

**Assembly Instructions for Code 61 and Code 62- Four Bolt Split Flange Connections**

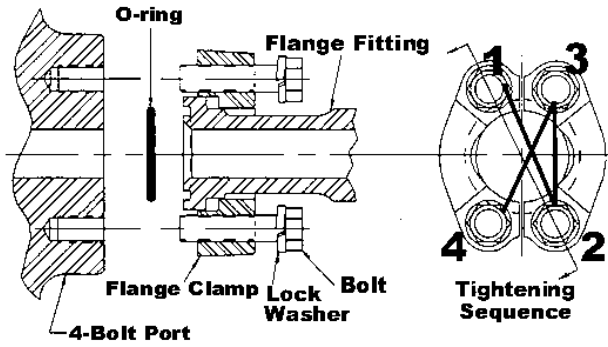


Fig.A12 Four Bolt Flange Fitting Assembly

1. Inspect components for damage or contamination.
2. Install correct O-ring in flange groove.
3. Lubricate O-ring and bolt threads.
4. Align flange and clamp halves to port.
5. Install bolts, hand tighten evenly to seat O-ring on port face.
6. Gradually tighten bolts in equal increments, alternating in a diagonal pattern, to recommended torque listed in Table A7 or A8. See Fig.A12.

**Table A7. Assembly Torque, Code 61 Flange Ends<sup>1</sup>**

Dash Size	Flange Size	Bolt Size	Ft. Lbs.	Nm.
-8	1/2	5/16-18 x 1-1/4	15-19	20-25
-12	3/4	3/8-16 x 1-1/4	21-29	28-40
-16	1	3/8-16 x 1-1/4	27-35	37-48
-20	1-1/4	7/16-14 x 1-1/2	35-46	48-62
-24	1-1/2	1/2-13 x 1-1/2	46-58	62-79
-32	2	1/2-13 x 1-1/2	54-67	73-90

1) Lubricated assembly, Grade 5 bolts or better.

**Table A8. Assembly Torque, Code 62 Flange Ends<sup>1</sup>**

Dash Size	Flange Size	Bolt Size	Ft. Lbs.	Nm.
-8	1/2	5/16-18 x 1-1/4	15-19	20-25
-12	3/4	3/8-16 x 1-1/2	25-33	34-45
-16	1	7/16-14 x 1-3/4	42-50	56-68
-20	1-1/4	1/2-13 x 1-3/4	62-75	85-102
-24	1-1/2	5/8-11 x 2-1/4	117-133	158-181
-32	2	3/4-10 x 2-3/4	200-217	271-294

1) Lubricated assembly, Grade 5 bolts or better.

