

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 <i>Loctite® 222/248</i>	4.5 <i>Loctite® 222/248</i>
8	555-154	Bent Tube Assembly, Side Block End	75	8.5
12	530-032	Screw, Main Exhaust Body	6 RTV Sealant	0.67 RTV Sealant
15	530-070	Screw, Handle	15 RTV Sealant	1.7 RTV Sealant
18	530-040	Screw, Handle	12	1.3
20	530-050	Screw, Side Block	20	2.25
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	2.25
28	530-035	Screw, Port Retainer	12	1.3
29	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
32	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
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 RTV Sealant	4 RTV Sealant
64	530-078	Screw, For Mounting Weights	20 RTV Sealant	2.25 RTV Sealant
67	530-308	Nut, Communications Posts	<i>Snug—DO NOT overtighten RTV Sealant</i>	
84	550-038	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads

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	2.25
12	530-035	Screw, Water Dump Body	6 RTV Sealant	0.67 RTV Sealant
13	530-070	Screw, Port Weight	20	2.25
16	530-078	Screw, Top Weight	20	2.25

1.1.2 SL 17C Torque Table

Loc. #	Part #	Description	Torque in inch pounds	Torque in Newton Meters
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	2.25
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	2.25
34	530-035	Screw, Port Retainer	12	1.3
35	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
38	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
44	530-015	Screw, Pull Pin	<i>Apply Loctite® 222/248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
46	530-032	Screw, Swing Catch Spring	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
47	530-059	Screw, Front Standoff	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
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 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
77	530-045	Screw, Swing Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
81	530-018	Screw	24 <i>Loctite® 222/248</i>	2.7 <i>Loctite® 222/248</i>
87	530-064	Screw, Neck Pad	<i>Snug—to no movement of pad</i>	
111	550-081	Nut Regulator Mount	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
115	530-018	Screw, Earphone Retainer	16	1.8
118	530-031	Screw, Chin Strap	14	1.6

1.1.3 SL 27 Torque Tables

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
7	555-154	Bent Tube Assembly, Side Block End	75	8.5
10	530-070	Screw, Port Weight	20	2.25
13	530-078	Screw, Rear Weight, SL 27	20 RTV Sealant	2.25 RTV Sealant
16	530-070	Screw, Handle	15 RTV Sealant	1.7 RTV Sealant
20	530-045	Screw, Handle	12	1.3
22	530-050	Screw, Side Block	20	2.25
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	30	3.38
31	530-052	Screw, Port Retainer Plug	20	2.25
32	530-035	Screw, Port Retainer	12	1.3
33	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
36	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
41	530-015	Screw, Helmet Ring, Sealed Pull Pin	<i>Apply Loctite® 222/248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
44	530-059	Screw, Front Standoff	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
46	530-032	Screw, Water Dump Body	6 RTV Sealant	0.67 RTV Sealant
65	530-045	Screw, Whisker Kidney Plate	12	1.3
70	530-035	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
75	530-045	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
83	530-064	Screw, Neck Pad	<i>Snug—to no movement of pad</i>	
98	550-081	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
102	530-018	Screw, Earphone Retainer	16	1.8
105	530-031	Screw, Chin Strap	14	1.5

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

1.1.4 KM 37 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque Newton Meters
11	530-070	Screw, Top Weight	20 RTV Sealant	2.25 RTV Sealant
12	530-032	Screw, Water Dump Body	6 RTV Sealant	0.67 RTV Sealant
13	530-070	Screw, Top Weight (Handle)	20	2.25
13	530-070	Screw, Port Weight	20 RTV Sealant	2.25 RTV Sealant
16	530-078	Screw, Top Weight	20 RTV Sealant	2.25 RTV Sealant
19	530-078	Screw, Top Weight (Outer)	20 RTV Sealant	2.25 RTV Sealant
23	530-045	Screw, Handle	12	1.3
25	530-050	Screw, Side Block	20	2.25
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	30	3.38
34	530-052	Screw, Port Retainer Plug	20	2.25
35	530-035	Screw, Port Retainer	12	1.3
36	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
39	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
44	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 222/248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
46	530-032	Screw, Swing Catch Spring	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
47	530-059	Screw, Front Standoff	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
53	530-019	Screw, Quad Exhaust Cover	12	1.3
67	530-045	Screw, Whisker Kidney Plate	12	1.3
72	530-035	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
77	530-045	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
85	530-064	Screw, Neck Pad	<i>Snug—to no movement of pad</i>	
100	550-081	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
104	530-018	Screw, Earphone Retainer	16	1.8

1.1.4 KM 37 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque Newton Meters
107	530-031	Screw, Chin Strap	14	1.5

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 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
8	530-078	Screw, Handle Grip	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
15	530-059	Screw, Handle Front	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
19	530-083	Screw, Side Block	20	2.25
23	530-317	Nut, Air Train Assembly	35	4
25	530-059	Screw, Port Retainer	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
26	550-566	Adaptor, Port Retainer Plug	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
27	530-052	Screw, Port Retainer Plug	15	1.7
28	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
31	550-577	Nose Block Guide	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
36	550-081	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
64	530-070	Screw, Whisker Kidney Plate/Anode	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
74	530-032	Screw, Tongue Catch Spring	12 <i>Loctite® 248</i>	1.3 <i>Loctite® 248</i>
75	530-035	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
82	530-045	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
90	530-037	Screw, Earphone Retainer	10 <i>Loctite® 248</i>	1.1 <i>Loctite® 248</i>
90	530-037	Screw, Snap Tab	10 <i>Loctite® 248</i>	1.13 <i>Loctite® 248</i>
94	530-059	Screw, Front Standoff	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
97	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 248 to the threads and install the screw until the head is bottomed out, just snug.</i>	

1.1.5 KM 37SS Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
106	555-154	Bent Tube, Side Block End	75	8.5
not numbered	530-037	Screw, Chin Strap Assembly	6 <i>Loctite® 248</i>	0.67 <i>Loctite® 248</i>

1.1.6 KM 47 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
9	550-372	Regulator Mount Nut	80 Christo-Lube® or equivalent on regulator threads	9 Christo-Lube® or equivalent on regulator threads
14	555-167	Bent Tube Assembly, Side Block End	100	11.3
14	555-167	Bent Tube, Regulator End	40	4.5
18	530-070	Screw, Top Weight	20 RTV Sealant	2.25 RTV Sealant
20	530-070	Screw, Handle	35	4
20	530-070	Screw, Port Weight	20 RTV Sealant	2.25 RTV Sealant
23	530-078	Screw, Top Weight	20 RTV Sealant	2.25 RTV Sealant
26	530-078	Screw, Top Weight (Outer)	20 RTV Sealant	2.25 RTV Sealant
30	530-045	Screw, Handle	12	1.3
32	530-050	Screw, Side Block	20	2.25
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	20	2.25
41	530-052	Screw, Port Retainer Plug	20	2.25
42	530-035	Screw, Port Retainer	12	1.3
43	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
46	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
51	530-015	Screw, Pull Pin	<i>Apply Loctite® 222/248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
55	530-045	Screw, Whisker, Kidney Plate	12	1.3
57	530-032	Screw, Tongue Catch Spring	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
58	530-059	Screw, Front Standoff	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>

1.1.6 KM 47 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
63	530-035	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
68	530-045	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
76	550-113	Screw, Neck Pad	<i>Snug—to no movement of pad</i>	
88	530-018	Screw, Earphone Retainer	16	1.8
91	530-031	Screw, Chin Strap	14	1.5

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	2.25 RTV Sealant
12	530-032	Screw, Water Dump Body	6 RTV Sealant	0.67 RTV Sealant
13	530-070	Screw, Top Weight (Handle)	20	2.25
13	530-070	Screw, Port Weight	20 RTV Sealant	2.25 RTV Sealant
16	530-078	Screw, Top Weight	20 RTV Sealant	2.25 RTV Sealant
19	530-078	Screw, Top Weight (Outer)	20 RTV Sealant	2.25 RTV Sealant
23	530-045	Screw, Handle	12	1.3
25	530-050	Screw, Side Block	20	2.25
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	30	3.38
34	530-052	Screw, Port Retainer Plug	20	2.25
35	530-035	Screw, Port Retainer	12	1.3
36	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
39	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
44	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 222/248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
45	530-032	Screw, Swing Catch Spring	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>

1.1.7 KM 57 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque Newton Meters
51	530-019	Screw, Quad Exhaust Cover	12	1.3
66	530-045	Screw, Whisker Kidney Plate	12	1.3
71	530-035	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
76	530-045	Screw, Tongue Catch	20 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
84	530-064	Screw, Neck Pad	<i>Snug—to no movement of pad</i>	
99	550-081	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
103	530-018	Screw, Earphone Retainer	16	1.8
106	530-031	Screw, Chin Strap	14	1.5

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 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
8	530-078	Screw, Handle Grip	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
15	530-059	Screw, Handle Front	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
19	530-083	Screw, Side Block	20	2.25
23	530-317	Nut, Air Train Assembly	35	4
25	530-059	Screw, Port Retainer	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
26	550-566	Adapter, Port Retainer Plug	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
27	530-052	Screw, Port Retainer Plug	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
28	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
31	550-577	Nose Block Guide	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
42	550-372	Regulator Mount Nut	80 Christo-Lube® or equivalent on regulator threads	9 Christo-Lube® or equivalent on regulator threads
56	530-070	Screw, Whisker Kidney Plate/ Anode	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>

59	530-032	Screw, Tongue Catch Spring	12 <i>Loctite® 248</i>	1.3 <i>Loctite® 248</i>
60	530-035	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
67	530-045	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
75	530-037	Screw, Earphone Retainer	10 <i>Loctite® 248</i>	1.1 <i>Loctite® 248</i>
75	530-037	Screw, Snap Tab	10 <i>Loctite® 248</i>	1.13 <i>Loctite® 248</i>
79	530-059	Screw, Front Standoff	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
82	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
91	555-167	Bent Tube, Side Block End	100	11.3
not numbered	530-037	Screw, Chin Strap Assembly	6 <i>Loctite® 248</i>	0.67 <i>Loctite® 248</i>

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 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
8	530-078	Screw, Handle Grip	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
15	530-059	Screw, Handle Front	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
19	530-083	Screw, Side Block	20	2.25
23	530-317	Nut, Air Train Assembly	35	4
25	530-059	Screw, Port Retainer	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
26	550-566	Adapter, Port Retainer Plug	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
27	530-052	Screw, Port Retainer Plug	15	1.7
28	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
31	550-577	Nose Block Guide	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
36	550-081	Regulator Mount Nut	75 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
63	530-070	Screw, Anode	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>

1.1.9 KM 97 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
73	530-032	Screw, Tongue Catch Spring	12 <i>Loctite® 248</i>	1.3 <i>Loctite® 248</i>
74	530-035	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
81	530-045	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
93	530-059	Screw, Front Standoff	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
89	530-037	Screw, Earphone Retainer	10 <i>Loctite® 248</i>	1.1 <i>Loctite® 248</i>
89	530-037	Screw, Snap Tab	10 <i>Loctite® 248</i>	1.13 <i>Loctite® 248</i>
96	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
105	555-154	Bent Tube, Side Block End	75	8.5
not numbered	530-037	Screw, Chin Strap Assembly	6 <i>Loctite® 248</i>	0.67 <i>Loctite® 248</i>

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 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
11	530-078	Screw, Handle Grip	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
18	530-059	Screw, Handle Front	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
23	530-059	Screw, Port Retainer	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
24	550-566	Adapter, Port Retainer Plug	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
25	530-052	Screw, Port Retainer Plug	15	1.7
29	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
32	550-577	Nose Block Guide	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
35	530-074	Screw, SBV	30 <i>Loctite® 248</i>	3.38 <i>Loctite® 248</i>
38	530-059	Screw, SBV Bracket	20 <i>Loctite® 248</i>	2.26 <i>Loctite® 248</i>

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
41	530-076	Screw, SBV Bracket	30 <i>Loctite® 248</i>	3.38 <i>Loctite® 248</i>
45	530-317	Nut, Air Train Assembly	35	4
46	530-083	Screw, Side Block	20	2.25
50	530-032	Screw, Tongue Catch Spring	12 <i>Loctite® 248</i>	1.3 <i>Loctite® 248</i>
52	530-059	Screw, Front Standoff	15 <i>Loctite® 248</i>	1.7 <i>Loctite® 248</i>
89	550-050	Jam Nut	40	4.5
92	530-059	Screw, Pod Mounting (Inside)	30	3.38
94	530-035	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
99	530-045	Screw, Tongue Catch	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>
102	530-037	Screw, Earphone Retainer	10 <i>Loctite® 248</i>	1.1 <i>Loctite® 248</i>
102	530-037	Screw, Snap Tab	10 <i>Loctite® 248</i>	1.13 <i>Loctite® 248</i>
123	530-015	Screw, Pull Pin Assembly	<i>Apply Loctite® 248 to the threads and install the screw until the head is bottomed out, just snug.</i>	
137	555-074	Bent Tube, Side Block End	100	11.3
not numbered	530-037	Screw, Chin Strap Assembly	6 <i>Loctite® 248</i>	0.67 <i>Loctite® 248</i>

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	1.3
28	550-074	Bishop Pin	20	2.26

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	6.78

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	20	2.26
22	530-309	Cap Screw	20	2.26
23	550-618	Adapter Outlet	60	6.78

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	6.78
88	550-533	Bent Tube Adapter	60	6.78

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 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
11 <i>See note 2</i>	530-097	Screw, Band Adjustment, Bronze	26 <i>See note 2</i>	2.94 <i>See note 2</i>
15	530-060	Comfort Insert Screw	6	0.68
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	2.25
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	2.25
34	530-073	Screw, Band Keeper	12	1.3
37	530-035	Screw, Port Retainer	12	1.3
38	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
41	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
42	530-045	Screw, Whisker Kidney Plate	12	1.3
60	530-035	Screw, Water Dump	6 RTV Sealant	0.67 RTV Sealant

1.2.1 KMB 18 Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
62	555-154	Bent Tube Assembly, 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 Christo-Lube® or equivalent on regulator threads	8.5 Christo-Lube® or equivalent on regulator threads
11 <i>See note 2</i>	530-097	Screw, Band Adjustment, Bronze	26 <i>See note 2</i>	2.94 <i>See note 2</i>
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	2.25
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	2.25
32	530-073	Screw, Band Keeper	12	1.3
35	530-035	Screw, Port Retainer	12	1.3
36	550-062	Knob, Nose Block	<i>Tighten to bottom out</i>	
39	550-116	Nose Block Guide	15 <i>Loctite® 222/248</i>	1.7 <i>Loctite® 222/248</i>
40	530-045	Screw, Whisker Kidney Plate	12	1.3
58	555-154	Bent Tube Assembly, Side Block End	75	8.5

1.3 Surface Supplied MOD-1 Torque Tables**1.3.1 Surface Supplied Pod**

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
16	805-250	Main Tube Hex	12	1.3
18	230-017	Adjustment Knob Screw	Tighten until the screw head is just below knob surface	
19	830-076	Screw	25	2.8
21	530-070	Screw	25	2.8
30	830-046	Screw	20	2.25
31	830-078	Screw	25	2.8
33	530-070	Screw	25	2.8

1.3.1 Surface Supplied Pod

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
37	850-129	Banjo Tube	28	3.16
41	850-124	Cap	30	3.38
42	830-073	Mount Screw Long	15	1.7
44	830-041	Mount Screw	15	1.7

1.3.2 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

1.3.3 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	2.25

1.3.4 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

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	2.25
18	550-178	Stud	20 <i>Loctite® 248</i>	2.25 <i>Loctite® 248</i>

1.4.1 Side Block Torque Table (Stainless Steel)

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
24	550-568	Bonnet, Steady Flow Valve	100	11.3
29	550-564	Side Block Bent Tube Adapter	100 <i>Loctite® 248</i>	11.3 <i>Loctite® 248</i>
31	550-095	L.P. Plug, w/O-ring	20	2.25
38	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 <i>Loctite® 222/248</i>	2.25 <i>Loctite® 222/248</i>
18	550-020	Bonnet, Steady Flow Valve	100	11.3
23	550-095	L.P. Plug, w/O-ring	20	2.25
25	550-140	Emergency Valve Body	See Note 1	See Note 1
29	550-091	Packing Nut	45 after seating	5.08 after seating

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 after seating	4.52 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 after seating	4.5 after seating
23	530-030	Screw, Regulator Clamp	12	1.3
32	530-020	Screw, Exhaust Flange	10 <i>Loctite® 222/248</i>	1.13 <i>Loctite® 222/248</i>

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	3.38
18	550-526	Packing Nut, 450 Regulator	30	3.3
30	530-052	Screw, 450 Regulator Cover	12	1.3

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	6.78
31	530-099	Cover Retainer Screw	18	2
35	550-533	Bent Tube Adapter	60	6.78

1.5.5 455 Balanced Regulator Torque Table

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
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	<i>Snug—DO NOT overtighten RTV Sealant</i>	
21	550-040	Mount Nut, Communications Gland	20	2.25
28	555-178	Packing Nut, Waterproof Connector	20	2.25

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 <i>Loctite® 222/248</i>	1.6 <i>Loctite® 222/248</i>
7	530-220	Screw, Pull Strap	14	1.6

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 <i>Loctite® 222/248</i>	2.7 <i>Loctite® 222/248</i>
7	530-024*	Screw	14	1.6
8	530-022	Screw	14 <i>Loctite® 222/248</i>	1.6 <i>Loctite® 222/248</i>
9	530-220	Screw, Pull Strap Plate	14 <i>Loctite® 222/248</i>	1.6 <i>Loctite® 222/248</i>

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 <i>Maximum</i>	5.7 <i>Maximum</i>
7	530-066	Screw	20	2.25
19	530-080	Screw, Yoke	20	2.25
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	<i>Snug—to no movement of pad</i>

1.9 Miscellaneous Torque Specifications

Loc. #	Part #	Description	Torque in Inch Pounds	Torque in Newton Meters
—	200-017	Overpressure Relief Valve	20	2.25
—	530-210	Weld Lens Mount Bolt	23	2.6
—	555-210	Restrictor Adaptor	20	2.25

1.10 Notes on Torque Specifications


NOTE

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

NOTE 2: Maximum torque, bands should have no less than an 1/8 inch even gap between the bands. On installation, a marine grade anti-seize may be used on this screw.


NOTE

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

*The screws may need adjustment after several dives.

1.11 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.