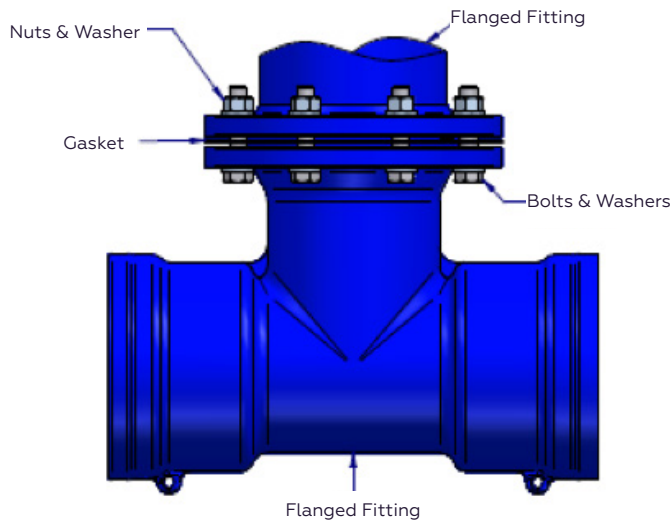


CREVET® DUCTILE IRON FITTINGS

FLANGE TO FLANGE

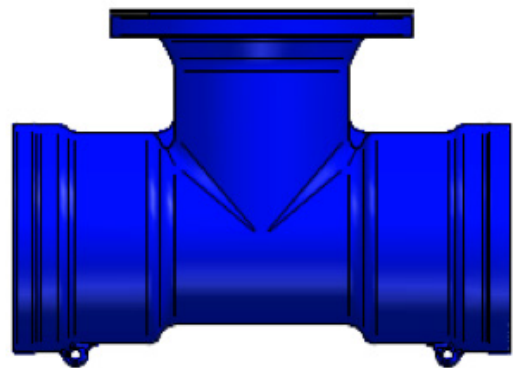
INSTALLATION GUIDELINES

FLANGE TO FLANGE ASSEMBLY COMPONENTS



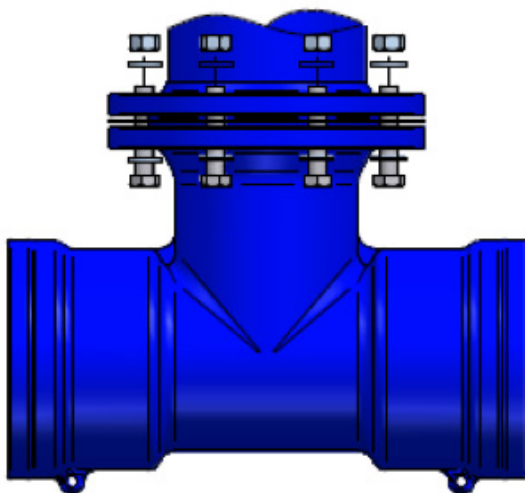
STEP 1

Place the gasket over the flange. Ensure that the holes on the gasket align evenly with the flanged holes.



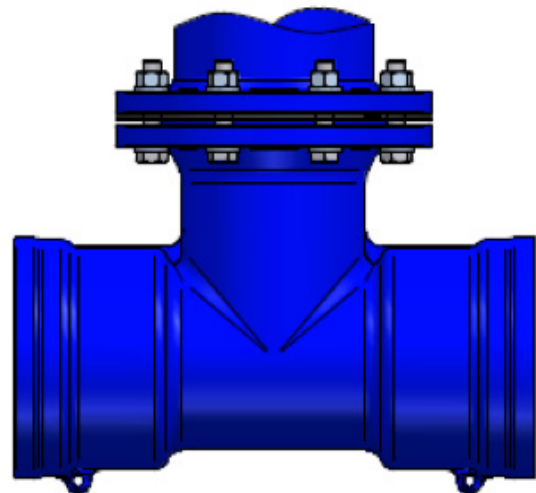
STEP 2

Place the flange over the gasket. Ensure that the flanges align evenly. Insert washers and bolts from one side and washers and nuts from the other side.



STEP 3

Tighten as per standard flange bolt tightening practice (refer to sheet 4).



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CREVET® DUCTILE IRON FITTINGS

FLANGE TO FLANGE

TABLE 1.1

Estimated tightening torque values standard pressure flanges as AS 4087 Figure B5.
 PN16 Grade 4.6 galvanised steel bolts and nuts or Grade 316 Class 50 stainless steel bolts
 and nuts with full face gasket – 3mm gasket rubber

NOMINAL SIZE (DN)	BOLT SIZE	NO. OF BOLTS	SUGGESTED LENGTH OF BOLTS (mm)	BOLT TENSION (kN)	ESTIMATED TORQUES (Nm)		
					LIGHTLY OILED 'GSB'	WELL LUBRICATED 'GSB'	WELL LUBRICATED 'SSB'
80	M16	4	65	16	60	40	55
100	M16	4	75	22	80	55	70
150	M16	8	75	17	60	40	55
200	M16	8	75	22	80	55	70
225	M16	8	75	24	85	60	80
250	M20	12	90	35	155	105	140
300	M20	12	100	28	125	85	115
375	M24	12	100	42	220	150	200
450	M24	12	120	53	280	190	255
500	M24	16	120	52	275	185	250
600	M27	16	130	67	400	270	360
750	M30	20	140	80	530	360	480

Note

- "Lightly oiled" Refers to the application of a good quality lubricating oil and is the usual as received condition of fasteners
- "Well lubricated" Refers to the application of molybdenum disulphide grease or equivalent anti-seize compound
- Recommended tightening in three steps 30%, 60% & 100%
- These guidelines are also applicable for dismantling joint and adapta flange fittings during flange to flange jointing

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CREVET® DUCTILE IRON FITTINGS

FLANGE TO FLANGE

TABLE 1.2

Estimated tightening torque values high pressure flanges AS 4087 Figure B6.
 PN35 Grade 8.8 galvanised steel studs and nuts or Grade 316 Class 70 stainless steel studs
 and nuts with full face gasket - 1.5mm fibre gasket

NOMINAL SIZE (DN)	BOLT SIZE	NO. OF BOLTS	SUGGESTED LENGTH OF BOLTS (mm)	BOLT TENSION (kN)	ESTIMATED TORQUES (Nm)		
					LIGHTLY OILED 'GSS'	LIGHTLY OILED 'GSS'	LIGHTLY OILED 'SSS'
80	M16	8	110	41	140	100	135
100	M16	8	110	52	100	130	170
150	M20	12	130	66	290	200	265
200	M20	12	130	93	410	280	365
225	M24	12	150	108	570	390	520
250	M24	12	150	118	620	430	570
300	M24	16	150	110	580	400	530
375	M27	16	170	141	840	570	760
450	M30	20	190	150	990	680	900
500	M30	24	190	156	1030	700	935
600	M33	24	210	195	1420	970	1290
750	M33	28	210	230	1670	1140	1520

Note

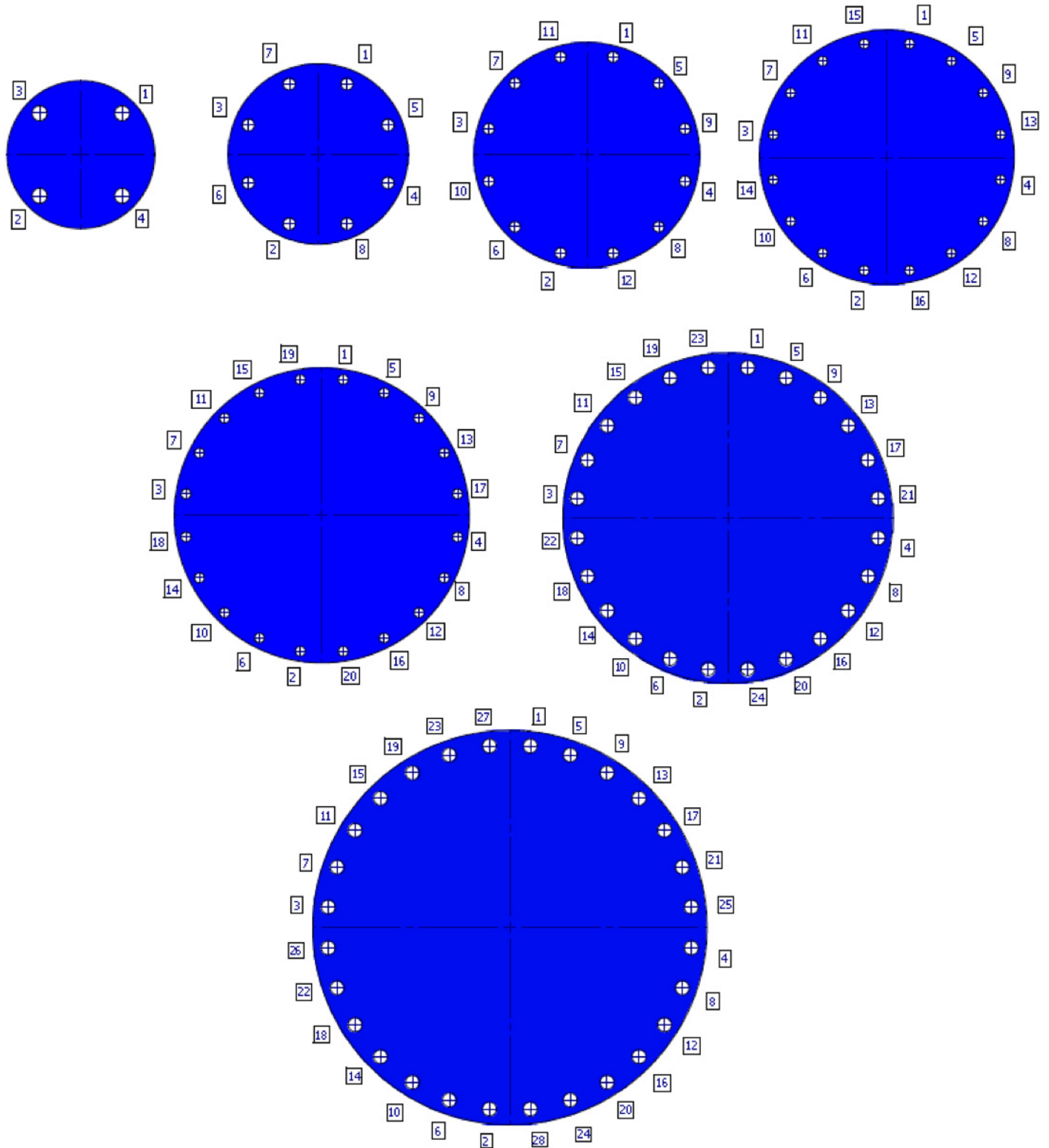
- "Lightly oiled" Refers to the application of a good quality lubricating oil and is the usual as received condition of fasteners
- "Well lubricated" Refers to the application of molybdenum disulphide grease or equivalent anti-seize compound
- Recommended tightening in three steps 30%, 60% & 100%
- These guidelines are also applicable for dismantling joint and adapta flange fittings during flange to flange jointing

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FLANGE TO FLANGE

FLANGE TO FLANGE (TYPICAL FLANGE BOLT TIGHTENING SEQUENCE)



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