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tightening procedure flange joints are torqued tight with the help of a torque wrench manual or hydraulic the clamp load produced during tightening is higher than 75 of the fastener s proof load

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web easy handling bolt numbering shall

be done clockwise around the flange with the following sequence the table below shows the torque sequence for flanges with 4 to 32 bolts number of bolt studbolt tightening sequence to follow

4 bolt flange 1 3 2 4  
8 bolt flange 1 5 3 7 2 6 4 8  
12 bolt flange 1 5 3 7 2 6 4 8 12  
16 bolt flange 1 5 3 7 2 6 4 8 12 16

### **bolt tightening sequence**

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web for flanges with 12 or more bolts 1 st round 20 percent of final torque 2 nd round 40 percent of final torque 3 rd round 80 percent of final torque 4 th round 100 percent of final torque final round clockwise or counter clockwise around the flange please take note the above bolt tightening sequences are the most

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web ensure the bolt lengths allow for a minimum of 2 3 threads protruding beyond the top of the nut when tightened bolts must be tightened according to the below sequence options assemble bolts hand tight maximum 30 of final tightening torque as per below cross pattern sequences

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web step 1 liberally lubricate all load bearing surfaces including threads and flat washers then install and finger tighten all fasteners number the bolts flange according to the bolt torque

sequence step 2 set the torque wrench to 1 3 of the target torque value and tighten in an order bolts 1 2 3 4 until all have been tightened

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flange joint securely it is essential to control the stress variation in the flange joint components in the case of the gasket this needs to be compressed evenly across the flange face if you were to tighten adjacent bolts when those opposite remain loose the result will be

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