

ALL PRODUCT DIMENSIONS ARE BEFORE COATING

REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

MATERIAL SPECIFICATION

END RING (Part 1)
STEEL to
BS EN10025-2:2004 GRADE S275JR
CENTRE SLEEVE (Part 2)
STEEL to
BS EN10025-2:2004 GRADE S275JR
GASKET (Part 3)
RUBBER 80 HARDNESS
Grade to suit service
BOLTS (Part 4)
STEEL BS EN ISO898-1:1999
PROPERTY CLASS 4.8
NUTS (Part 5)
STEEL BS4190:2001
GRADE 4
WASHERS (Part 6)
STAINLESS STEEL BS1449:PART 2:1983
GRADE 304S15

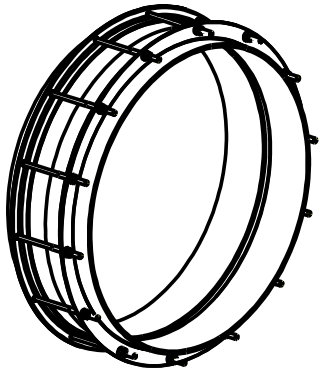
FINISH SPECIFICATION

NOTES

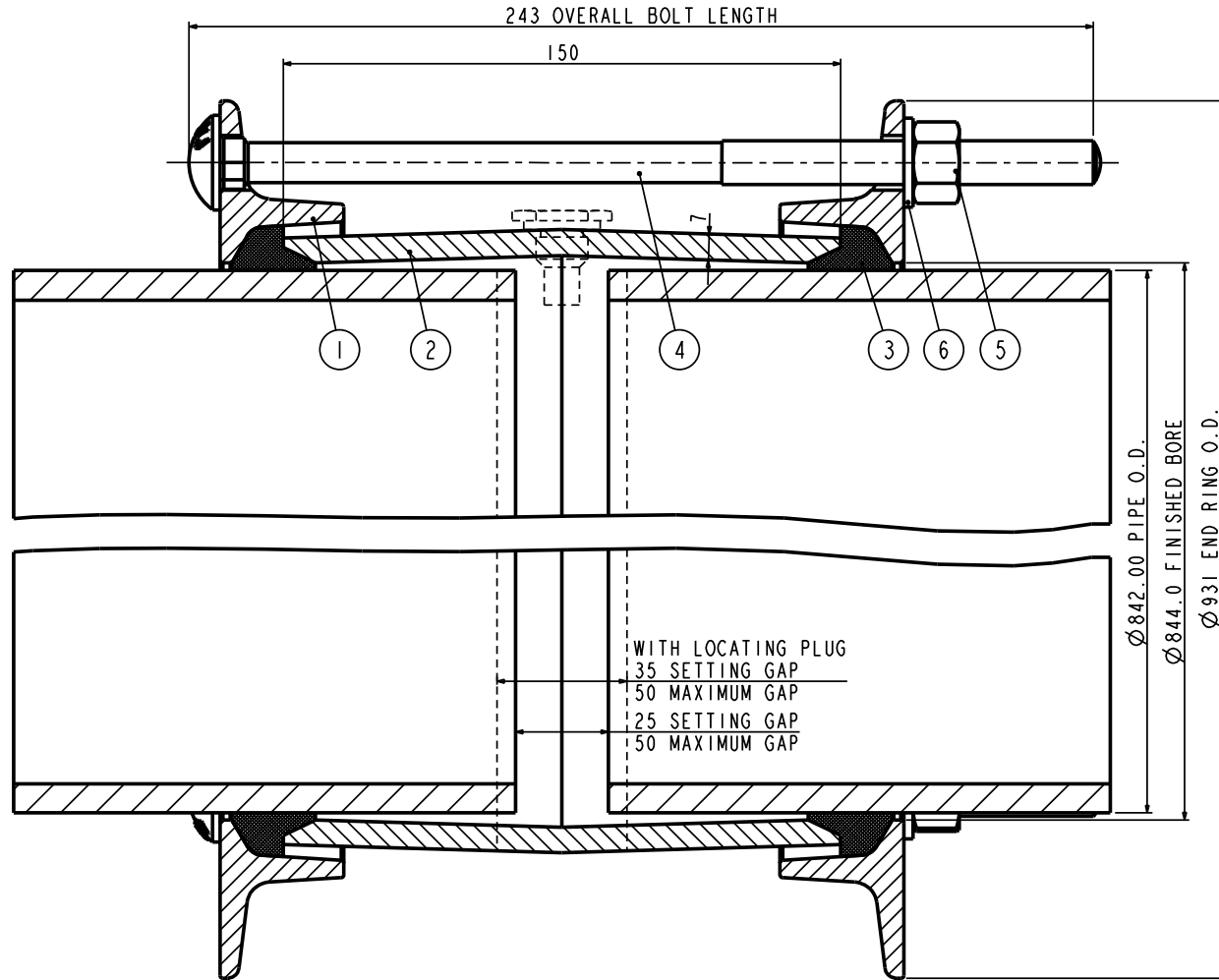
Locating Plugs/Pin Register.
If Locating Plugs/Pins are required,
3 Plugs/Pins are to be supplied.

BOLT TORQUES

PIPE MATERIAL	Nm	lbf ft
GRP/GRP	27-33	20-25
GRP/ALL OTHERS	27-33	20-25
ALL OTHERS	54-65	70-90



ISOMETRIC VIEW



PIPE O.D.	PIPE MATERIAL	PIPE TOLERANCE		BOLTS NO-SIZE	GASKET MOULD	WORKING PRESSURE	TEST PRESSURE	WEIGHT KG	ASSEMBLY DRG NO
		+	-						
842.00	DUCTILE IRON	1.00	4.50	14-M12x235	J65LS	18.9bar	28.4bar	44.6	7829_409

OVERALL DIMENSIONS DRAWING
FOR REFERENCE ONLY
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CRANE A Crane Co Company

OVERALL DIMENSIONS OF
VIKING JOHNSON COUPLING ASSEMBLY
'LO2' SECTION
FOR 842.00mm O.D. PIPE

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



DRAWN	AUTO	SCALE	N.T.S.
DATE	11/12/07	GENERIC	7829

DRG NO SKP7-1