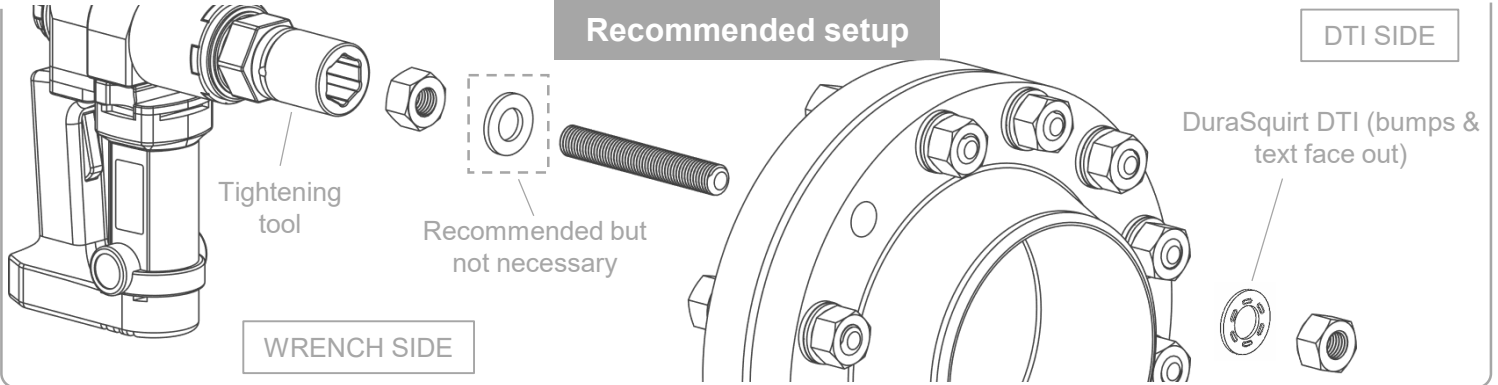


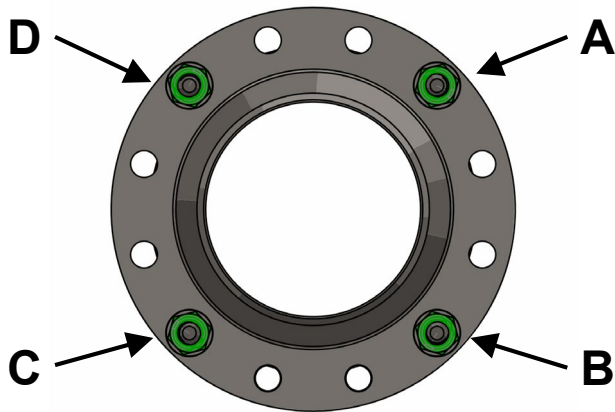
ASME Alt-3 Pattern

Recommended setup

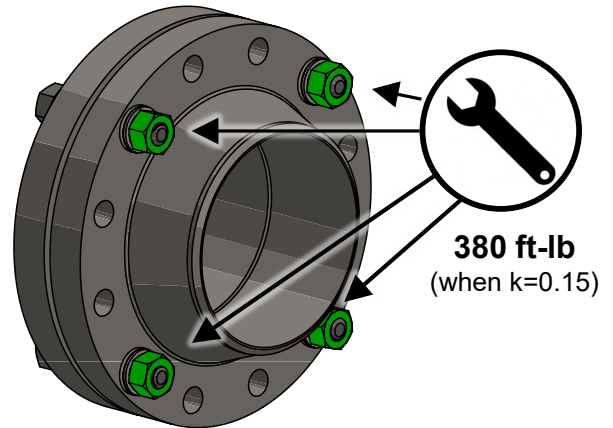
DTI SIDE



### Fit-up (no DTIs yet)



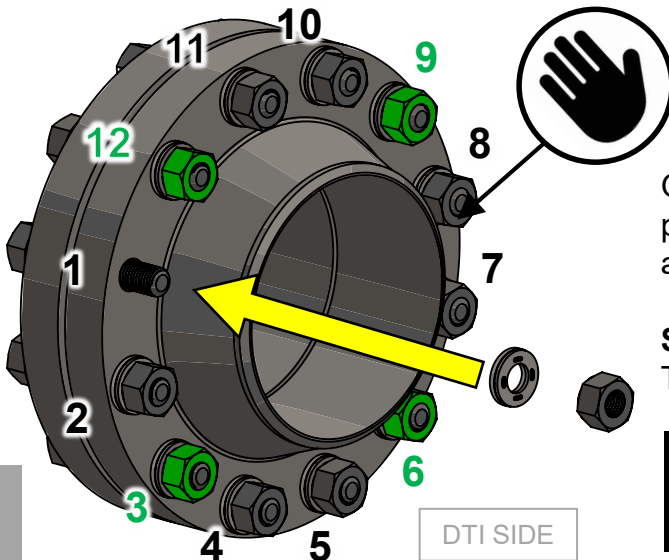
**1** Insert **four** fit-up studs; one in each quadrant.



**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.

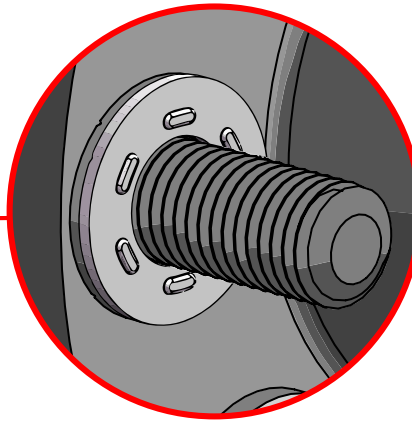
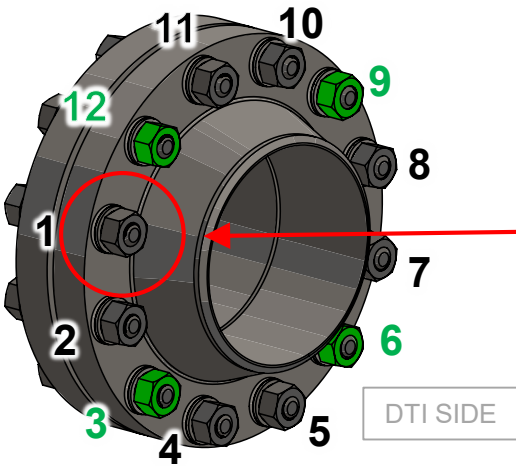
Going **counterclockwise** from the last fit-up stud place **DTI #1** and continue in **numerical order**, around the flange.

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



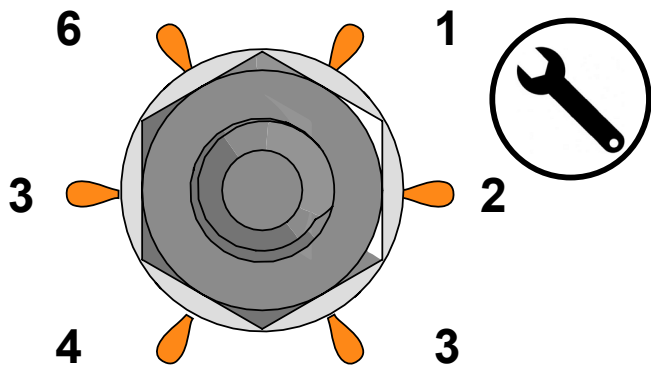
**DTIs are counterclockwise so tightening goes clockwise.**

# Tightening



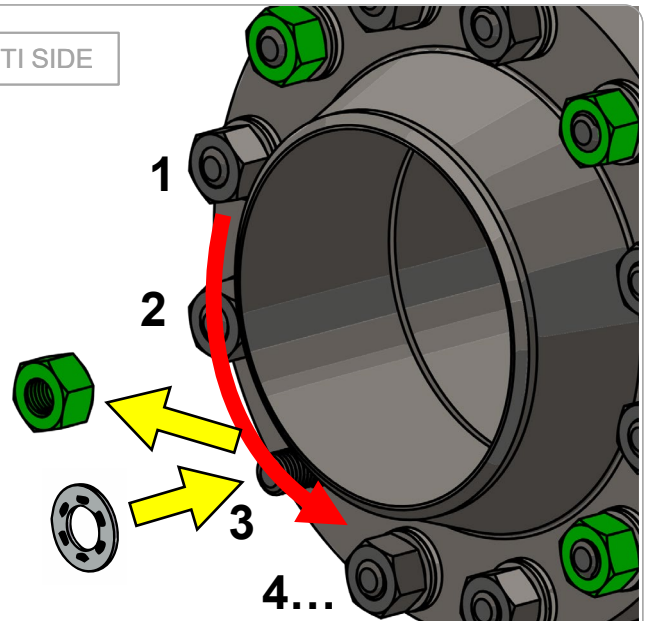
nut removed for clarity

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



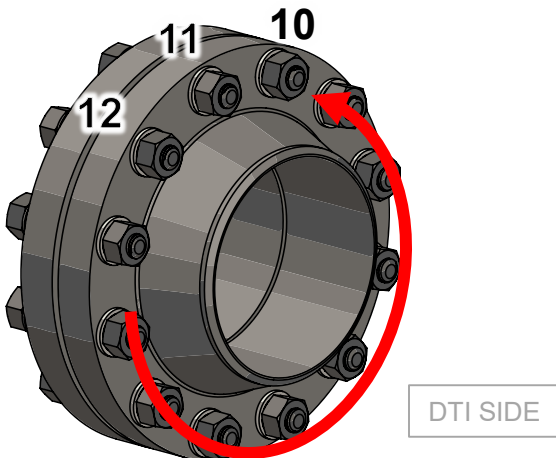
**5** Tighten #1 DTI (from wrench side) just until it squirts at **all six** bump locations.

**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](mailto:flange@appliedbolting.com)

[www.appliedbolting.com](http://www.appliedbolting.com)



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