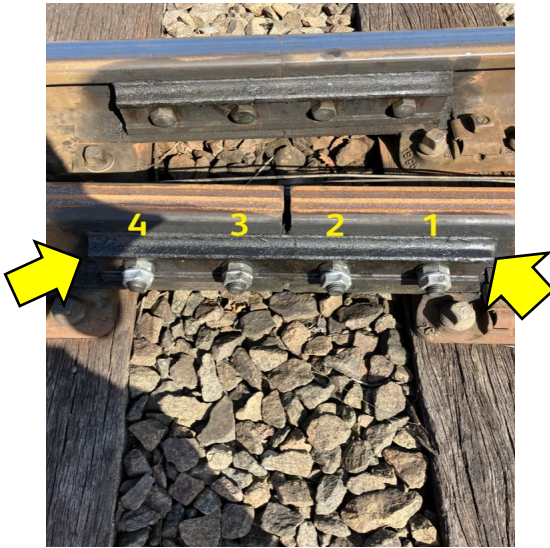


Fishplate Conversion – Bolt Tightening Sequence Best Practice



Toolbox:

1. 36mm Spanner
2. 36mm Socket
3. Torque wrench
4. Hardlock Convex and Concave nut (M24)
5. Fishplate Bolt
6. Conical Washer
7. Copper Mallet
8. Interflon Metal Clean
9. Scraper
10. Interflon Lube EP

Installation Steps

- Remove fishplates and clean all mating surfaces using a scraper and **Interflon Metal Clean**.
- Insert bolts through the joint.
- From the **nut side**, fit the **conical (domed) washer – belly facing out**.
- Hold the bolt head with a spanner to prevent rotation.
- Fit the **convex nut (lower nut)** and hand-tighten.
- Using a **calibrated torque wrench** tighten convex nuts to **350 Nm**.
- **Tightening sequence must be followed: 2 → 3 → 4 → 1**
- Once all four nuts are torqued, use a **copper mallet** to strike both fishplates.
→ Strike points as shown by yellow arrows on diagram.
- Re-torque convex nuts (lower nut) to **350 Nm** in sequence **2 → 3 → 4 → 1**.
- Fit **concave nut (upper nut)** onto convex nut.
- Torque concave nut to **300 Nm**.
- Apply an overspray of **Interflon Lube EP** along each edge of the plate, including top, bottom and both sides.