 530-035 | Screw, Water Dump | 6<br>RTV Sealant | 0.7<br>RTV Sealant |
| 63 | 555-154 | Bent Tube Assembly,<br>Side Block End | 75 | 8.5 |

### 1.2.2 KMB 28 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 7 | 550-081 | Regulator Mount Nut | 75<br>Molykote® 111<br>Lubricate or<br>Equivalent | 8.5<br>Molykote® 111<br>Lubricate or<br>Equivalent |
| 11<br>*See note 2* | 530-097 | Screw, Band Adjustment, Bronze | 26<br>*See note 2* | 2.9<br>*See note 2* |
| 18 | 530-317 | Nut, Air Train (Outer) | 15 | 1.7 |
| 20 | 530-317 | Nut, Air Train (Inner) | 35 | 4 |
| 22 | 530-050 | Screw, Side Block | 20 | 2.3 |
| 23 | 530-062 | Screw, Band Keeper | 14 | 1.6 |
| 26 | 530-073 | Screw,Band Keeper | 12 | 1.3 |
| 31 | 530-052 | Screw, Port Retainer Plug | 20 | 2.3 |
| 32 | 530-073 | Screw,Band Keeper | 12 | 1.3 |
| 35 | 530-035 | Screw, Port Retainer | 12 | 1.3 |
| 37 | 550-062 | Knob, Nose Block | *Tighten to bottom out* | |
| 40 | 550-116 | Nose Block Guide | 15<br>Medium Strength<br>Thread Locker | 1.7<br>Medium Strength<br>Thread Locker |
| 41 | 530-045 | Screw, Whisker Kidney Plate | 12 | 1.3 |
| 59 | 555-154 | Bent Tube Assembly,<br>Side Block End | 75 | 8.5 |

## 1.3 Surface Supplied MOD-1 Torque Tables

### 1.3.1 Surface Supplied MOD-1

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 11 | 230-017 | Adjustment Knob Screw | Tighten until the screw head is just below knob surface | |
| 13 | 830-076 | Screw | 25 | 2.8 |
| 15 | 530-070 | Screw | 25 | 2.8 |


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### 1.3.1 Surface Supplied MOD-1

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 20 | 530-070 | Screw | 25 | 2.8 |

### 1.3.2 Surface Supplied Pod

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 9 | 805-250 | Main Tube Hex | 12 | 1.3 |
| 17 | 830-046 | Screw | 20 | 2.3 |
| 18 | 830-078 | Screw | 25 | 2.8 |
| 21 | 850-129 | Banjo Tube | 28 | 3.2 |
| 25 | 850-124 | Cap | 30 | 3.4 |
| 26 | 830-073 | Mount Screw Long | 15 | 1.7 |
| 28 | 830-041 | Mount Screw | 15 | 1.7 |

### 1.3.3 Regulator Pod Sub-Assembly

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 4 | 850-132 | Port Plug | 15 | 1.7 |
| 13 | 830-014 | Screw | 8 | 0.9 |

### 1.3.4 Side Block Sub-Assembly w/Emergency Valve

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 3 | 850-126 | Hose Adapter | 70 | 7.9 |
| 6 | 850-126 | Hose Adapter | 70 | 7.9 |
| 22 | 550-095 | Plug w/ O-ring | 20 | 2.3 |

### 1.3.5 Main Tube Assembly/Surf-Sup

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 20 | 220-021 | End Cap Packing Nut | 8 | 0.9 |

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# 1.4 Side Block Torque Tables

## 1.4.1 Side Block Torque Table (Stainless Steel)

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 555-117 | Adapter, Brass (Umbilical) | See Note 1 | See Note 1 |
| 2 | 555-195 | One Way Valve Seat | 150 | 17 |
| 8 | 555-195 | One Way Valve Body | 150 | 17 |
| 11 | 850-126 | Hose Adapter | 70 | 7.9 |
| 15 | 350-060 | Low Pressure Plug, Large | 20 | 2.3 |
| 23 | 550-568 | Bonnet, Steady Flow Valve | 100 | 11.3 |
| 28 | 550-564 | Side Block Bent Tube Adapter | 100 Medium Strength Thread Locker | 11.3 Medium Strength Thread Locker |
| 30 | 550-095 | L.P. Plug, w/O-ring | 20 | 2.3 |
| 37 | 550-551 | Bonnet, EGS Valve | 100 | 11.3 |

## 1.4.2 Brass Side Block Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 555-117 | Adapter, Brass | See Note 1 | See Note 1 |
| 2 | 555-195 | Seat, One Way Valve | 150 | 17 |
| 8 | 555-195 | Body, One Way Valve | 150 | 17 |
| 12 | 550-024 | Stud, Side Block | 20 Medium Strength Thread Locker | 2.3 Medium Strength Thread Locker |
| 18 | 550-020 | Bonnet, Steady Flow Valve | 100 | 11.3 |
| 23 | 550-095 | L.P. Plug, w/O-ring | 20 | 2.3 |
| 25 | 550-140 | Emergency Valve Body | See Note 1 | See Note 1 |
| 29 | 550-091 | Packing Nut | 45 after seating | 5.1 after seating |


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# 1.5 Regulator Torque Tables

## 1.5.1 SuperFlow® Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 550-050 | Jam Nut, Regulator | 40 | 4.5 |
| 2 | 550-048 | Inlet Nipple, Regulator | 40 | 4.5 |
| 3 | 550-046 | Inlet Nipple, Regulator | 40 | 4.5 |
| 17 | 550-055 | Packing Nut, Regulator | 40<br>after seating | 4.5<br>after seating |
| 27 | 530-030 | Screw, Regulator Clamp | 12 | 1.3 |

## 1.5.2 SuperFlow® 350 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 550-050 | Jam Nut | 40 | 4.5 |
| 2 | 550-048 | Inlet Nipple | 40 | 4.5 |
| 13 | 550-055 | Packing Nut | 40<br>after seating | 4.5<br>after seating |
| 23 | 530-030 | Screw, Regulator Clamp | 12 | 1.3 |
| 32 | 530-020 | Screw, Exhaust Flange | 10<br>Medium Strength Thread Locker | 1.1<br>Medium Strength Thread Locker |

## 1.5.3 SuperFlow® 450 Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 1 | 550-050 | Jam Nut, Regulator | 40 | 4.5 |
| 2 | 550-533 | Bent Tube Adapter, 450 Regulator | 30 | 3.4 |
| 18 | 550-526 | Packing Nut, 450 Regulator | 30 | 3.4 |
| 30 | 530-052 | Screw, 450 Regulator Cover | 12 | 1.3 |

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### 1.5.4 REX® Regulator Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 8 | 350-025 | Packing Nut, Regulator Knob | 40 | 4.5 |
| 34 | 550-560 | Adjustment Lock Nut, REX | 40 | 4.5 |

### 1.5.5 455 Balanced Regulator Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 17 | 550-567 | Adjustment Packing Nut | 60 | 6.8 |
| 31 | 530-099 | Cover Retainer Screw | 18 | 2 |
| 35 | 550-533 | Bent Tube Adapter | 60 | 6.8 |
| 36 | 550-050 | Jam Nut | 40 | 4.5 |

## 1.6 Communications Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 15 | 530-308 | Nut, Communications Posts | *Snug—DO NOT overtighten* RTV Sealant | |
| 21 | 550-040 | Mount Nut, Communications Gland | 20 | 2.3 |
| 28 | 555-178 | Packing Nut, Waterproof Connector | 20 | 2.3 |

## 1.7 Neck Ring Torque Tables

### 1.7.1 Neoprene Neck Ring Assembly Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 5 | 530-024* | Screw, Split Ring | 14 | 1.6 |
| 6 | 530-022 | Screw, Split Ring | 14 Medium Strength Thread Locker | 1.6 Medium Strength Thread Locker |
| 7 | 530-220 | Screw, Pull Strap | 14 | 1.6 |


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### 1.7.2 Latex Neck Ring Assembly Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 6 | 530-018 | Screw | 24 Medium Strength Thread Locker | 2.7 Medium Strength Thread Locker |
| 7 | 530-024* | Screw | 14 | 1.6 |
| 8 | 530-022 | Screw | 14 Medium Strength Thread Locker | 1.6 Medium Strength Thread Locker |
| 9 | 530-220 | Screw, Pull Strap Plate | 14 Medium Strength Thread Locker | 1.6 Medium Strength Thread Locker |

### 1.7.3 SL 17B Neck Clamp Yoke Assembly

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 5 | 530-320 | Nut, Lock | 50 ***Maximum*** | 5.7 ***Maximum*** |
| 7 | 530-066 | Screw | 20 | 2.3 |
| 19 | 530-080 | Screw, Yoke | 20 | 2.3 |
| 23 | 530-025 | Screw, Rear Hinge Tab | 25 | 2.8 |

## 1.8 Locking Collar Torque Table

### 1.8.1 Locking Collar Torque Table (Stainless Steel)

| Loc. # | Part # | Description | Torque |
|---|---|---|---|
| 5 | 530-064 | Screw, Neck Pad | *Snug—to no movement of pad* |

## 1.9 Manifold Block Torque Table

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| 4 | 550-091 | Packing Nut | 45 after seating | 5.1 after seating |

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| | | | | |
|---|---|---|---|---|
| 8 | 550-140 | Emergency Valve Body | See Note 1 | See Note 1 |
| 11 | 550-095 | Plug, L.P | 20 | 2.3 |
| 13 | 555-195 | Body, One Way Valve | 150 | 17 |
| 19 | 555-195 | Body, One Way Valve | 150 | 17 |
| 21 | 555-117 | Adapter | See Note 1 | See Note 1 |
| 22 | 355-225 | Adapter | See Note 1 | See Note 1 |
| 23 | 355-205 | Adapter | See Note 1 | See Note 1 |
| 24 | 530-070 | Screw | 35 | 4 |
| 29 | 350-060 | Plug, Large | 20 | 2.3 |
| 30 | 550-095 | Plug, L.P | 20 | 2.3 |

## 1.10 Miscellaneous Torque Specifications

| Loc. # | Part # | Description | Torque in Inch Pounds | Torque in Newton Meters |
|---|---|---|---|---|
| — | 200-017 | Overpressure Relief Valve | 20 | 2.3 |
| — | 530-210 | Weld Lens Mount Bolt | 23 | 2.6 |
| — | 555-210 | Restrictor Adaptor | 20 | 2.3 |

## 1.11 Notes on Torque Specifications




**NOTE 1:** Use Teflon® tape for two to two and a half wraps, starting two threads back from the pipe thread end of the fitting to avoid getting Teflon® tape in the valve. Tighten pipe thread using standard pipe threading procedures.




**NOTE 2:** Maximum torque, bands should have no less than an ⅛ inch even gap between the bands. On installation, a marine grade anti-seize may be used on this screw.




**NOTE 3:** Kirby Morgan recommends that torque tools be calibrated annually. (Allowable deviation: ±8%).

*The screws may need adjustment after several dives.

## 1.12 Checklist, Maintenance, and Pre-Dive Inspections

For the most current check lists, helmet and BandMask® maintenance procedures, and pre-dive inspections, please check on the internet at www.divelab.com.


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