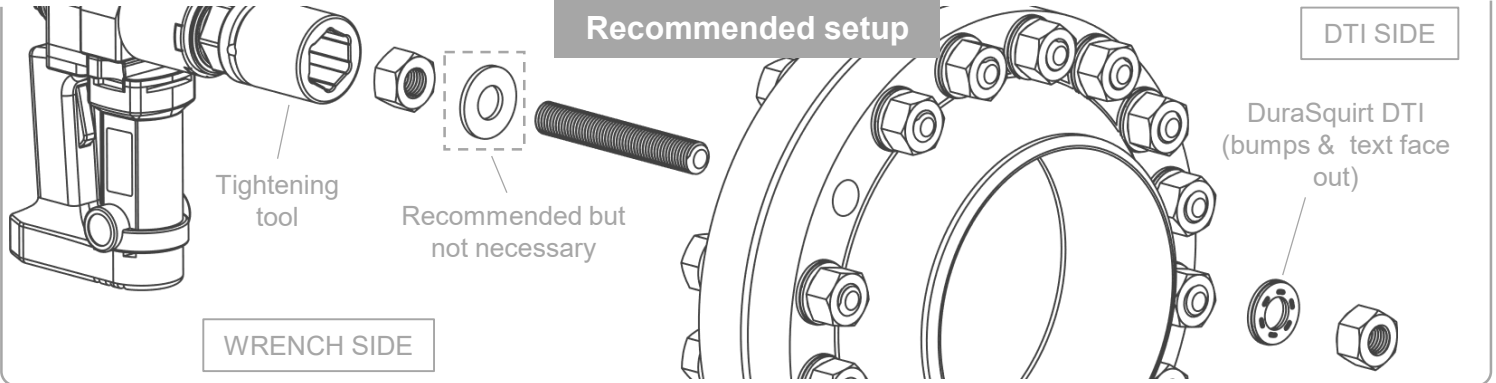


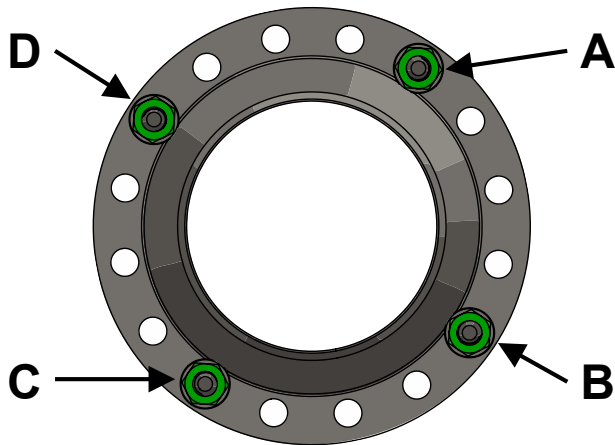
ASME Alt-3 Pattern

Recommended setup

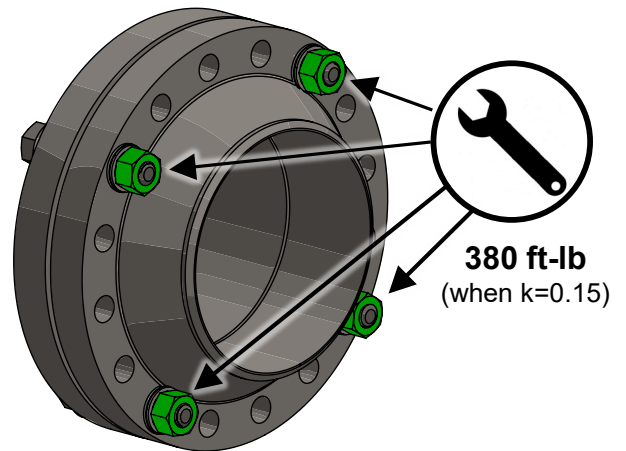
DTI SIDE



Fit-up (no DTIs yet)



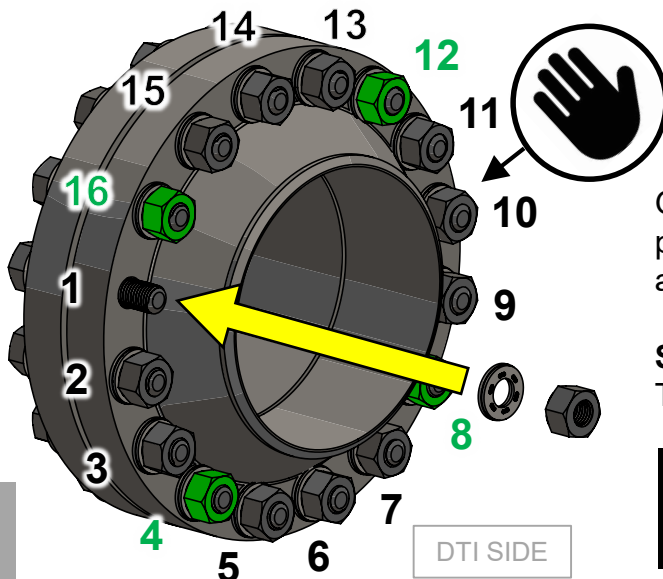
1 Insert **four** fit-up studs; one in each quadrant.



2 Tighten them to align and stabilize flange.



Do not bring the flange together with DTIs on fit-up studs. DTIs are for the tightening pass only.



Insert and **hand tighten** the remaining hardware, now including DTIs.

Going **counterclockwise** from the last fit-up stud place **DTI #1** and continue in **numerical order**, around the flange.

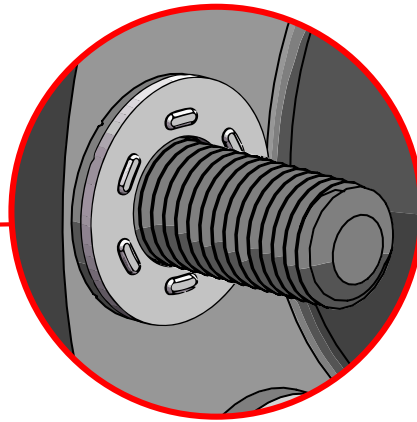
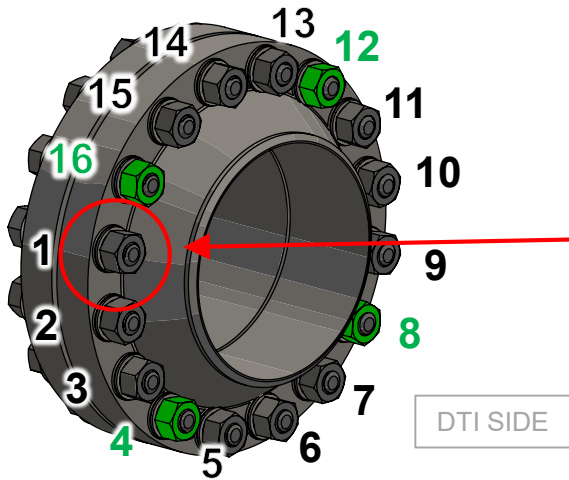
Save and set aside the DTIs for the fit-up studs. They will be installed during the tightening step.



DTIs are counterclockwise so tightening goes clockwise.

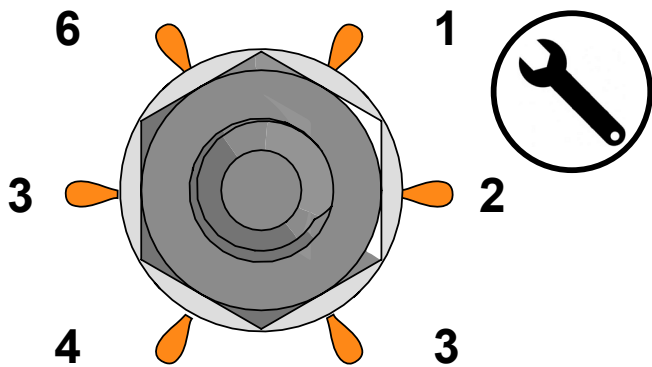
3

Tightening



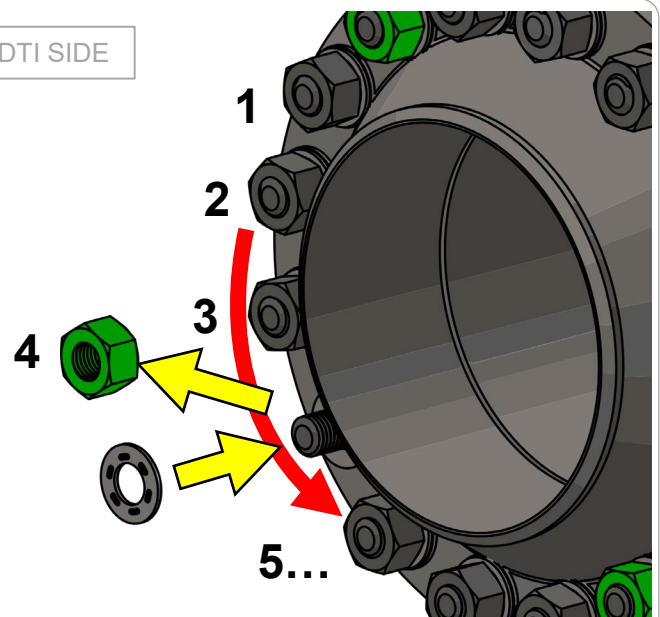
nut removed for clarity

4 Confirm the DuraSquirt DTIs were installed correctly and the fit-up ones are available, which will get installed in step 6.



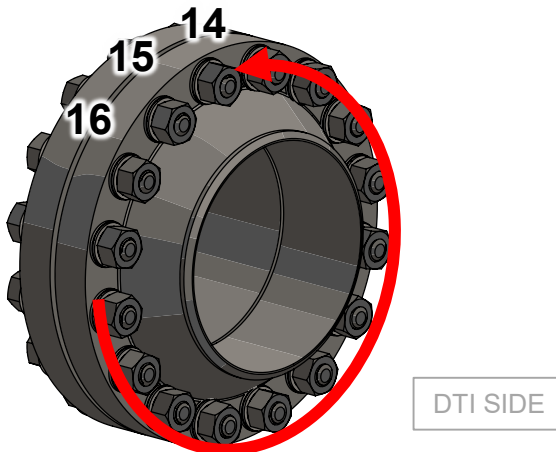
5 Tighten #1 DTI (from wrench side) just until it squirts at **all six** bump locations.

Pro Tip: Make sure stud threads are lubed and wrench is set to max, so it does not stall before squirt indication.



6 Continue in numerical order tightening each DTI until all bumps squirt.

When you reach a fit-up stud, back off the nut, install next DTI, and tighten until squirted.



7 Continue around, until the last DTI is squirted. You are done!

Questions? Our experts are here to help.
Call us at **(802) 460-3100**
or email flange@appliedbolting.com

www.appliedbolting.com



Do not re-touch. No multiple passes. Once around and you are done.