UNLESS OTHERWISE SPECIFIED, TORQUE ALL FASTENERS (EXCLUDING SWING BOLTS) TO THE FOLLOWING. TORQUE ALL FASTENERS TO SPEC. "B"

1/2"----- 20, FT.-LBS.  1-3/8"----- 420, FT.-LBS.
5/8"----- 40, FT.-LBS.  1-1/2"----- 1500, FT.-LBS.
3/4"----- 65, FT.-LBS.  1-3/4"----- 870, FT.-LBS.
7/8"----- 110, FT.-LBS.  2"----- 1300, FT.-LBS.
1"----- 150, FT.-LBS.  2-1/4"----- 1900, FT.-LBS.
1-1/4"----- 220, FT.-LBS.  2-1/2"----- 3600, FT.-LBS.
1-1/2"----- 320, FT.-LBS.

THE MAGNITUDE OF THE TIGHTENING STRESS FOR A GIVEN TORQUE VARIES CONSIDERABLY WITH THE TYPE OF LUBRICATION USED. WHENEVER THESE SPECIFICATIONS ARE USED, BOTH THE THREADS AND THE FACE OF THE NUT OR THE FACE OF THE BOLT OR CAPSCREWS MUST BE THOROUGHLY BUT LIGHTLY LUBRICATED WITH AIDON THREAD LUBE "HOLDING" UNDER NO CIRCUMSTANCES ARE THESE TORQUES TO BE USED WITH NO LUBRICATION OR WITH LUBRICANTS SUCH AS NLGI-1-LOBE, "NEVER-SEIZE", ETC.

EXCEPTION -- THE THREADS ON THE END OF THE STUD BEING INSERTED INTO A TAPPED HOLE SHOULD HAVE ONLY A VERY LIGHT FILM OF OIL.

REFERENCE DRAWINGS:
36 LB REEL ELEVATION, M3-F9-117
36 LB REEL B/M, M9N-193-444

PRINT REFERENCES
PRINT SPECIFICATIONS PER ES.OA0007/A/0
AND THEIRES STANDARD APPLICATION SPES.

STANDARD TOP COAT: F073-GB169 (BLUE BRY)

UNIT PAINT CODES:
10 NR PAINT
20 PRINT REQUIRED
26 SAFETY ORANGE PAINT REQUIRED
27 SAFETY YELLOW PAINT REQUIRED

DRAWN:
REVISED:
CHECKED:
APPROVED:

SAPRAGE PAPERBOARD INC.
VERSALIES, CT

STANA00065

CERTIFIED 18-FEB-02

STANLEY W. SHIKE