



BOLT TIGHTENING PROCEDURE

FOR TTMA FLANGES

Correct bolt tightening is essential to ensure a safe, leak-free and reliable flange connection. Follow the procedure below for optimal performance.



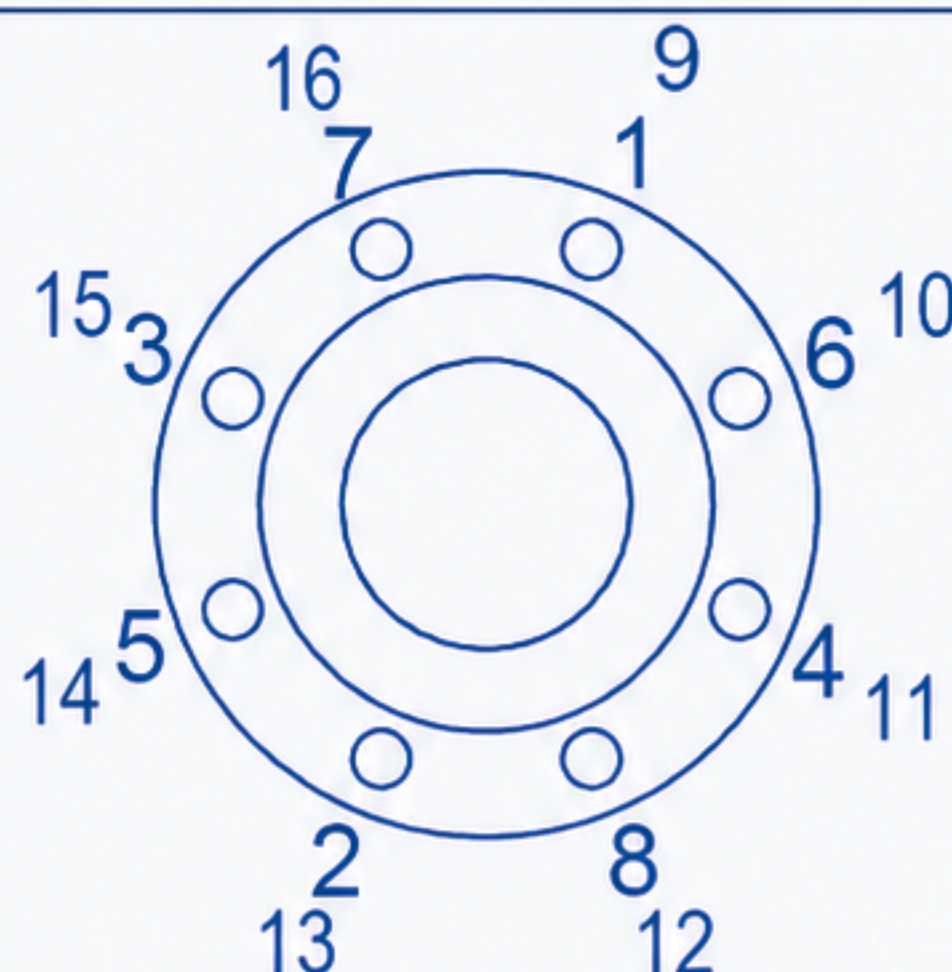
1. LUBRICATE

Lubricate the threads and the contact surface of the bolt and nut with an appropriate lubricant.



2. USE CORRECT TOOLS

Use a calibrated torque wrench or tensioning device to achieve the correct level of bolt tension.



BOLT TIGHTENING PATTERN

5/8" B7 STUDS - 100Nm
M10 CLASS 8.8 BOLTS;
STEEL FLANGES - 44Nm
ALUM FLANGES - 35Nm

TIGHTENING SEQUENCE

1

FIRST ROUND



30% OF FINAL TORQUE
(flange sequential order)

2

SECOND ROUND



60% OF FINAL TORQUE
(flange sequential order)

3

THIRD ROUND



100% OF FINAL TORQUE
(flange sequential order)

4

FINAL PASS



ONE FINAL TIME
clockwise or counter-clockwise
sequentially around the flange.

