



Evans Metal Products Co., Inc.

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“Building Beyond Tomorrow”

Established 1945



EMP's Quality Policy

1. Provide products and services of the highest possible standards, to satisfy our customer's need, expectations of quality, safety, reliability and service.
2. We accomplish these objectives by establishing, implementing and maintaining a documented effective Quality Management System.
3. We strive to become a world-class organization.

Shop Bolting is not a process Evans Metal has chosen to do at present.

In the unusual case shop bolting is requested, it is directly supervised by the President.

Snug Tight Shop Bolting Habits @ Evans Metal

1.12.2.8 - Revised May 5, 2018

1. We verify that bolts will fit through the holes without damage to the threads.
2. We select only controlled bolts and record the heat number on the part drawing for washers, nuts and bolts.
3. We also check to make sure that the bolt used are the correct grade and length.
4. We never use a bolt where the bolt does not extend **past** the nut and washer assembly.
5. We made sure to have nut and washer labels exposed for verification.
6. We install washers and nuts with markings facing away from the bolt head.
7. We tighten the bolts finger tight.
8. We then tighten bolts sufficiently to prevent removal of nuts without the use of a wrench.
 - a. If we use an impact wrench, we only use a few impacts
 - b. If we use a spud wrench, we use our full effort
9. We make sure that all plies are brought into contact with each other.
10. We use a pattern in tightening. We start at the most rigid area locations and tighten towards the least rigid.
 - a. For larger connections, this tightening pattern may need to be repeated more than once!

David Evans

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