

BOLT TIGHTENING SEQUENCES PER ASME PCC-1 -2000

24 BOLT	1-13-7-19 4-16-10-22 2-14-8-20 5-17-11-23 3-15-9-21 6-18-12-24
28 BOLT	1-15-8-22 4-18-11-25 6-20-13-27 2-16-9-23 5-19-12-26 7-21-14-28 3-17-10-24
32 BOLT	1-17-9-25 5-21-13-29 3-19-11-27 7-23-15-31 2-18-10-26 6-22-14-30 4-20-12-28 8-24-16-32
36 BOLT	1-2-3 19-20-21 10-11-12 28-29-30 4-5-6 22-23-24 13-14-15 31-32-33 7-8-9 25-26-27 16-17-18 34-35-36
40 BOLT	1-2-3-4 21-22-23-24 13-14-15-16 33-34-35-36 5-6-7-8 25-26-27-28 17-18-19-20 37-38-39-40 9-10-11-12 29-30-31-32
44 BOLT	1-2-3-4 25-26-27-28 13-14-15-16 37-38-39-40 5-6-7-8 29-30-31-32 17-18-19-20 41-42-43-44 9-10-11-12 33-34-35-36 21-22-23-24
48 BOLT	1-2-3-4 25-26-27-28 13-14-15-16 37-38-39-40 5-6-7-8 29-30-31-32 17-18-19-20 41-42-43-44 9-10-11-12 33-34-35-36 21-22-23-24 45-46-47-48
52 BOLT	1-2-3-4 29-30-31-32 13-14-15-16 41-42-43-44 5-6-7-8 33-34-35-36 17-18-19-20 45-46-47-48 21-22-23-24 49-50-51-52 25-26-27-28 9-10-11-12 37-38-39-40
56 BOLT	1-2-3-4 29-30-31-32 13-14-15-16 41-42-43-44 21-22-23-24 49-50-51-52 9-10-11-12 37-38-39-40 25-26-27-28 53-54-55-56 17-18-19-20 45-46-47-48 5-6-7-8 33-34-35-36
60 BOLT	1-2-3-4 29-30-31-32 45-46-47-48 13-14-15-16 5-6-7-8 37-38-39-40 21-22-23-24 53-54-55-56 9-10-11-12 33-34-35-36 49-50-51-52 17-18-19-20 41-42-43-44 57-58-59-60 25-26-27-28
64 BOLT	1-2-3-4 33-34-35-36 17-18-19-20 49-50-51-52 9-10-11-12 41-42-43-44 25-26-27-28 57-58-59-60 5-6-7-8 37-38-39-40 21-22-23-24 53-54-55-56 13-14-15-16 45-46-47-48 29-30-31-32 61-62-63-64
68 BOLT	1-2-3-4 37-38-39-40 21-22-23-24 53-54-55-56 9-10-11-12 45-46-47-48 29-30-31-32 61-62-63-64 17-18-19-20 57-58-59-60 33-34-35-36 5-6-7-8 41-42-43-44 13-14-15-16 49-50-51-52 25-26-27-28 65-66-67-68
72 BOLT	1-2-3-4 37-38-39-40 21-22-23-24 57-58-59-60 5-6-7-8 41-42-43-44 25-26-27-28 61-62-63-64 9-10-11-12 45-46-47-48 29-30-31-32 65-66-67-68 13-14-15-16 49-50-51-52 33-34-35-36 69-70-71-72 17-18-19-20 53-54-55-56

**** See following page Fig 3 & 4 for illustrations of cross tightening sequences**