FIG.7

FASTENING CONDITION TABLE 96

LINE NAME	FLANGE No.	FLANGE DIMENSIONS	GASKET PART No.	GASKET DIMENSIONS	NUMBER OF BOLTS	FASTENING CONDITION	Pass 1	Pass 2	Pass 3	.....	Pass 13
LineA	1	JIS10K15A	6596VSESZZZt3	.....	4	1	4	6	8	.....	26
LineA	2	JIS10K20A	6596VSESZZZt3	.....	4	2	5	8	10	.....	34
LineA	3	JPI300lb1B	6596VSESZZZt3	.....	4	3	8	12	16	.....	55
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
LineA	8	JPI300lb16B	MJ	.....	20	8	53	81	108	.....	363
LineB	1	JIS10K15A	6596VSESZZZt3	.....	4	9	4	6	8	.....	26
LineB	2	JIS10K20A	6596VSESZZZt3	.....	4	10	5	8	10	.....	34
LineB	3	JPI300lb1B	6596VSESZZZt3	.....	4	11	8	12	16	.....	55
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
LineB	8	JPI300lb16B	MJ	.....	20	16	53	81	108	.....	363

96-1 96-2 96-3 96-4 96-5

96

FIG.10

A [FASTENING RESULT INFORMATION 138]

138-1	LINE NAME (APPLIED POINT INFORMATION)	LineA
	INDIVIDUAL BOLT FASTENING CONDITIONS	1
138-2	FASTENING DATE AND TIME	3/4 10:00
138-3	FASTENING ERROR DETERMINATION	OK
138-4	FASTENING RESULT (TORQUE)	100N·m
138-5	FASTENING RESULT (NUT ROTATIONAL ANGLE)	10°

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B [LOG INFORMATION TABLE 98-1]

LINE NAME	FLANGE No	FLANGE DIMENSIONS	GASKET PART No.	NUMBER OF BOLTS	FASTENING CONDITION No.	FASTENING RESULT			WORKER ID
						PASS NUMBER	PASS 1 TORQUE	FINAL PASS TORQUE	
LineA	1	JIS10K15A	6596VSESZZZt3	4	1	13	4	26	0000
LineA	2	JIS10K20A	6596VSESZZZt3	4	2	13	5	34	0000
LineA	3	JPI300lb1B	6596VSESZZZt3	4	3	13	8	55	0000
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
LineA	8	JPI300lb16B	MJ	20	8	13	53	363	0000
LineB	1	JIS10K15A	6596VSESZZZt3	4	9	13	4	26	0001
LineB	2	JIS10K20A	6596VSESZZZt3	4	10	13	5	34	0001
LineB	3	JPI300lb1B	6596VSESZZZt3	4	11	13	8	55	0001
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮
LineB	8	JPI300lb16B	MJ	20	16	13	53	363	0002

98-11 98-12 98-13 98-14 98-15 98-16 98-17

98-1

FIG.11

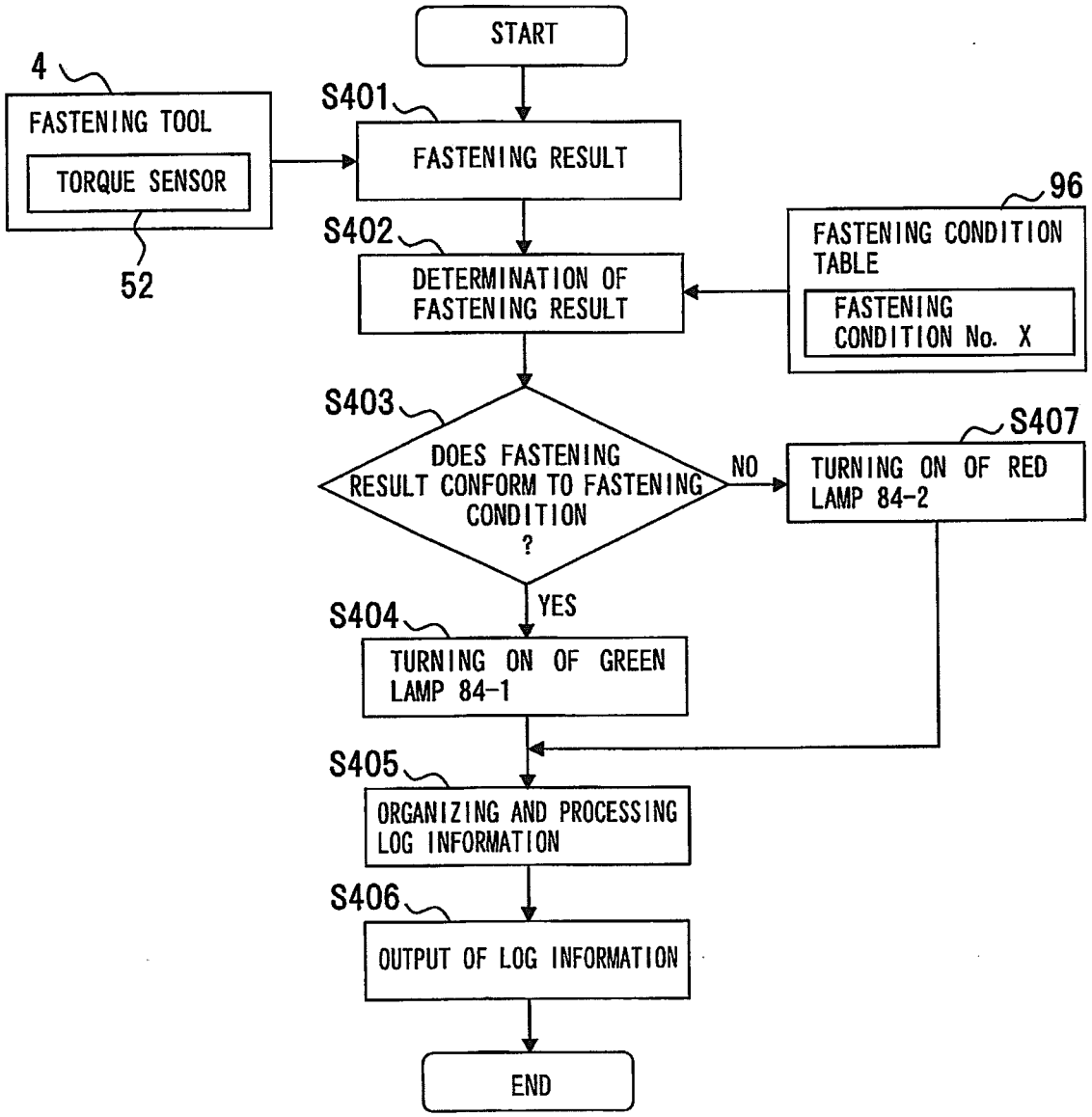
LOG INFORMATION TABLE 98-2

LINE NAME	FLANGE No.	GASKET PART No.	GASKET DIMENSIONS	WORKER ID	FASTENING CONDITION	FASTENING DATE AND TIME	ERROR DETERMINATION	FIRST ROUND FASTENING RESULT BOLT 1	.....	BOLT 8	FINAL ROUND FASTENING RESULT BOLT 1	.....	BOLT 8	NUMBER OF TIMES OF ROUND
Line A	1	GF300 T3.0	150lb4B	0000	No. 1	3/4 10:00	OK	20 N・m	.....	20 N・m	110 N・m	.....	110 N・m	10
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	.....	⋮	⋮	.....	⋮	⋮
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	.....	⋮	⋮	.....	⋮	⋮
Line B	1	6596V SESZZZ	10K25A	0000	No. 4	3/4 10:45	OK	10	.....	10	60	.....	60	10
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	.....	⋮	⋮	.....	⋮	⋮
⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	⋮	.....	⋮	⋮	.....	⋮	⋮

98-21 98-22 98-23 98-27 98-25 98-28 98-29 98-30 98-31 98-32

98-2

FIG.14


START
4
FASTENING TOOL
TORQUE SENSOR
52
S401
FASTENING RESULT
96
FASTENING CONDITION TABLE
FASTENING CONDITION No. X
S402
DETERMINATION OF FASTENING RESULT
S403
DOES FASTENING RESULT CONFORM TO FASTENING CONDITION ?
NO
S407
TURNING ON OF RED LAMP 84-2
YES
S404
TURNING ON OF GREEN LAMP 84-1
S405
ORGANIZING AND PROCESSING LOG INFORMATION
S406
OUTPUT OF LOG INFORMATION
END