

1.5 Capscrew Tightening Sequences and Torques

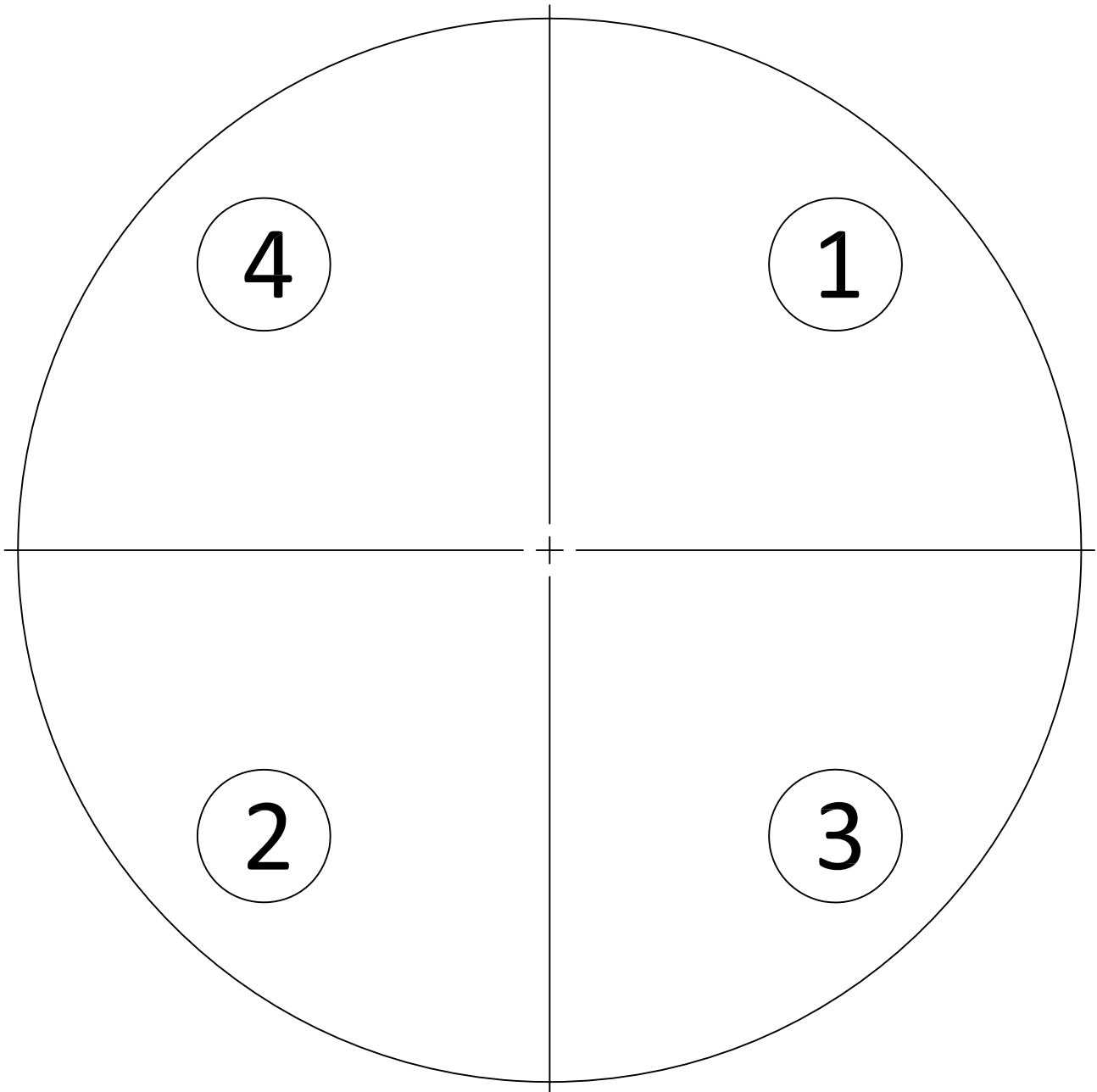
RECOMMENDED CAP SCREW TIGHTENING TORQUE		
Torque (FT. / LBS)		
	Wet (Never Seize)	Wet (Never Seize)
Screw Diameter	B7M Bolt (Black) @ 50% yield	B7 Bolt (Blue) @ 50% yield
7/16"	22	30
1/2"	27	35
5/8"	52	68
3/4"	90	118
7/8"	143	188
1"	213	279
1-1/8"	305	401
1-1/4"	421	533
1-1/2"	733	962
1-3/4"	1,169	1,534

NOTES

Torques are calculated with Never Seize and could vary depending on the amount of Never Seize
 All Bolts are Xylan Coated

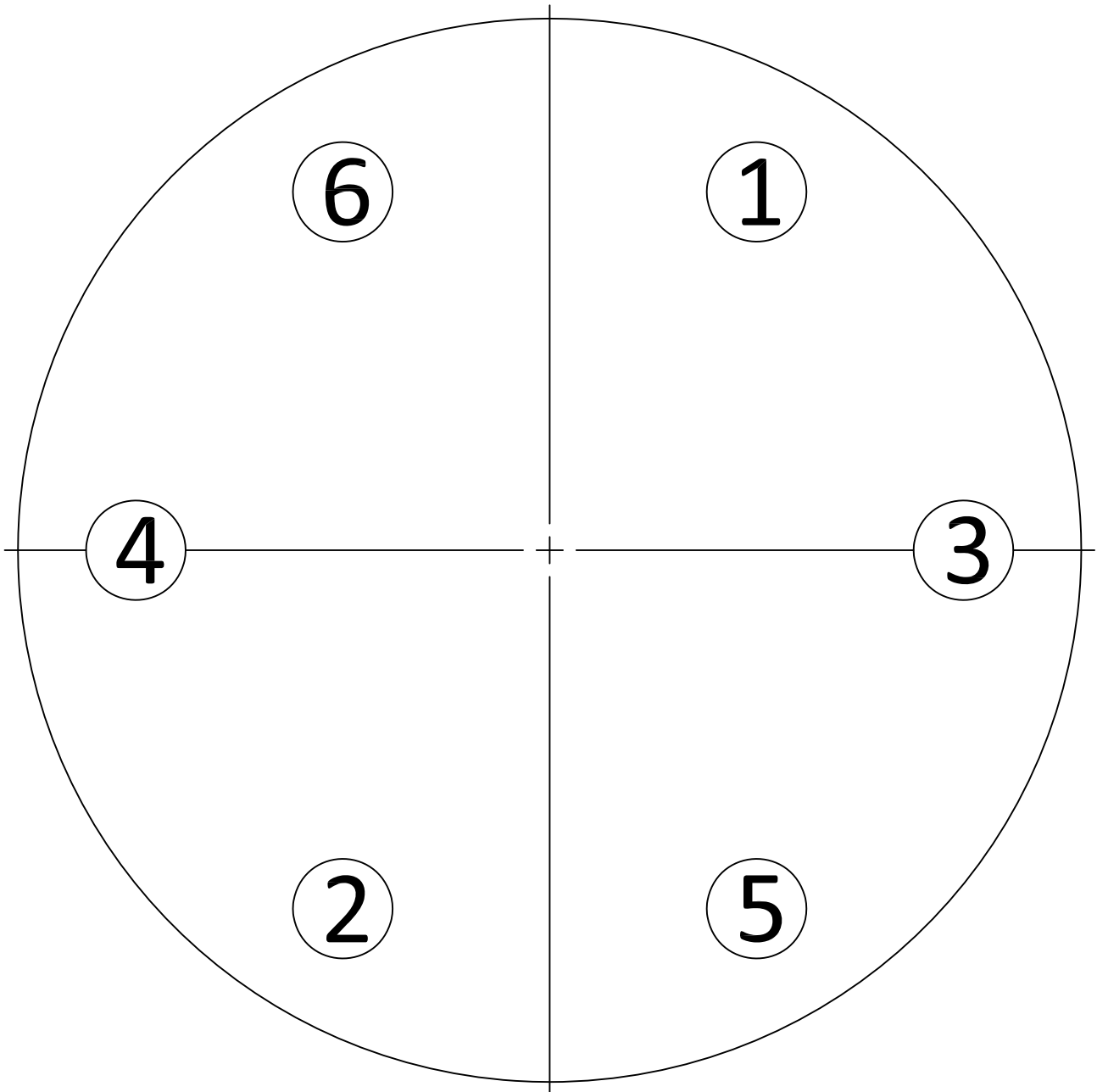
BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE

1-2-3-4



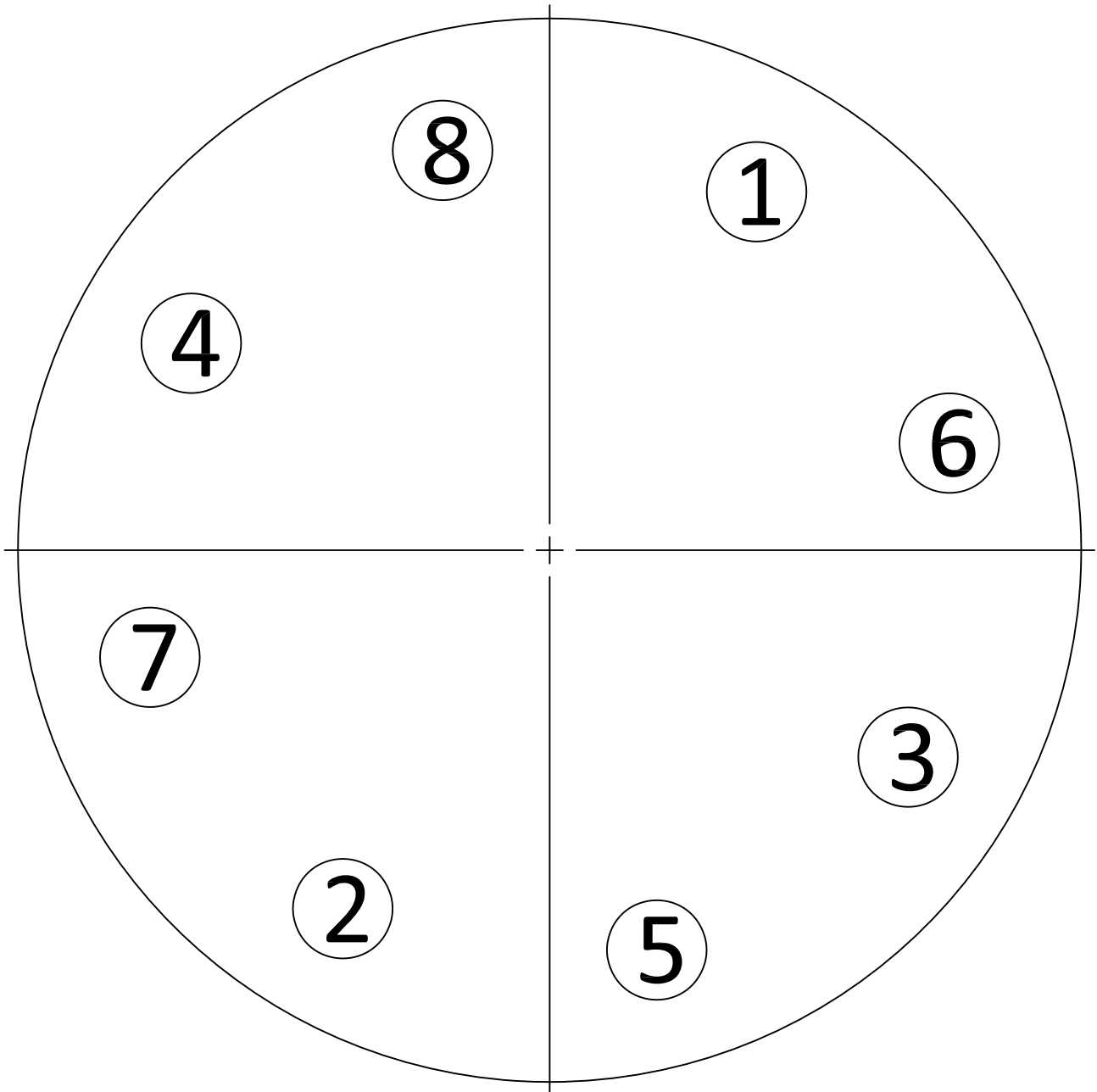
4 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE 1-2-3-4-5-6



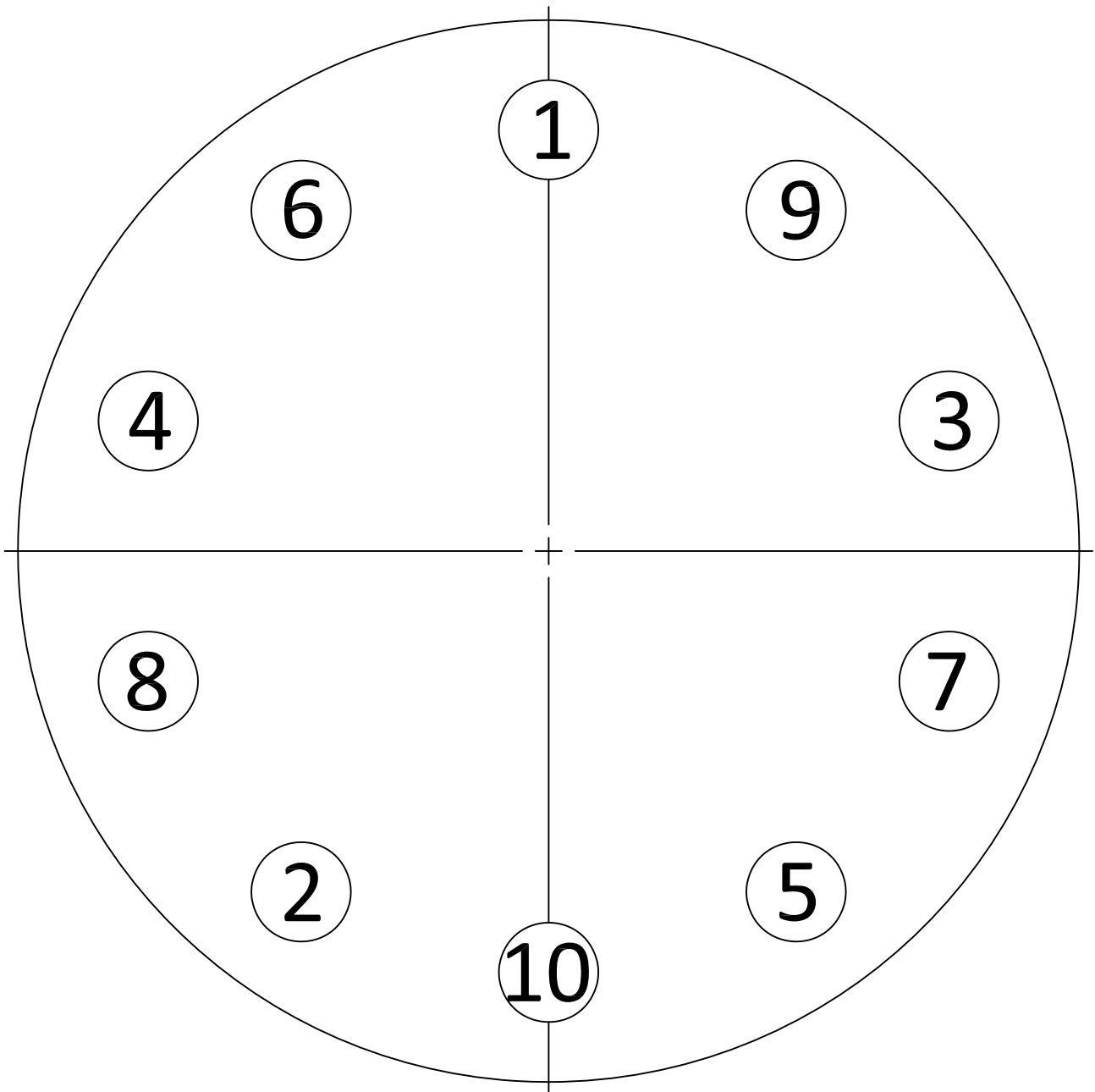
6 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE 1-2-3-4-5-6-7-8



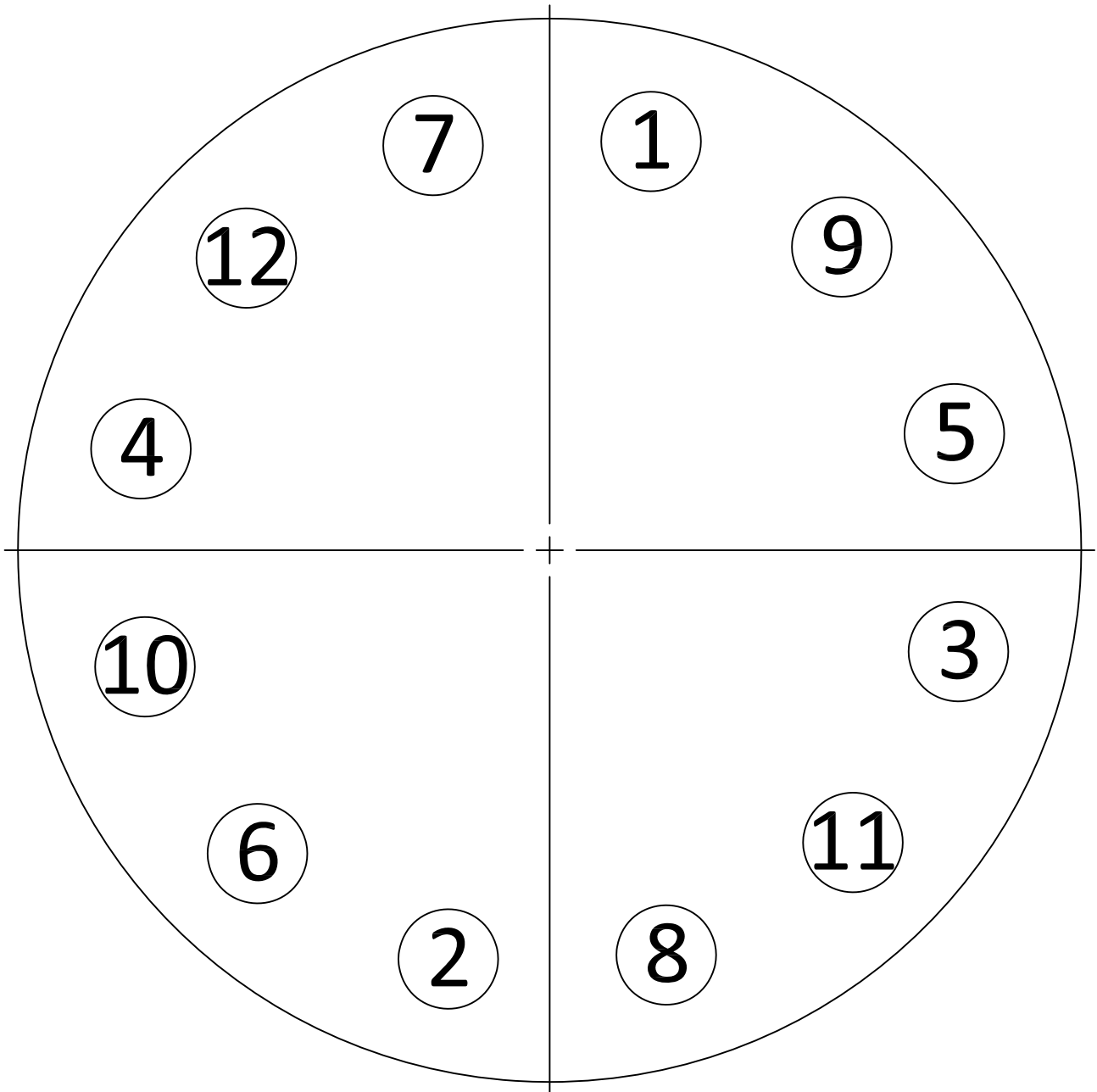
8 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE 1-2-3-4-5-6-7-8-9-10



10 - BOLT PATTERN

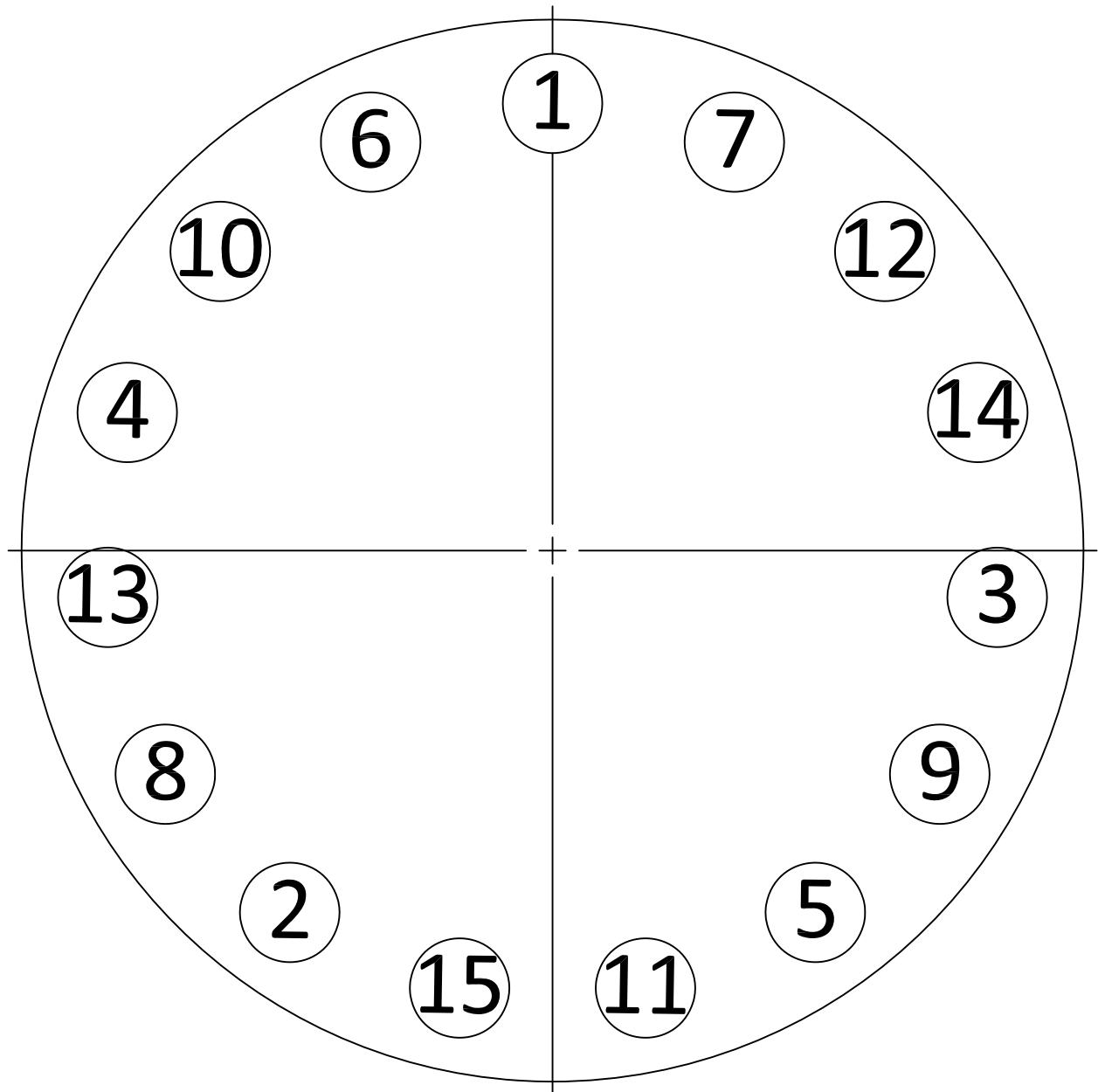
BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE 1-2-3-4-5-6-7-8-9-10-11-12



12 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE

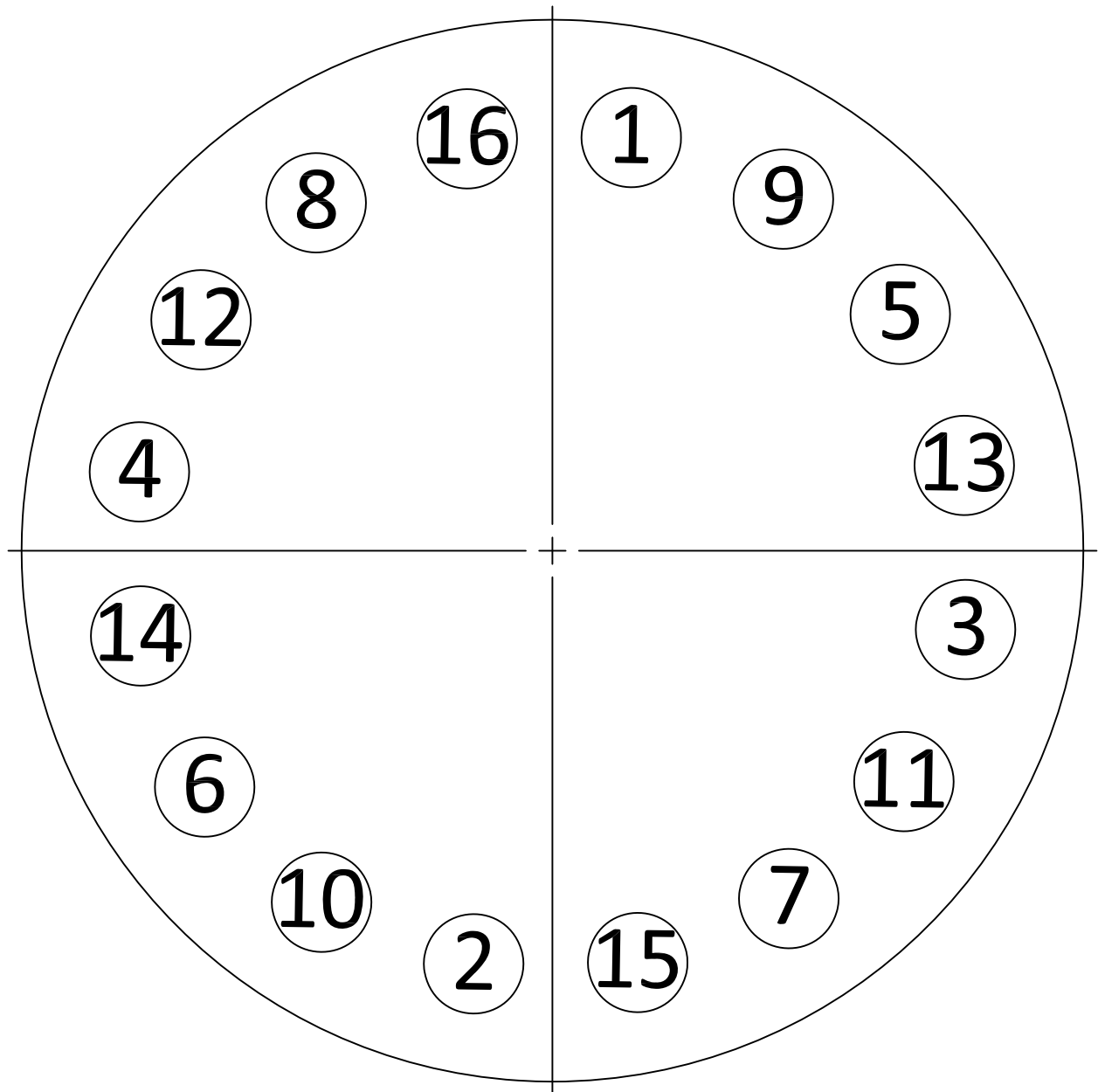
1-2-3-4-5-6-7-8-9-
10-11-12-13-14-15



15 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE

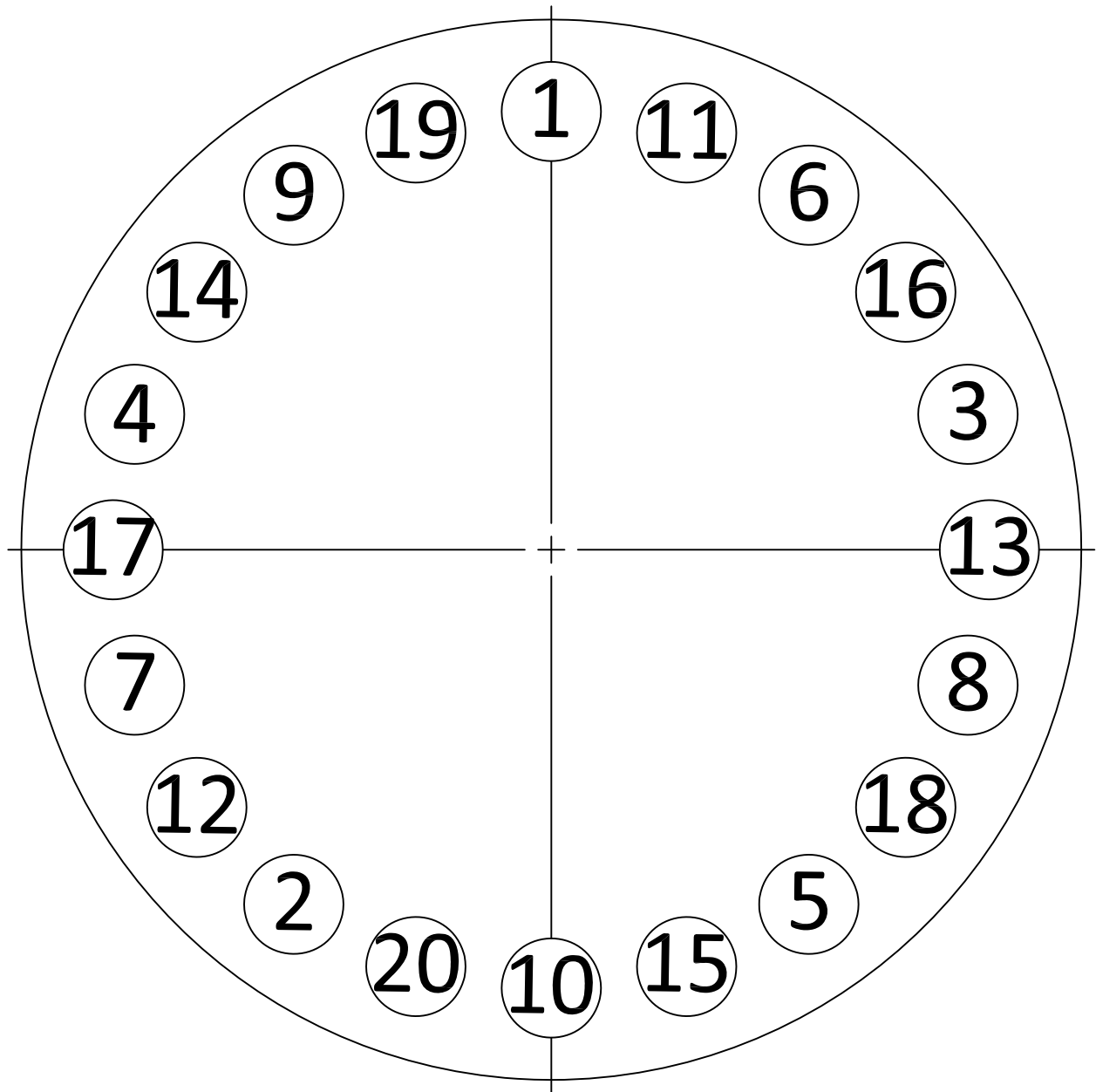
1-2-3-4-5-6-7-8-9-
10-11-12-13-14-15-16



16 - BOLT PATTERN

BOLT TIGHTENING - STAR CROSS PATTERN SEQUENCE

1-2-3-4-5-6-7-8-9-10-11-12-
13-14-15-16-17-18-19-20



20 - BOLT PATTERN