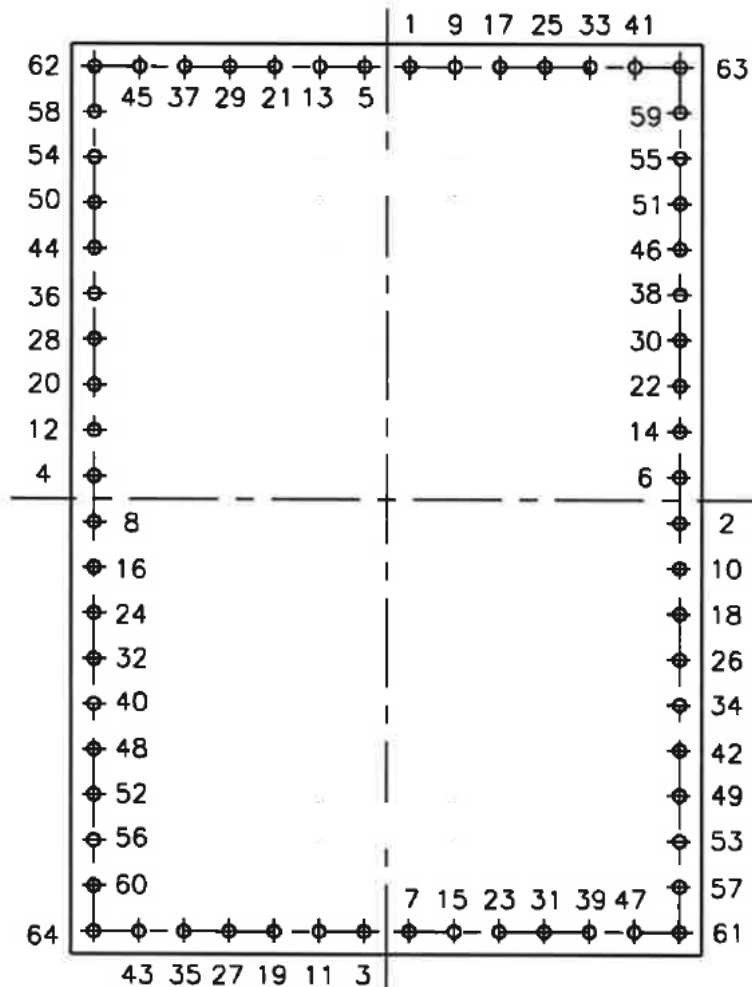


EnviroVault Bolt-In Torque Guide



NOTES:

1. ALL TORQUE VALUES ARE FOR DOORS USING NEOPRENE GASKET AND CHIME LAP.
2. ALIGN COMPONENT PARTS AND CLAMP TOGETHER WITH HOLD DOWN.
3. LUBRICATE BOLT THREADS IN AREA ON NUT ENGAGEMENT. ALSO LUBRICATE FACE OF NUTS AND BOLT HEAD USING A SUITABLE LUBRICANT.
4. INSTALL ALL BOLTS AND NUTS FINGER TIGHT.
5. NUMBER BOLTS SO THAT TORQUING REQUIREMENTS CAN BE FOLLOWED.
6. TORQUE ALL BOLTS TO 20 FT-LBS IN THE SEQUENCE INDICATED, THEN REPEAT TO 25 FT-LBS.
7. FOR ADDITIONAL SEALING, INCREASE TORQUE BY 5 FT-LB INCREMENTS AND TIGHTEN IN THE SEQUENCE INDICATED TO A MAXIMUM OF 35 FT-LBS.
8. OVER TIGHTENING MAY CAUSE GASKET FAILURE.
9. USE ROTATIONAL TIGHTENING UNTIL ALL BOLTS ARE STABLE AT FINAL TORQUE LEVEL (TWO COMPLETE TIMES AROUND IS USUALLY REQUIRED).

MAXIMUM TORQUE VALUE: 35 FT/Lbs.
(BASED ON GR. 5 BOLTING)