



WARNING

Must read the instruction of cap flange bolts tightening instruction.

Model	Flange bolt torque
RC-Ni series	40 foot pound (50 N-m)
OTF-1200X-HP-55-UL	40 foot pound (50 N-m)
OTF-1200X-HP-30A-UL	15 foot pound (20 N-m)
OTF-1200X-HPV	15 foot pound (20 N-m)

Must follow the star pattern tightening sequence as the following steps:

1. Secure the high pressure vessel vertically. If not applicable, secure the vessel horizontally.
2. Place the new copper gasket in the slot in flange.
3. Place the cap flange. Do it gently to make sure the copper gasket is in the slot.
4. Place one bolt in the threaded hole. Using your fingers, turn the bolt gently so that it is putting only gentle pressure on the flange. Follow the star pattern to add other bolts in the same way.
5. Go back to the first bolt, and tighten it by an [L-shape Allen wrench \(Manual Hex key\)](#) using moderate pressure. Tighten other bolts in the same way by working in a star pattern sequence.
6. Continue to work in a star pattern to tighten the bolts as much as you can by the [L-shape Allen wrench \(manual hex key\)](#).
7. Now using the [torque wrench](#), set the correct torque limits, to work in a star pattern to tighten all the bolts.
8. Place the high pressure vessel back to the furnace. The flange cap tightening job is done.

Always attach this instruction to the furnace to place it in a noticeable location.