



HNT SERVICES BOLT TORQUE GUIDELINE

HDPE X METAL

IPS SIZE	BOLT DIA	NUMBER	MAX FT LB TORQUE	FLG OD/ID
2	.625	4	35	3.9/1.94
3	.625	4	50	5.0/2.86
4	.625	8	50	6.6/3.68
6	.75	8	75	8.5/5.42
8	.75	8	120	10.63/6.76
10	.875	12	120	12.75/8.75
12	.875	12	160	15.00/10.43

CRISS CROSS TIGHTENING SEQUENCE

4 BOLT – 1/3/2/4

8 BOLT – 1/5/3/7 >> 2/6/4/8

12 BOLT – 1/7/4/10 >> 2/8/5/11 > 3/9/6/12