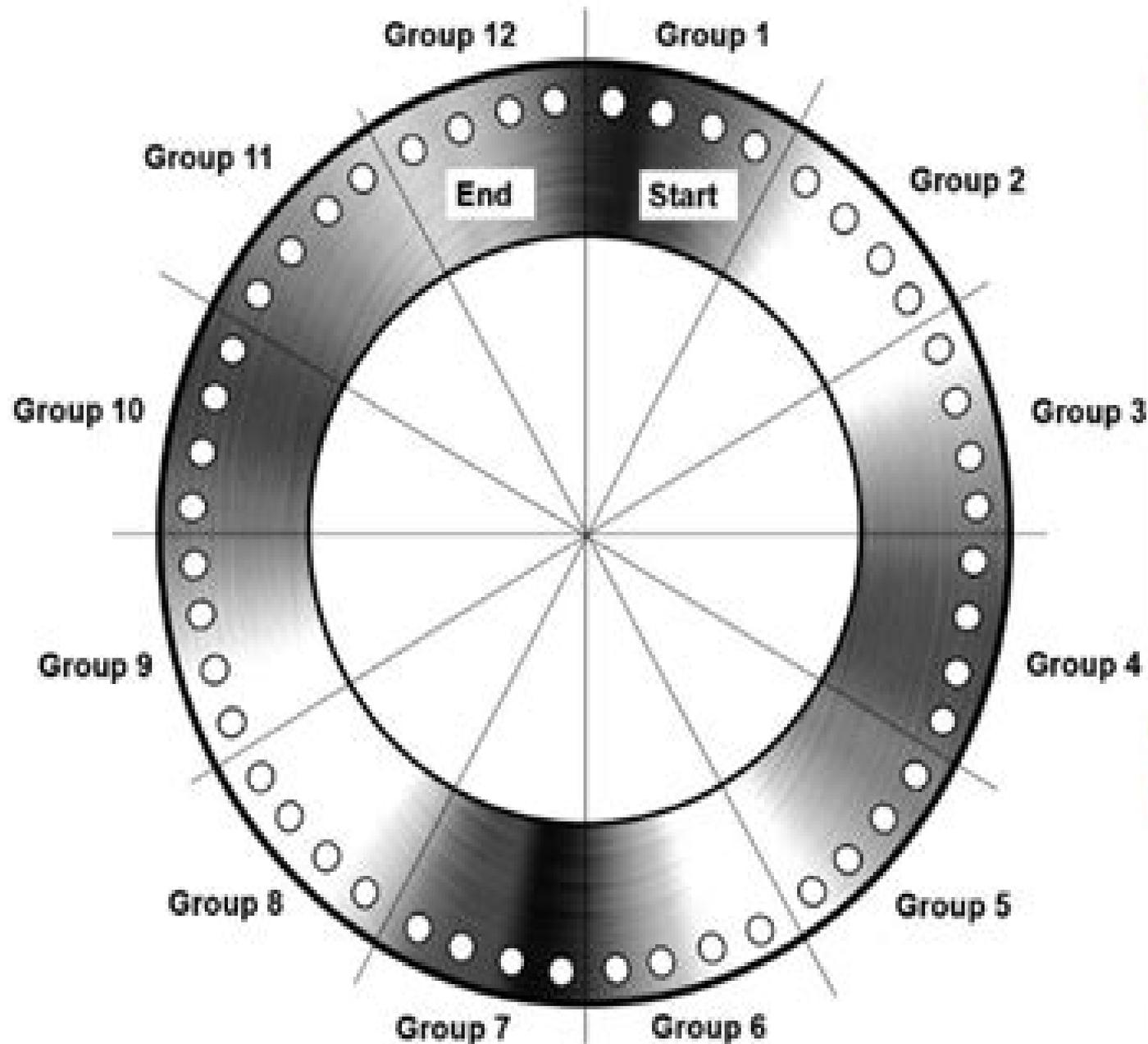


# 48-Bolt Flange Bolt Grouping



Group	Bolts
1	1-2-3-4
2	5-6-7-8
3	9-10-11-12
4	13-14-15-16
5	17-18-19-20
6	21-22-23-24
7	25-26-27-28
8	29-30-31-32
9	33-34-35-36
10	37-38-39-40
11	41-42-43-44
12	45-46-47-48

Tightening Sequence for 12 Groups
1-7-4-10
2-8-5-11
3-9-6-12

The 12 group sequence is the same as a 12 bolt sequence.

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**J Spring**



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