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.

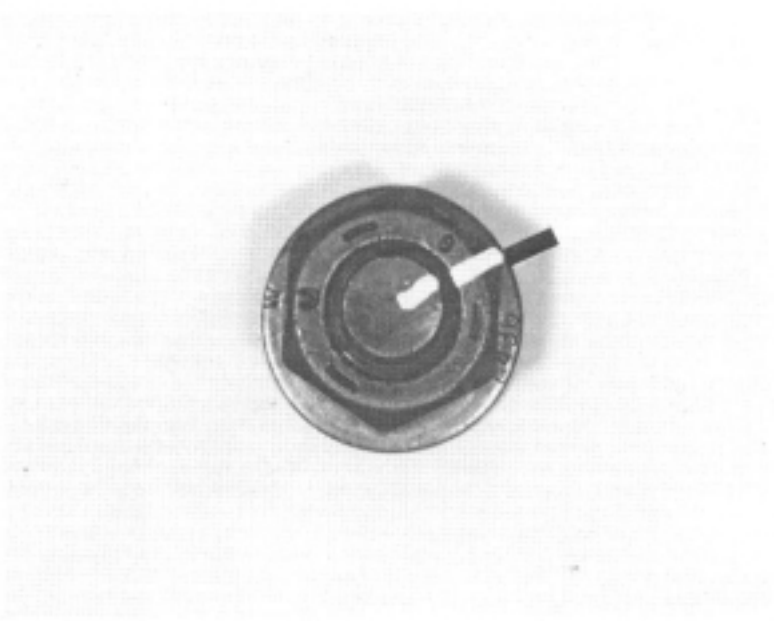
TIGHTEN NUT TO "SNUG TIGHT" CONDITION

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

AND/OR

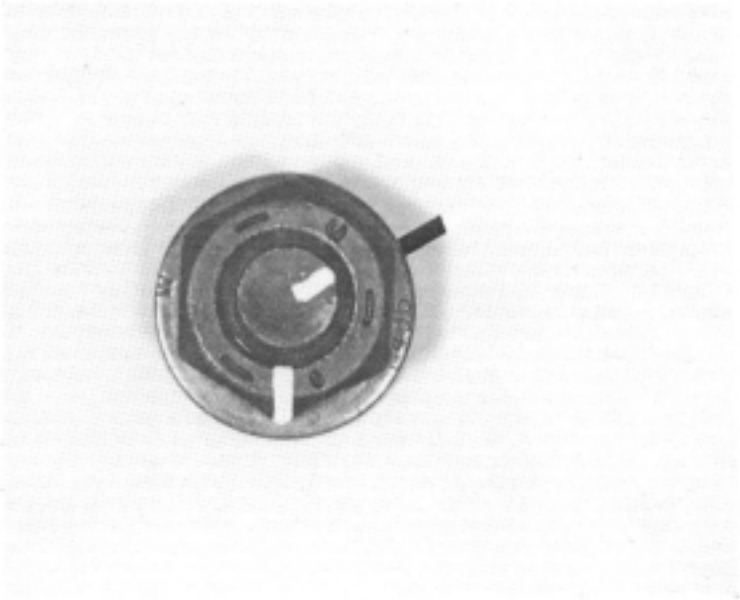
- 20 percent of the "Tension" value listed in Article 2408.39 C.1. and having all faying surfaces in tight contact.

Step 2.



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

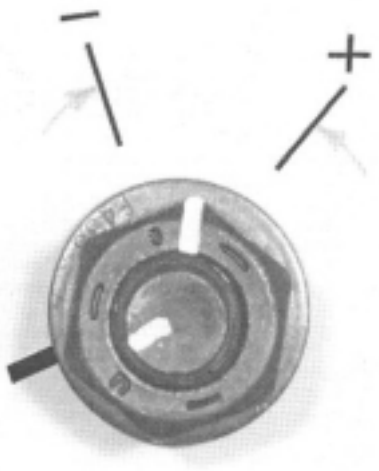
Step 3.



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

(Refer to Article 2408.39)

Step 4



Check for rotated Tolerance
(Refer to Article 2408.39)