

# Torque Instructions

This preventive maintenance procedure will insure longer sifter life by guarding against loose bolts resulting from normal wood shrinkage caused by plant temperature or humidity changes, etc.

Norvell recommends that you tighten your sifter bolts with a **torque** wrench to the below specifications every 90 days<sup>1</sup>:

- 5/8” bolts – 15/16” socket – 90 foot-pounds
  - *Sifter Box*
  - *Sifter Drive to Box*
  - *Side Channel & Tie Bar Plate*
  
- 1/2” bolts – 3/4” socket – 70 foot-pounds
  - *Reed Caps (Ceiling & Side Channel)*
  - *Weight Plates<sup>2</sup>*
  
- 1/2” bolts - 3/4” socket – 90 foot-pounds<sup>3</sup>
  - *Grade 8 Cable Clamp Brackets (Ceiling & Side Channel)*

**DO NOT** use a hammer to tighten the door handle nuts. The door handle nuts are to be tightened only enough to press the door firmly against the sieves and to hold the sieves firmly against the internal plush strips. The door handles must be tightened evenly on both sides.

1. *On new sifters, Norvell recommends checking the torque every two weeks for the 1<sup>st</sup> month, and then once a month for the next three month allowing for a break-in period.*
2. *This only applies to sifters manufactured after September 2015.*
3. *The only exception to this are the 1/2” bolts on the side panel covers enclosing the weight bucket drive. These should be tightened enough to hold the side panel cover in place securely, over-tightening these bolts could severely damage the side panel covers.*



**4002 Liberty Bell Road  
Fort Scott, KS 66701  
Phone: 800-653-3147  
Fax: 620-223-3115  
Email: [sales@norvellco.com](mailto:sales@norvellco.com)**