Dismantling Joints DN350 to DN1600 (PN40)
Dismantling Joint
(For diameters over DN1600 contact Viking Johnson)

Flange Details
<table>
<thead>
<tr>
<th>Nom</th>
<th>Drilling</th>
<th>Flange Thickness E (mm)</th>
<th>Flange OD A (mm)</th>
<th>Nominal Length B (mm)</th>
<th>Minimum Length C (mm)</th>
<th>Maximum Length D (mm)</th>
<th>Dia x Length (mm) M33 x 520</th>
<th>No.</th>
<th>Total Weight of DJ (kg)</th>
<th>Dia x Length (mm) M36 x 540</th>
<th>No.</th>
<th>Total Weight of DJ (kg)</th>
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</table>

Note: Stainless steel tie rods cannot accommodate this working pressure so not available.

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.

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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

Materials & Relevant Standards

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

**Fabricated Flange Adaptor Body**
Rolled Steel to BS EN 10025-2:
Grade S275

**End Rings & Sleeve Options:**
➤ Rolled Steel to BS EN 10025-2:
Grade S275
➤ Rolled Steel to BS EN 10025-2:
Grade S355
(depending on section)

**Flange**
Rolled Steel to BS EN 10025-2:
Grade S275

**Spigot Options:**
➤ Steel tube to BS10216-1:
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**

**Tie Rods**
ASTM A193 (Grade B7/MB7)
equivalent to BS EN10269:+A1:
Name 42CrMo4 (Yield 725N/mm²)

**Tie Rod Nuts**
ASTM A194 Grade 2H/M2H
equivalent to BS EN20898-2:
Property Class 8.00

**Flange Adaptor Studs**
Steel to BS EN ISO988-1:
Property Class 4.8

**Flange Adaptor Nuts**
Steel to BS4190: Grade 4

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

**Option 2: Stainless Steel**

**Tie Rods**
Stainless Steel to BS EN3506-1:
Grade A4 Property Class 70
(Yield 450N/mm²)

**Tie Rod Nuts**
Stainless Steel to BS EN3506-2:
Grade A4 Property Class 80

**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

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