



16 STUD EXAMPLE

NO OF STUDS	NOMINAL FLG SIZE	STUD NUT TIGHTENING SEQUENCE
8	4", 6", 8"	1, 5, 3, 7, 2, 6, 4, 8
12	10", 12"	1, 7, 4, 10, 2, 8, 5, 11, 3, 9, 6, 12
16	16"	1, 9, 5, 13, 2, 10, 6, 14, 3, 11, 7, 15, 4, 12, 8, 16
20	20"	1, 11, 6, 16, 2, 12, 7, 17, 3, 13, 8, 18, 4, 14, 9, 19, 5, 15, 10, 20

NOTES:

1. STUDS AND NUTS SHALL BE CLEAN AND DRY (UNLUBRICATED).
 - A. HAND TIGHTEN ALL NUTS.
 - B. CONSECUTIVELY NUMBER THE STUDS AROUND THE FLANGE.
2. TIGHTEN STUD NUTS TO ONE-THIRD OF TARGET TORQUE IN SEQUENCE GIVEN.
3. TIGHTEN STUD NUTS TO TWO-THIRDS OF TARGET TORQUE IN SEQUENCE GIVEN.
4. TIGHTEN STUD NUTS TO FULL TARGET TORQUE IN SEQUENCE GIVEN.
5. AFTER 24 HOURS, RE-TIGHTEN STUD NUTS TO FULL TARGET TORQUE IN SEQUENCE GIVEN.
6. TORQUE WRENCHES AND WRENCHES USED FOR STUD NUT TIGHTENING SHALL BE IN GOOD CONDITION AND CERTIFIED BY AN INDEPENDENT TESTING AGENCY WITHIN 6 MONTHS OF USE.
7. SEQUENCE GIVEN FOR AWWA C207 CLASS B, D, AND E AND ANSI CLASS 150 FLANGES.

D DENVER WATER	
STUD NUT TIGHTENING SEQUENCE	
Scale: <u> NONE </u>	Date: <u> May 2018 </u>
Drawn: <u> RLB </u>	Ck: <u> K ROSS </u>
Approved: <u> Steph C. Penn </u>	Dr. <u> 127 </u> No. <u> 35 </u>