



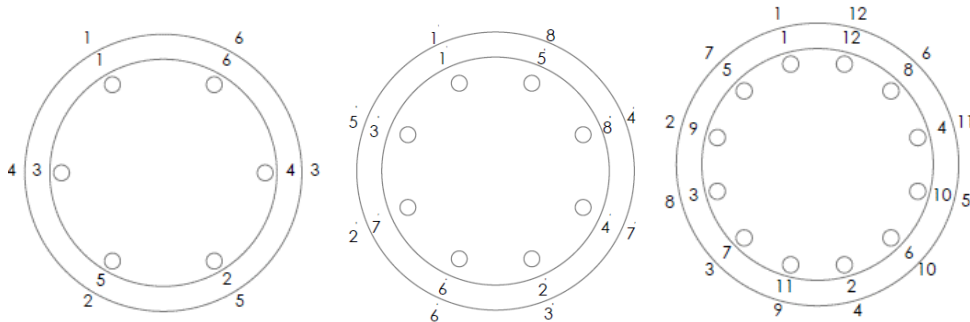
Technical Bulletin (TB-0031)

STC, HPC, STEM and STEH Heads Torque Information

Version 2, October 2013

STC and HPC Condenser Heads Torque Information

Torque sequence

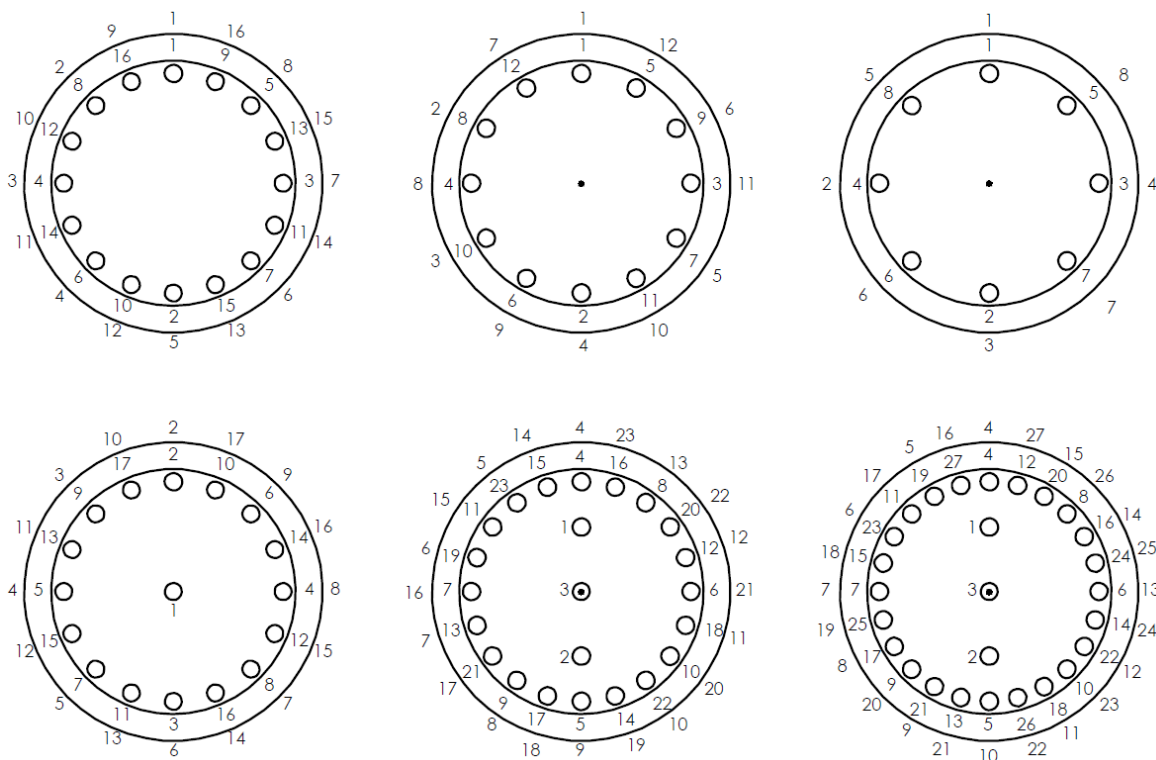


Torque Information

Stud Dia.	Torque1 [ft*lbs] Inner Ring	Torque2 [ft*lbs] Outer Ring	Torque3 [ft*lbs] Inner Ring	Retorque [ft*lbs] Inner Ring
3/8"	10	20	30	30
1/2"	20	40	60	55
5/8"	35	70	100	90

STEM and STEH Evaporator Heads Torque Information

Torque sequence



Torque Information

VESSEL NOM. DIA.	Torque1 [ft*lbs] Inner Ring	Torque2 [ft*lbs] Outer Ring	Torque3 [ft*lbs] Inner Ring	Retorque [ft*lbs] Inner Ring
6	15	30	40	35
8	15	30	50	45
10	20	40	60	55
12	20	40	60	55
14	20	50	70	65
16	30	60	120	110
18	30	60	120	110
20	30	60	120	110

Notes

1. If the unit that you are working on does not match one of these use the written instructions below.
 - a. Start at a top bolt or 12 o' clock, torque bolt.
 - b. Move 180 degrees to a bottom bolt or 6 o' clock, torque bolt.
 - c. Move 90 degrees to a bolt at 9 o' clock, torque bolt.
 - d. Move 180 degrees to a bolt at 3 o' clock, torque bolt.
 - e. Go back to the top and move clock wise one bolt and start the sequence over. Continue using the steps out lined above, using the torque steps listed in the chart below.
2. Do not oil gasket!
3. Clean and inspect the sealing surface and threads.
4. After pressurizing tighten the screws again.
5. Use a drop of Loctite 277 in the tubesheet threaded holes.
6. It is recommended to replace gaskets and lock washers if the head is removed.
7. Refer to DB-205 for further operation instructions.