

Action code: AT FIRST OPPORTUNITY

Hydraulic tightening pressure for connecting rodSL2019-680/JNN
August 2019**Concerns**Owners and operators of
MAN four-stroke diesel engines.

Type:

L23/30 series, GenSet

Attachment:

Description 500.40 (57)

Dear Sir or Madam

We introduced the elongation measurement for all hydraulically tightened bolts in our Service Letter SL2018-656. The aim was to increase the safety level for the bolts tightened by the hydraulic tool.

From the service feedback received, we have noted that the change of connecting rod tightening pressure from 700 to 750 bar, introduced in 2005 for the L23/30 series engine, has not been introduced by all owners / operators.

By this Service Letter we would like to clarify that the 750 +0/-30 bar tightening pressure is valid for all hydraulically tightened connecting rods for the L23/30 and L23/30H (DF) engines.

The introduced 30 bar tolerance allows the tightening pressure to be within 720 – 750 bar.

The increased tightening force only increases the safety margin of the bolt connection and does not jeopardize the design in any way.


The increase from 700 bar to 750 +0/-30 bar should be introduced in addition to assembly of the connecting rod during a major overhaul.

Correct marking of the hydraulic tool must be carried out. The hydraulic tool is currently marked with “working pressure 700 bar”, which must be re-marked to “working pressure 750 bar”.

Note: The tool can be used safely with the higher pressure, and the tool will work as regards function and operation.

In order to ensure that the instruction manual is updated, we kindly ask you to replace the page ‘Data for Tightening Torque’ with the enclosed page.

Yours faithfully


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