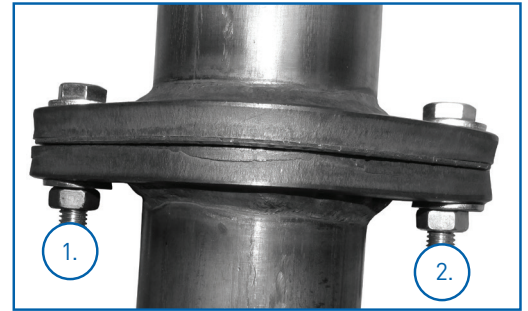


## EXCLUSIVE EMISSIONS CONTROL REPAIR TIP!

### CHALLENGE

#### IMPROPERLY TORQUED FLANGES CAN RESULT IN LEAKS, WARPING & FAILURE

Exhaust flanges that are improperly tightened or torqued can cause many problems, including exhaust system leaks; associated component failure, like gaskets and studs; and premature system fatigue and failure.



### SOLUTION

#### PROGRESSIVELY TIGHTEN BOLTS ON FLANGES

Flanges are found on a variety of parts associated with exhaust repairs. Each has its own process for achieving proper torque and successful installation. In general, all nuts are secured following a progressive, higher torque sequence. For example, the nuts require 60-ft.-lbs. of torque. Begin by torquing nut one, two and three to 20-ft.-lbs. Then, tighten all three nuts to 40-ft.-lbs., and finish by tightening each to 60-ft.-lbs.

#### For Y-Pipes:

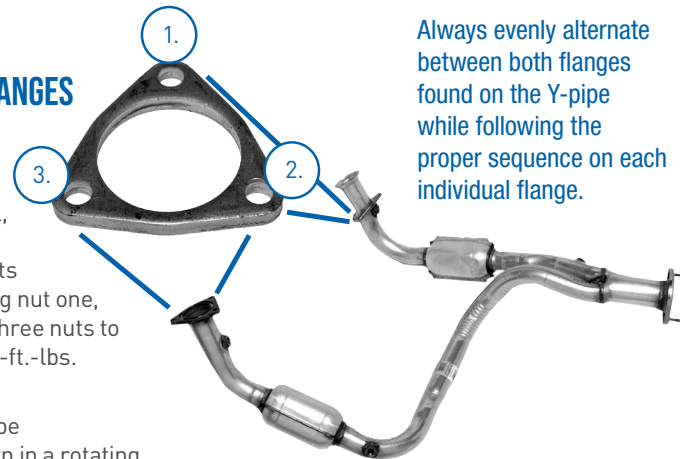
It's important to secure both sides of the Y-pipe simultaneously. Begin by tightening nuts down in a rotating sequence between both pipes. It is also necessary to alternate between both flanges found on the Y-pipe.

#### For Manifold Converters:

Typically, the tightening sequence begins in the middle of the manifold, while working your way out evenly between both sides. Be sure to review manufacturer's recommended torque sequence for each application.

#### IMPORTANT:

In all installation instances above, tighten all studs evenly throughout the process.



Always evenly alternate between both flanges found on the Y-pipe while following the proper sequence on each individual flange.

