

ROD TIGHTENING
MAY 20, 2014

	<u>1</u>	<u>4</u>	<u>7</u>	<u>10</u>
FINGER TIGHT	10164 1110	1141 .128	.161	.148
+1 TURN	.083 5	.096	.133	.113
+1/2 TURN	Torque = 125 ft-lb .069 D = .041	.080 D = .048	.113 D = .048	.098 .050
+1/4 TURN	.057 D = .053	.073 D = .055	.109 .052	.090 .058
				} Torque ~ 140 ft-lb

PROCEDURE

- INSTALL RODS AND NUTS FINGER TIGHT.
- MEASURE ROD LENGTHS
- TIGHTEN SEQUENTIALLY IN CROSS PATTERN,
MEASURE AMOUNT EACH ROD SHORTENS, KEEPING
THE DELTA APPROX EQUAL WHILE APPROACHING
140 ft-lbs.