

# TORQUE PROCEDURE

This document defines general requirements for assembly of flanged joints in Piping Systems where controlled tightening of stud bolt using torque measurement is mandated.

1. The bolts (or the flange) shall be numbered with the cross-bolting pattern sequence to be used. Refer to numbering specifications.
2. The bolts shall be then tightened (torqued) to the First Torque Level shown on the Flange Torquing Table, using the cross-bolting sequence marked on the flange or bolts (1/3 of the full torque).  
This sequence shall be repeated as necessary at this torque level until all the nuts cease to move when the torque is applied.
3. The bolts shall then be tightened to the Second Torque Level, using the same cross-bolting sequence (2/3 of the full torque). The sequence shall be repeated until the nuts cease to move when the torque is applied.
4. The bolt shall then be tightened to the Full Torque Level, using the same cross-bolting sequence. The sequence shall be repeated until the nuts cease to move when torque is applied.
5. Full torque shall then be applied to all the bolts in rotational order. This shall be continued until all the nuts cease to move when the torque is applied.



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