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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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web dec 17 2020 bolt tightening sequence why it matters to complete a 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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web jan 10 2016 twelve bolt tightening sequence sequential order 1 2 3 4 5 6 7 8 9 10 11 12 rotation order 1 5 9 3 7 11 2 6 10 4 8 12 sixteen bolt tightening sequence sequential order 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 rotation order 1 9 5 13 3 11 7 15 2 10 6 14 4 12 8 16 twenty bolt tightening sequence

**flange bolt tightening sequence chart new line** - Jul 01 2022

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