



HOSHIZAKI AMERICA, INC.

SERVICE BULLETIN

SB10-0005R5

Issued August 30, 2010

Revised April 14, 2020

Page 1 of 2

Subject: Extruding Head Seal Bolts and Torque

The extruding head mounting bolts on all auger models must be replaced with new bolts whenever they are removed as the seal material is considered a onetime use seal. The bolt/seal combination helps with alignment, as well as providing a water seal. Failure to replace these bolts or if bolts continue to leak, scale around the extruding head and/or damage to the evaporator could occur.

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 P01768-02 with all revisions. However for DT-400 units without an orange band extruding head heater, the seal should be removed from the bolt.

Hoshizaki recommends that you stock at least 4 each of these parts on your service truck if you service auger type units. If new seal bolts are not immediately available you should coat the seal material with non-corrosive, Dow Corning food grade silicone #748 as a temporary sealing measure and tighten them to the torque spec provided on page two of this bulletin.

Seal bolts supplied on all units and for service parts after October 2012 will be pre-coated with thread sealant. If your bolt does not have thread sealant, Loctite 243 must be applied to bolt threads at the time of installation. Also, inspection of all bolts is part of the annual maintenance inspection as recommended in the instruction manual supplied with the unit. Seal bolts should always be checked for leaks and tightened or replaced as necessary to the torque spec attached.

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Page 2 of 2

Bolt Torque Specifications below in FT LB and N/M:

Evap size	Cutter bolt to auger			Evaporator to extruding. head bolts*			Evaporator to housing bolts**			Housing to gear motor		
	Bolt	FT LB	N/M	Bolt	FT LB	N/M	Bolt	FT LB	N/M	Bolt	FT LB	N/M
Ø45	N/A	7.4	10	M8	11.1	15	M6	3.8	5	M6	7.4	10
Ø70	M10	7.4	10	M8	11.1	15	M8	7.4	10	M6	7.4	10
										M8	14.8	20
Ø950	M10	9.62	13	M10	25.8	35	M10	14.8	20	M10	14.8	20

Conversion to kg/cm: 1 FT LB =13.8kg/cm

*Extruding head bolts must be torqued twice, to the torque spec listed above. This should be done with at least 2 minutes in between to compensate for seal relaxation.

**Loctite 243 (blue) must be applied to the threads of bolts from evaporator to housing at time of installation

If you have any questions, please contact Hoshizaki Technical Support at tech-support@hoshizaki.com or 1-800-233-1940.