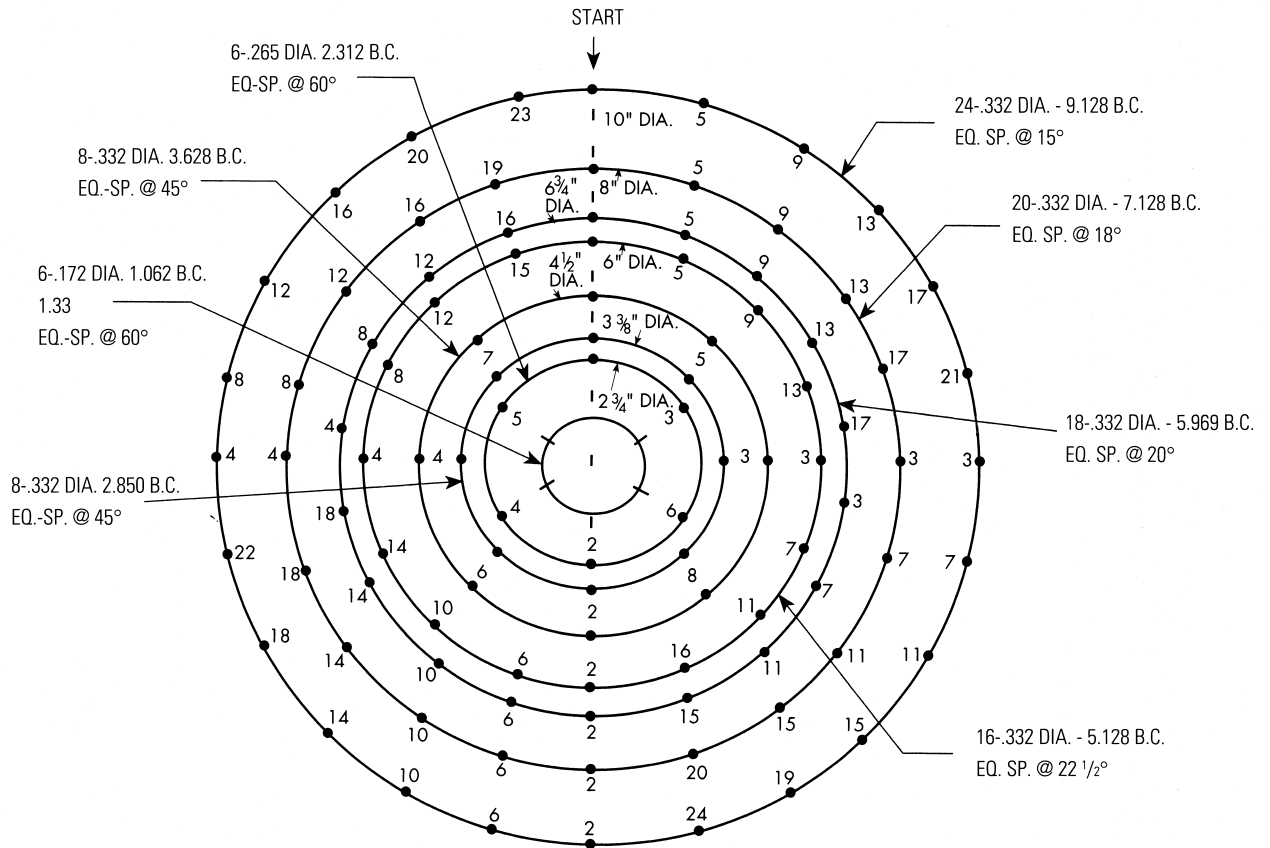


CONFLAT FLANGE: TIGHTENING SEQUENCE & BOLT HOLE LAYOUT



Schematic of bolt-hole locations, 1.33 in., 2-3/4 in., 3-3/8 in., 4-1/2 in., 6 in., 6-3/4 in., 8 in., 10 in. ultra-high-vacuum bakeable flanges numbered in sequence for completing seal.

Flange Bolt and Torque Data

Lubricated Bolt Torque	Bolt dia/thd	Flange Size (OD in.) and Number of Bolts						
		2 3/4	3 3/8	4 1/2	6	6 3/4	8	10
80 in.-lb (7 ft.-lb.) to 100 in.-lb max	1/4 in. -20	6	—	—	—	—	—	—
120 in.-lb (10 ft.-lb.) to 150 in.-lb max	5/16 in. -18	—	8	8	16	18	20	24

TECHNICAL REFERENCE