



# HOSHIZAKI AMERICA, INC.

## SERVICE BULLETIN

SB10-0005Rev6

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### Subject: Extruding Head Seal Bolts & Evaporator Bolts Torque

All extruding head mounting bolts on all auger models must be replaced with new bolts whenever the bolts are removed as the sealing material is considered a “onetime” use. The Bolt/Seal combination helps with alignment as well as providing a watertight seal. Failure to replace these bolts and to torque properly can lead to water leaks, scale buildup, extruder head and/or evaporator damage.

#### Specifications

Evaporator Size	Cutter Bolt to Auger		Evaporator to Extruding Head Bolts		Evaporator to Housing Bolts		Housing to Gear Motor Bolts	
	N*M	BOLT	N*M	BOLT	N*M	BOLT	N*M	BOLT
Ø45	10	N/A	15 <sup>ab</sup>	M8	5 <sup>c</sup>	M6	10	M6
Ø70	10	M10	7.8 <sup>ab</sup>	M6	10 <sup>c</sup>	M8	10	M6
			15 <sup>ab</sup>	M8			20	M8
Ø95	13	M10	35 <sup>ab</sup>	M10	20 <sup>c</sup>	M10	20	M8

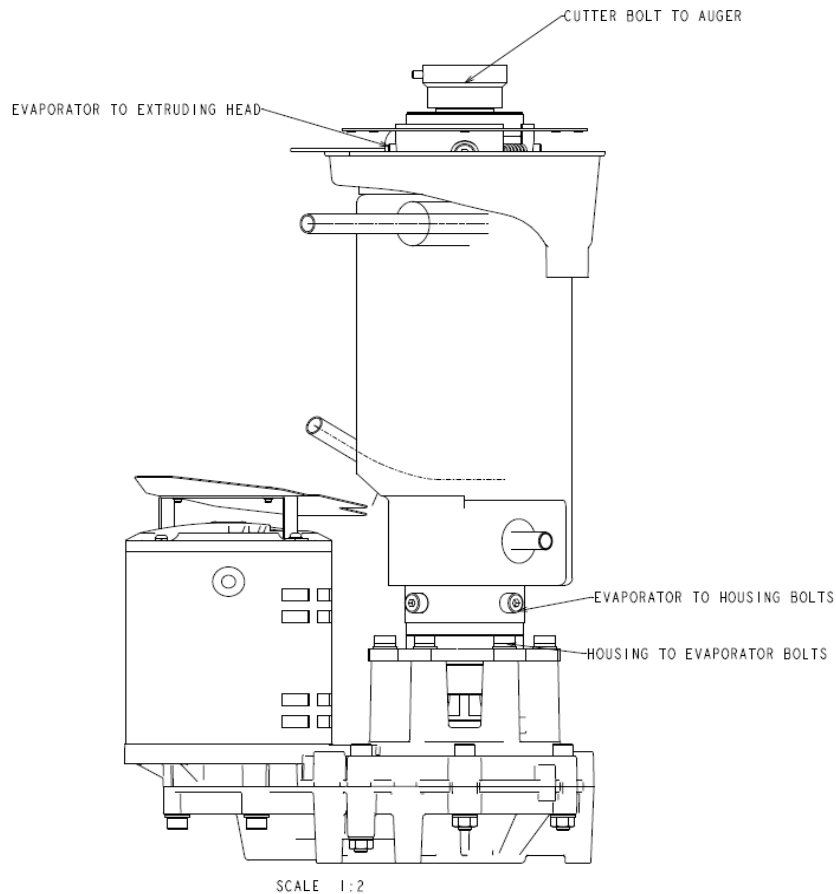
**Tolerance:** 0-35Nm, +2/0                      35Nm and above +3/0

**Conversion:** 5Nm=3.8ftlb, 7.8Nm=5.75ftlb, 10Nm=7.4ftlb, 13Nm=9.6ftlb, 15Nm=11.1ftlb, 20Nm= 14.8ftlb, 35Nm=25.8ftlb

- <sup>a</sup> Loctite 243 (blue) must be applied to threads of extruding head bolts at time of installation unless bolt has pre-coat thread lock (Loctite 200) applied.
- <sup>b</sup> Extruding head bolts must be torqued to specified torque twice with minimum 5 seconds ~ maximum 4 hours in between applications to compensate for seal relaxation.
- <sup>c</sup> Loctite 243 (blue) must be applied to threads of bolts from evaporator to housing at time of installation unless bolt has pre-coat thread lock (Loctite 200) applied.

### Caution/ Warning:

**Failure to torque bolt to specified specification may result in catastrophic failure.**



**Auger models and proper bolt part numbers:**

Models	Part number	Evaporator Diameter
C-80/100/101B DCM-240/270/300 F-300/330/450/500B	P01768-02	Ø45
F-800/801/1000/1001/1002M FD-650/801/1001/1002M FS-1001/1022M DCM-450/500/ DT-400B H (See note below)	P01768-02	Ø70
F-1500/1501M, F-2000/2001M DCM-750/751B FS-1500/1501M	474757G02	Ø95

Note: For DT-400 series, use P1768-02 with all revisiona. However, for DT-400 units without on orange band extruding head heater, the seal should be removed from the bolt.

If you have any questions, please contact Hoshizaki Technical Support at 1-800-233-1940, or at email: [tech-support@hoshizaki.com](mailto:tech-support@hoshizaki.com)