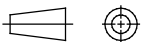


ISSUE	ALTERATION	DATE & INITIAL	ATO NO
B	REDRAWN	12:11:99PN	

SPECIFICATION DRAWING ONLY. NOT TO BE USED FOR INSPECTION PURPOSES.



DO NOT SCALE

ALL PRODUCT DIMENSIONS ARE BEFORE COATING

FOR HARNESSING ARRANGEMENT THIS PRODUCT WILL REQUIRE NOTCHING, AS SHOWN UN-NOTCHED END RINGS WILL BE SUPPLIED, UNLESS REQUESTED OTHERWISE.

NOTCHING REQUIREMENTS FOR CAST & DUCTILE IRON PIPES		
FLANGE HOLES	MINIMUM	CALCULATED MINIMUM
ALL FLANGE DRILLINGS	HALF THE NUMBER OF FLANGE HOLES	CALCULATED USING A YIELD OF 725N/mm ²

NOTCHING REQUIREMENTS FOR ALL OTHER PIPE MATERIALS		
FLANGE HOLES	MINIMUM	CALCULATED MINIMUM
FLANGES WITH 8 HOLES OR LESS	4	CALCULATED USING A YIELD OF 725N/mm ²
FLANGES WITH MORE THAN 8 HOLES	QUARTER THE NUMBER OF FLANGE HOLES	CALCULATED USING A YIELD OF 725N/mm ²

MATERIAL SPECIFICATION

FLANGE (Part 1)
Steel to BS EN10025-2:Grade S275JR

PART CENTRE SLEEVE (Part 2)
Steel to BS EN10025-2:Grade S275JR

END RING (Part 3)
Steel to BS EN10025-2:Grade S275JR

GASKET (Part 4)
80 IRHD Moulded Compound
Grade to suit service

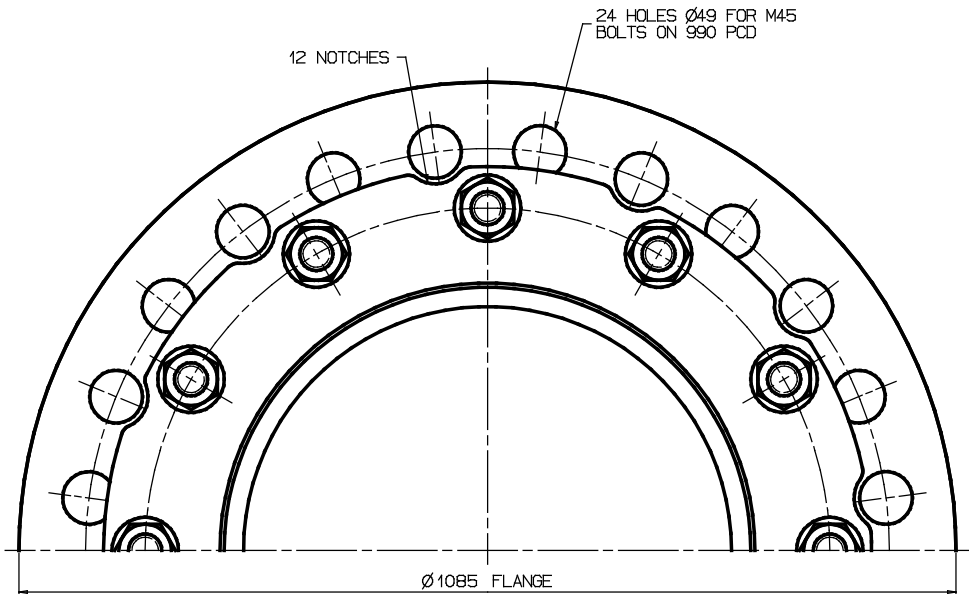
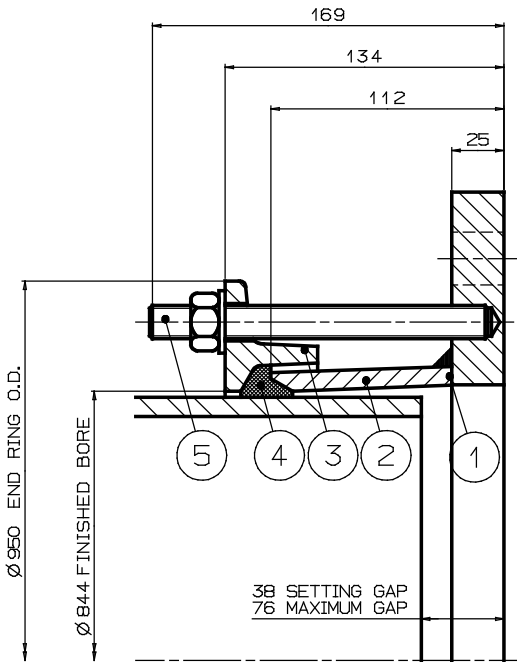
STUDS, NUTS & WASHERS (Part 5)

STUDS
Steel to BS EN ISO898-1:
Property Class 4.8

NUTS
Steel to BS4190:Grade 4

WASHERS
Stainless Steel to BS1449:Part 2
Grade 304S15

FINISH SPECIFICATION



STUD TORQUES		
PIPE MATERIAL	Nm	lbf ft
GRP	47-60	35-45
ALL OTHERS	95-120	70-90

PIPE			FLANGE	STUDS	GASKET	END RING	WORKING	TEST	SECTION	WEIGHT	ASSEMBLY
O.D.	MATERIAL	TOLERANCE	DRILLING		MOULD	NOTCHES	PRESSURE	PRESSURE		KG	DRAWING NO
842	DUCTILE IRON	+1.0 -4.5	800 PN25	12-M16x160	J65LS	12	25bar	37.5bar	YF2	100	7880/1

5	STUDS, NUTS & WASHERS		12
4	GASKET		1
3	END RING		1
2	SLEEVE		1
1	FLANGE		1
PART	DESCRIPTION	DRG NO	NO OFF

LIST OF PARTS

OVERALL DIMENSIONS FOR REFERENCE ONLY
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CRANE A Crane Co Company

TITLE

**OVERALL DIMENSIONS OF
V.J. FLANGE ADAPTOR
FOR 842mm O.D. PIPES
800 NOM PN25 FLANGE**



DRAWN	CAD	DATE
SCALE N.T.S.	P.N.	29:9:97 APPROVED
CHECKED		

DRG NO. SKC22892-2

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