

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.



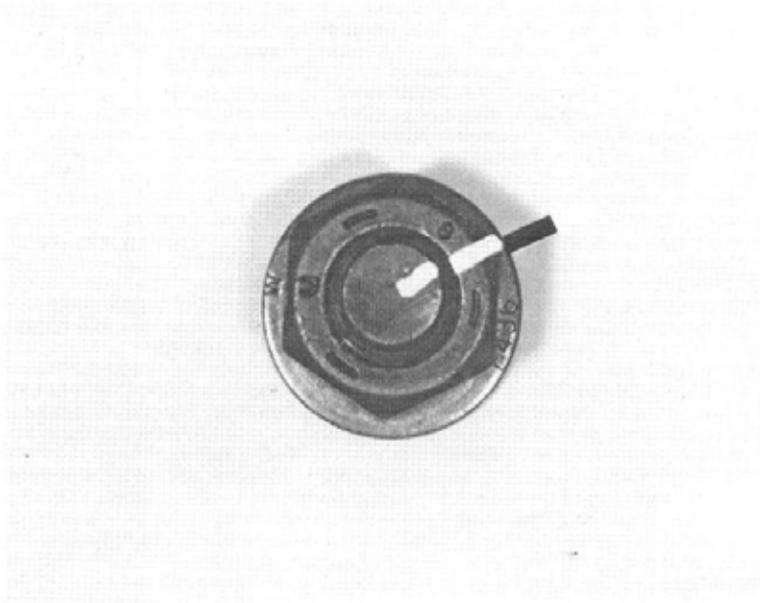
TIGHTEN NUT TO "SNUG TIGHT" CONDITION

- 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)**

