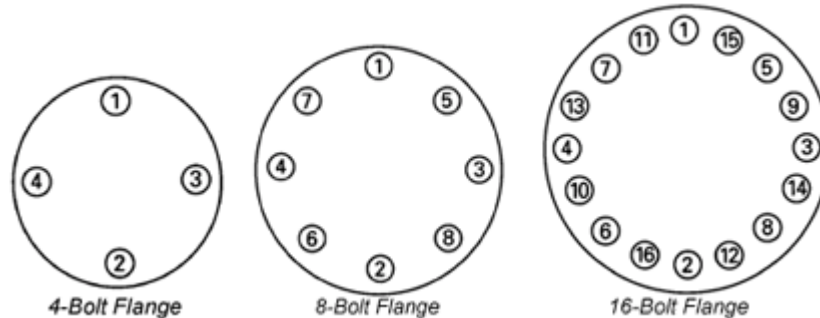


Bolting Procedures



- Place the gasket on the flange surface to be sealed.
- Bring the opposing flange into contact with the gasket.
- Clean the bolts and lubricate them with a quality lubricant, such as an oil and graphite mixture.
- Place the bolts into the bolt holes.
- Finger-tighten the nuts.
- Follow the bolting sequence in the diagrams above.
- During the initial tightening sequence, do not tighten any bolts more than 30% of the recommended bolt stress. Doing so will cause cocking of the flange and the gasket will be crushed.
- Upon reaching the recommended torque requirements, do a clockwise bolt-to-bolt torque check to make certain that the bolts have been stressed evenly.
- Due to creep and stress relaxation, it is essential to pre-stress the bolts to ensure adequate stress load during operation.