Dismantling Joints DN40 to DN300 (PN10,16,25,40)

Dismantling Joint

![Diagram of Dismantling Joint]

**Note:** Maximum Longitudinal Adjustment = Maximum Length – Minimum Length

Dismantling Joints (Standard Product)

Table provides details of standard product – for products offering longer flange dimensions and / or increased longitudinal adjustment contact Viking Johnson.

<table>
<thead>
<tr>
<th>Nom</th>
<th>Drilling</th>
<th>Flange Details</th>
<th>Flange to Flange Details</th>
<th>Tie Rod Details</th>
<th>Flange Adaptor &amp; Spigot Manufacture</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Flange Thickness</td>
<td>Flange OD</td>
<td>Nominal Length</td>
<td>Minimum Length</td>
</tr>
<tr>
<td></td>
<td></td>
<td>(mm)</td>
<td>(mm)</td>
<td>(mm)</td>
<td>(mm)</td>
</tr>
<tr>
<td>40</td>
<td>PN10,16,25,40</td>
<td>18</td>
<td>18</td>
<td>150</td>
<td>187</td>
</tr>
<tr>
<td>50</td>
<td>PN10,16,25,40</td>
<td>17</td>
<td>17</td>
<td>165</td>
<td>194</td>
</tr>
<tr>
<td>65</td>
<td>PN10,16</td>
<td>17</td>
<td>17</td>
<td>185</td>
<td>194</td>
</tr>
<tr>
<td>80</td>
<td>PN10,16,25,40</td>
<td>17</td>
<td>17</td>
<td>200</td>
<td>194</td>
</tr>
<tr>
<td>100</td>
<td>PN10,16,25,40</td>
<td>17</td>
<td>17</td>
<td>220</td>
<td>194</td>
</tr>
<tr>
<td>100</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>235</td>
<td>194</td>
</tr>
<tr>
<td>125</td>
<td>PN10,16</td>
<td>17</td>
<td>17</td>
<td>250</td>
<td>194</td>
</tr>
<tr>
<td>125</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>270</td>
<td>194</td>
</tr>
<tr>
<td>150</td>
<td>PN10,16</td>
<td>17</td>
<td>17</td>
<td>285</td>
<td>194</td>
</tr>
<tr>
<td>150</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>300</td>
<td>194</td>
</tr>
<tr>
<td>150</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>300</td>
<td>194</td>
</tr>
<tr>
<td>200</td>
<td>PN10</td>
<td>20</td>
<td>20</td>
<td>340</td>
<td>194</td>
</tr>
<tr>
<td>200</td>
<td>PN16</td>
<td>20</td>
<td>20</td>
<td>340</td>
<td>194</td>
</tr>
<tr>
<td>200</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>360</td>
<td>194</td>
</tr>
<tr>
<td>200</td>
<td>PN40</td>
<td>25</td>
<td>25</td>
<td>375</td>
<td>194</td>
</tr>
<tr>
<td>250</td>
<td>PN10</td>
<td>19</td>
<td>20</td>
<td>395</td>
<td>194</td>
</tr>
<tr>
<td>250</td>
<td>PN16</td>
<td>19</td>
<td>20</td>
<td>405</td>
<td>194</td>
</tr>
<tr>
<td>250</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>425</td>
<td>194</td>
</tr>
<tr>
<td>250</td>
<td>PN40</td>
<td>25</td>
<td>25</td>
<td>450</td>
<td>194</td>
</tr>
<tr>
<td>300</td>
<td>PN10</td>
<td>19</td>
<td>19</td>
<td>445</td>
<td>194</td>
</tr>
<tr>
<td>300</td>
<td>PN16</td>
<td>19</td>
<td>20</td>
<td>460</td>
<td>194</td>
</tr>
<tr>
<td>300</td>
<td>PN25,40</td>
<td>25</td>
<td>25</td>
<td>485</td>
<td>194</td>
</tr>
<tr>
<td>300</td>
<td>PN40</td>
<td>25</td>
<td>25</td>
<td>515</td>
<td>194</td>
</tr>
</tbody>
</table>

Every effort has been made to ensure that the information contained in this publication is accurate at the time of publishing. Crane Ltd assumes no responsibility or liability for typographical errors or omissions or for any misinterpretation of the information within the publication and reserves the right to change without notice.
Technical Information

Working Pressure Rating
Water - In accordance with the flange rating
Gas 6 bar

Vacuum Pressure
Capable of accommodating a vacuum pressure of -0.7 bar

Site Test Pressure
1.5 times working pressure for short duration (2 hours)

Angularity
Dismantling joints are in essence double flanged pipe where the flange to flange dimension can be adjusted, and therefore are not able to accommodate any angularity.

Bolt Torque/Spanner
M12; Torque 55-65Nm on every bolt
M16; Torque 95-110Nm on every bolt

Tie rods
Torque is a function of the flange connecting gasket, not supplied by Viking Johnson; consult flange gasket supplier.

Temperature Rating of Product
EPDM -20°C to +90°C
Nitrile -20°C to +90°C
For use on applications with fluctuating and / or elevated temperatures (> 60°C) may require regular maintenance to re-tighten the bolts and must be included in any maintenance schedule.

Approvals
The following water contact materials used in Dismantling Joints are approved for use with potable water:-
Rilsan Nylon 11:
> WRAS, AS/NZS 4020, DVGW, W270, ACS & KIWA
> EPDM Gaskets:
> WRAS, AS/NZS 4020

In addition to the above, the flange adaptor component in the Dismantling Joint has as a finished product KIWA certification verifying that it complies with the requirements of the Water Supply (Water Fittings) Regulations for England and Wales 1999, the Water Byelaws 2000, Scotland and the Water Regulations Northern Ireland.

Materials & Relevant Standards

Flange Drilling
BS EN1092-1
(formerly BS4504), ISO7005

Cast Flange Adaptor Body & End Rings
Ductile Iron to BS EN1563:
Symbol EN-GJS-450-10

Fabricated Flange Adaptor Body & End Rings
Rolled Steel to BS EN 10025-2:
Grade S275

Sleeve Options
> Steel Tube to BS EN10255
> Steel Tube to BS EN10216-1:
Grade P265TR1
> Rolled Steel to BS EN 10025-2:
Grade S275

Cast Flange Spigot:
Ductile Iron to BS EN1563:
Symbol EN-GJS-450-10

Fabricated Flange Spigot:
Rolled steel to BS EN10025-2:
Grade S275

Steel Spigot Options:
> Steel tube to BS EN10255
> Steel tube to BS EN10216-1:
Grade P265TR1
> Rolled steel to BS EN10025-2:
Grade S275

Gaskets
Standard:
> EPDM to BS EN681-1: Type WA
Other gasket grades are available contact Viking Johnson.

Coatings
Flange Adaptor, Spigot & End Ring:
> Rilsan Nylon 11 to
WIS 4-52-01 Part 1
Option 1 Flange Adaptor bolts & Nuts:
> Sheraplex to WIS 4-52-03
Steel Tie Rods/Nuts:
> Zn³ Zinc coated

Tie Rods, Studs, Nuts and Washers
The following two options are as standard variants:-

Option 1: Zinc Plated Steel

<table>
<thead>
<tr>
<th>Tie Rods</th>
<th>ASTM A193 (Grade B7/MB7) equivalent to BS EN10269:+A1: Name 42CrMo4 (Yield 725N/mm²)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tie Rod Nuts</td>
<td>ASTM A194 Grade 2H/M2H equivalent to BS EN20898-2: Property Class 8.00</td>
</tr>
</tbody>
</table>

Option 2: Stainless Steel

<table>
<thead>
<tr>
<th>Tie Rods</th>
<th>Stainless Steel to BS EN3506-1: Grade A4 Property Class 70 (Yield 450N/mm²)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tie Rod Nuts</td>
<td>Stainless Steel to BS EN3506-2: Grade A4 Property Class 80</td>
</tr>
</tbody>
</table>

Flange Adaptor Studs
Stainless Steel to BS EN ISO 3506-1: grade A4 property class 50

Flange Adaptor Nuts
Stainless Steel to BS EN ISO 3506-2: grade A4 property class 80

Flange Adaptor Washers
Stainless Steel to BS1449: Part 2: Grade 304S15

Every effort has been made to ensure that the information contained in this publication is accurate at the time of publishing. Crane Ltd assumes no responsibility or liability for typographical errors or omissions or for any misinterpretation of the information within the publication and reserves the right to change without notice.