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Step 1: Tighten 4 jackbolts by hand or using a small wrench to center the main thread and to eliminate backlash. Tighten bolts crosswise. Step 2: Now tighten these 4 jackbolts crosswise with 50% of the recom- mended jackbolt torque. Step 3: Tighten the same 4 jackbolts cross- wise with 100%.

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