

## TURN-OF-NUT PROCEDURE

### INSTALLATION:

- Check bolts and nuts for rust and lubrication.
- Install nut and washer with "markings up."
- Washer must be installed under the "turned" element.

### Step 1.



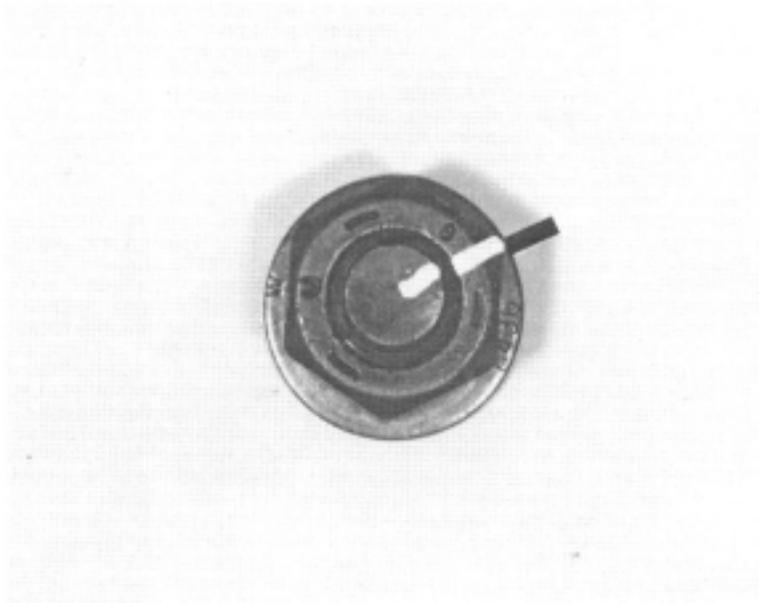
### TIGHTEN NUT TO "SNUG TIGHT" CONDITION

- This is the full effort of an average person, using a standard spud wrench.

### AND/OR

- 20 percent of the "Tension" value listed in Article 2408.39 C.1. and having all faying surfaces in tight contact.

**Step 2.**



**"Match-Mark"  
Bolt tip, Nut,  
and Base  
Steel**

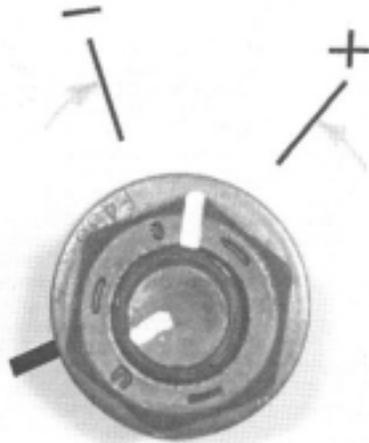
**Step 3.**



**Rotate nut  
specified  
"Turn-of-Nut"  
amount.**

**(Refer to Article  
240B.39)**

Step 4



Check for  
rotated  
Tolerance  
(Refer to Article  
2408.39)