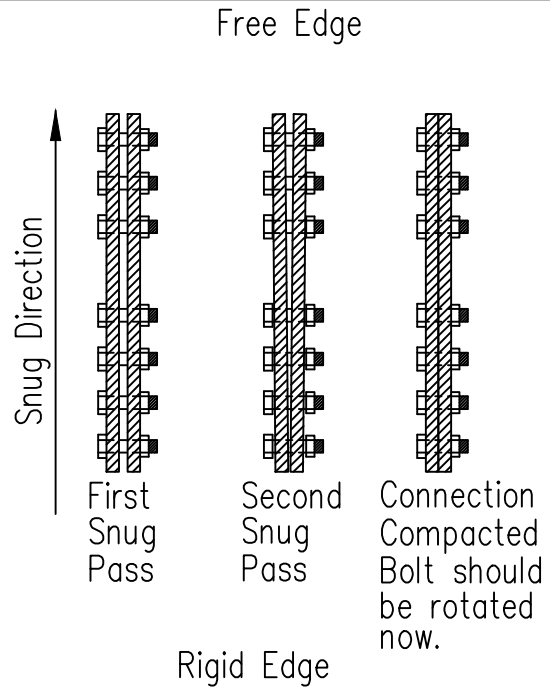


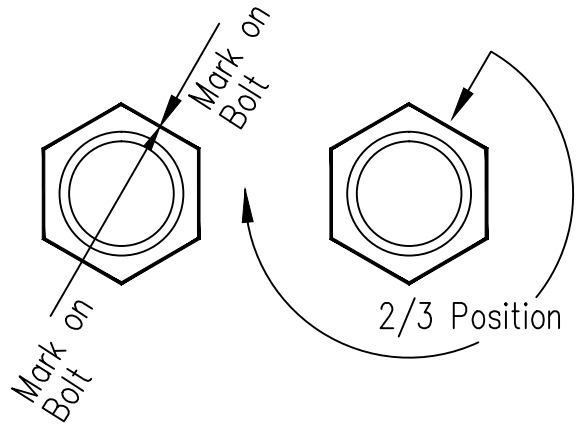
1. Install all bolts in connection.
2. Beginning at a rigid point in the connection (point with no gap), tighten each row of bolts to snug tight progressing toward the free edge(s) of the connection (edge with gap).
3. Repeat step 2 until all plies of the connection are completely pulled together with no gap present, and all bolts are snug tight.
4. Mark each bolt head or nut at its present position. Rotate bolt required amount shown in the table. Difference in mark locations will insure correct bolt tightness.



Turn-of-Nut Sequence Order

When connection is compacted and bolt is snug:

1. Mark nut and bolt location with keel or chalk.
2. Rotate nut as required per chart conditions.
3. Finished mark locations are proof that bolts have been properly tightened.



Turn-of-Nut Procedure

08/21/09

Created On: 08/21/09

NOTE: These drawings are intended to depict general installation of item(s) described above. Some item(s) may have been omitted for clarity of presentation. Consult your erection manual or additional SD-Sheets for further guidelines and/or clarifications.

DRAWING NO.

SD238B