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AN Whitehead

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torque in ft lb k dimensionless nut factor or tightening factor f axial force in pounds d nominal bolt diameter in inches in the metric system torque applied t k d f 1000 where t torque in n m f bolt load in n

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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 13248 bolt flange 1537264812 bolt flange 17410285113961216 bolt

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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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