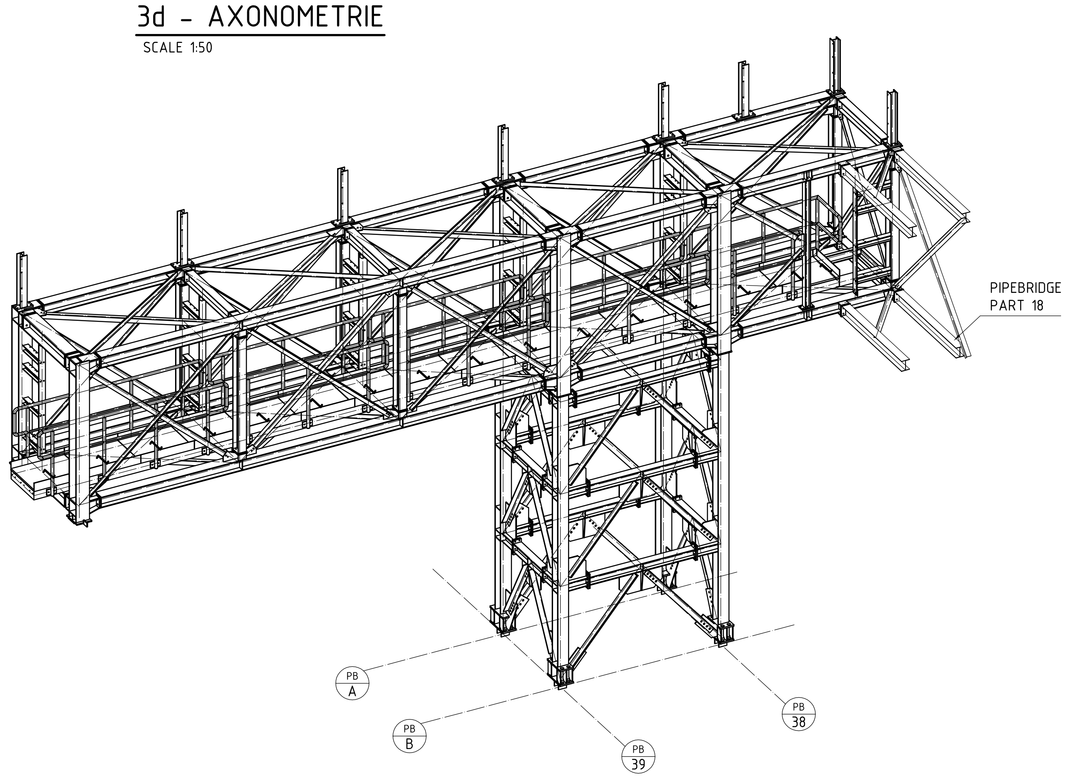
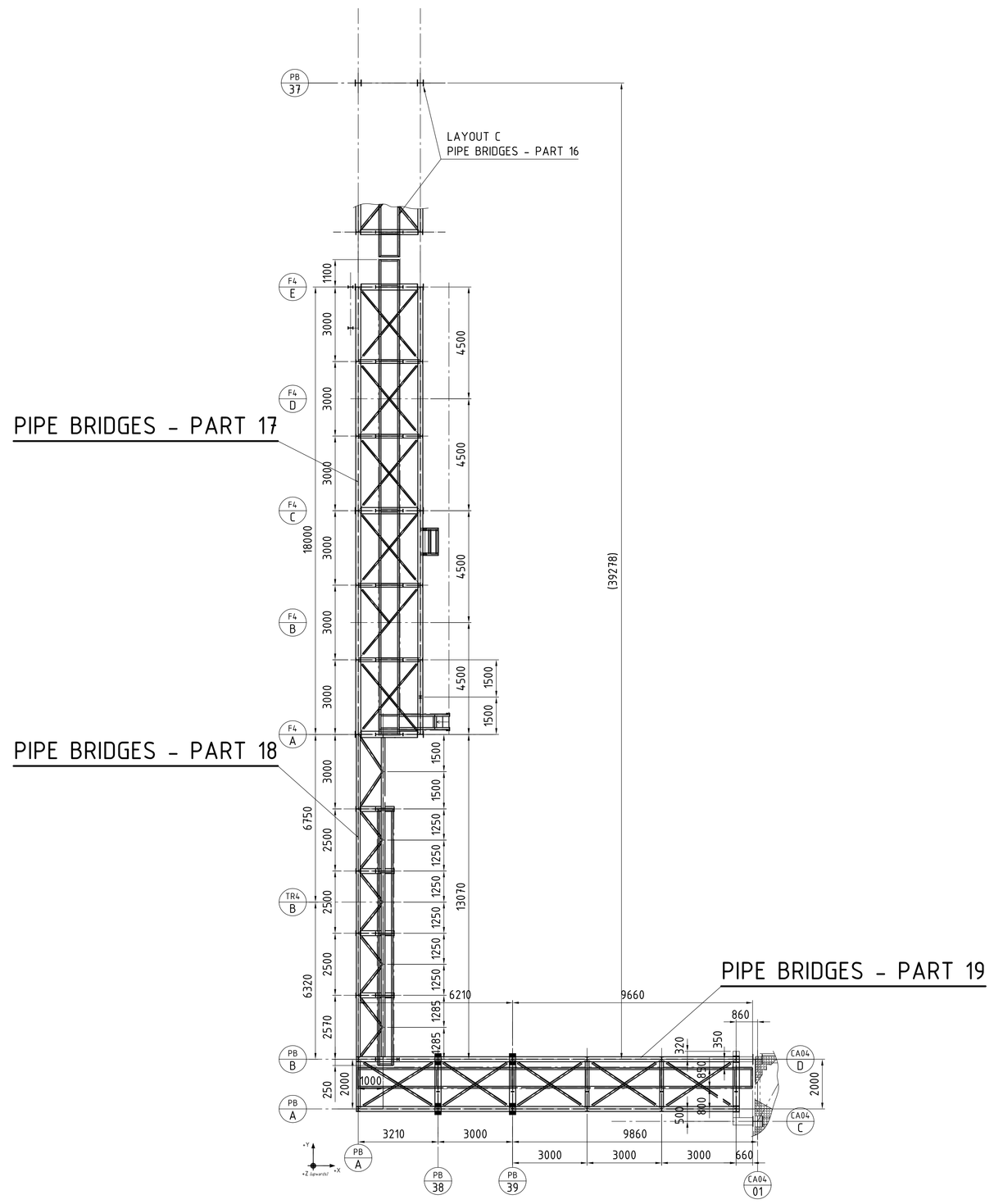
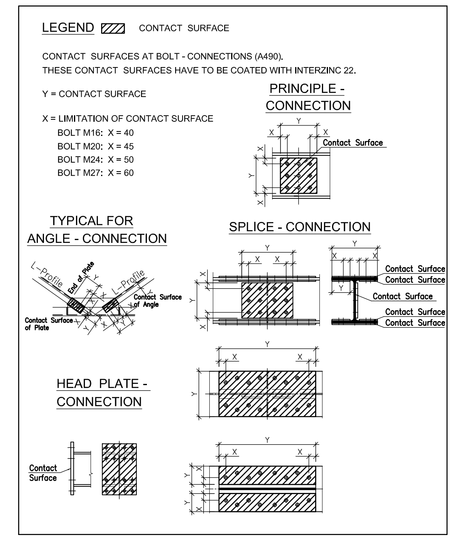
Reference Drawings		
	DWG No.	Title
		Bag Filter
I.	EK560013.P.120.4800	Erection drawing - 3D views
II.	EK560013.P.120.4801	Erection drawing - Views
III.	EK560013.P.120.4802	Erection drawing - Levels

PIPE BRIDGES - PART 19
3d - AXONOMETRIE
SCALE 1:50



Level ±0.000 Layout D
1:100





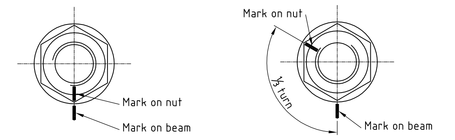
TIGHTENING OF ASTM A490 BOLTS FOR ALL STRUCTURES

TURN-OF-NUT METHOD

1) Pretensioning according table:

Bolt size	M12	M16	M20	M22	M24	M27	M30	M36
Preliminary tightening torque $M_{PA,W}$ Nm	10	50	50	100	100	200	200	200
Surface condition: according procedure and lubricated and in "as received and lubricated" condition (Nuts treated with molybdenum disulphide or equivalent lubrication)								

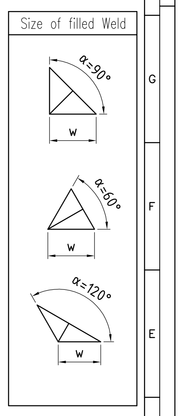
2) Marking of nut



3) Turn-of-nut pretensioning angle according table:
Nut rotation from snug-tight condition for turn-of-nut pretensioning

Bolt length ℓ	Disposition of outer faces of bolted parts		
	Both faces normal to bolt axis	One face normal to bolt axis, other sloped not more than 1:20	Both faces sloped not more than 1:20 from normal to bolt axis
Not more than $4d_B$	⅓ turn	½ turn	⅔ turn
More than $4d_B$ but not more than $8d_B$	½ turn	⅔ turn	⅚ turn
More than $8d_B$ but not more than $12d_B$	⅔ turn	⅚ turn	1 turn

Size of filled Weld



GENERAL TOLERANCES
SEE EK560013.P.120.0100

ALL WELDS IN THIS DRAWING
ACCORDING TO AWS
, w△ , s∨ , s ||
UNLESS OTHERWISE SPECIFIED

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