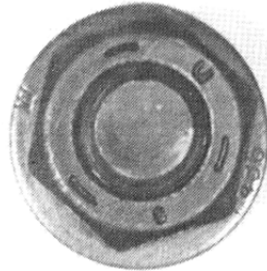


TURN-OF-NUT PROCEDURE

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.



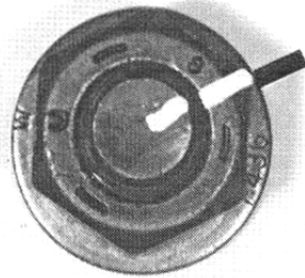
TIGHTEN NUT TO "SNUG TIGHT" CONDITION

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

AND/OR

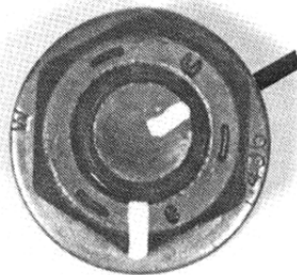
- **20 percent of the "Tension" value listed in Article 2408.03, S, 5, a, 6 and having all faying surfaces in tight contact.**

Step 2.



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

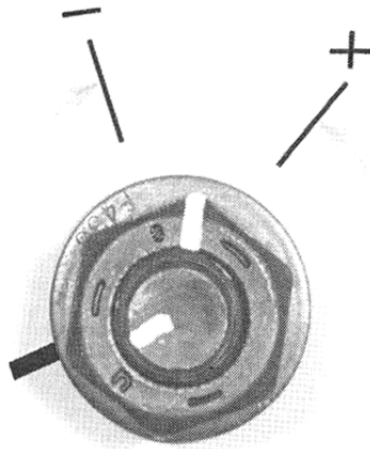
Step 3.



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

(Refer to Article
2408.03, S, 5, b, 5)

Step 4



Check for
rotated
Tolerance
(Refer to Article
2408.03, S, 5, b, 5)