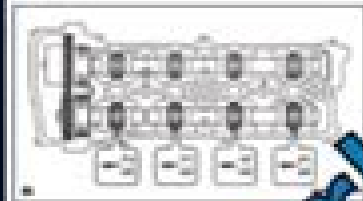
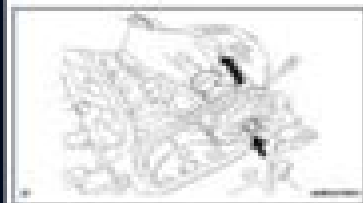
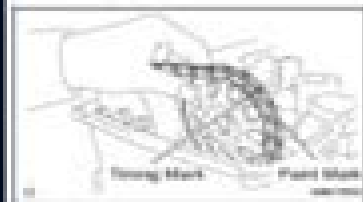
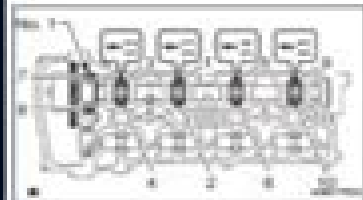


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- (b) Using several steps, uniformly tighten the 10 bearing cap bolts in the sequence shown in the illustration.  
Torque: 25.5 N·m (201 kgf·cm, 22 ft·lb) for No. 1 bearing cap  
9.8 N·m (82 kgf·cm, 80 in·lb) for No. 3 bearing cap

## 16. INSTALL NO. 2 CAMSHAFT

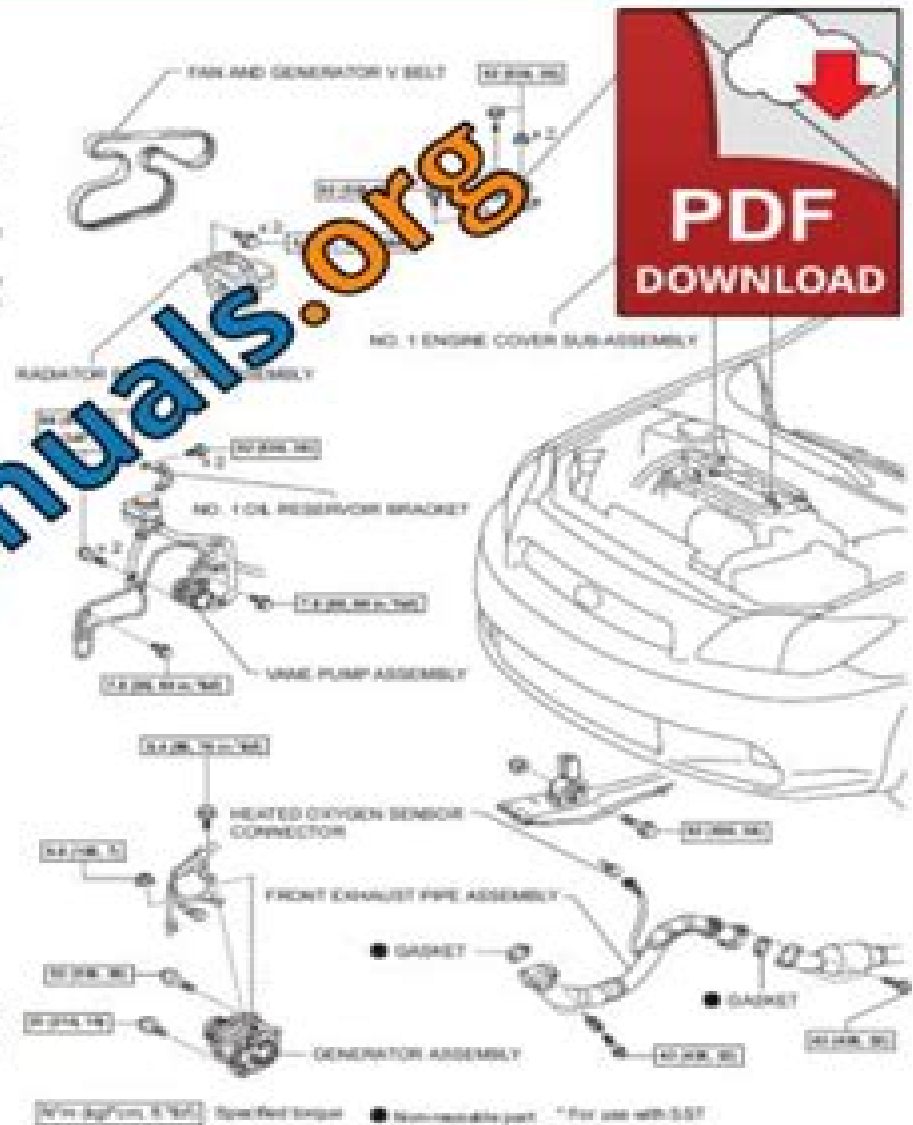
- (a) Apply a light coat of engine oil to the journal portion of the No. 2 camshaft.  
(b) Put the No. 2 camshaft on the cylinder head with the paint mark of the chain aligned with the timing mark in the camshaft timing sprocket.

- (c) While holding the No. 2 camshaft by hand, temporarily tighten the camshaft timing bolt.

- (d) Examine the timing mark and numbers and check that the camshaft is installed as the illustration. Then turn the crankshaft clockwise until the timing mark on the crankshaft is aligned with the timing mark on the cylinder head.

- (e) Turn the crankshaft clockwise until the timing mark on the crankshaft is aligned with the timing mark on the cylinder head.

- (f) Using several steps, uniformly tighten the 10 bearing cap bolts in the sequence shown in the illustration.  
Torque: 25.5 N·m (201 kgf·cm, 22 ft·lb) for No. 1 bearing cap  
9.8 N·m (82 kgf·cm, 80 in·lb) for No. 3 bearing cap



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web bolt torque is calculated for a flanged assembly using the following equation applied torque  $T_k = F_d \cdot 12$  in FPS unit where  $T$  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  $T_k = F_d \cdot 1000$  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 1 3 2 4 8 bolt flange 1 5 3 7 2 6 4 8 12 bolt flange 1 7 4 10 2 8 5 11 3 9 6 12 16 bolt

**bolt tightening sequence procedures maxpro corp** - Mar 09 2023

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

**bolt tightening sequence recommendations and restrictions** - Aug 14 2023

web jan 27 2021 the gasket type and arrangement of the flange connection are both critical to choosing which tightening sequence an assembler can use this article which is intended for supervisors engineers or anyone else who oversees bolted flange assembly or maintenance will discuss different torque sequences

**flange bolt torque sequence and torque table a complete bolt** - Oct 16 2023

web number of bolt stud bolt 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 7 4 10 2 8 5 11 3 9 6 12 16 bolt flange 1 9 5 13 3 11 7 15 2 10 6 14 4 12 8 16 20 bolt flange 1 11 6 16 3 13 8 18 5 15 10 20 2 12 7 17 4 14 9 19 24 bolt flange

**bolt tightening sequence albion valves** - Feb 08 2023

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

**tightening sequence inerteck** - Jul 13 2023

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

[hytorc flange pattern calculator](#) - Apr 10 2023

web welcome to this interactive flange bolting calculator from hytorc the program computes recommended torque values bolting patterns tool selection and pump pressure settings for standard asme b16 5 and api 6a flanges under normal assembly conditions

**flange bolt up torque tightening preload torque procedures** - Oct 04 2022

web tightening sequence the first pass lightly tighten the first bolt then move directly across or 180 degrees for the second bolt then move 1 4 turn around the circle or 90 degrees for the third bolt and directly across for the fourth continue this sequence until all bolts are tightened when tightening a four bolt flange use a criss cross

[bolt tightening sequence why it matters energpac blog](#) - Nov 05 2022

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

*bolt tightening procedure piping designer* - Jun 12 2023

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

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