

# 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

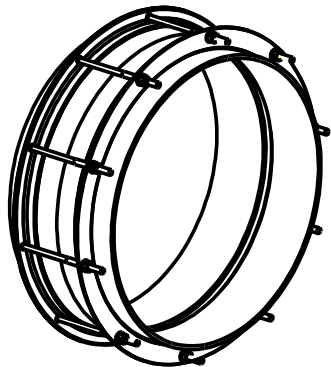
## FINISH SPECIFICATION

## NOTES

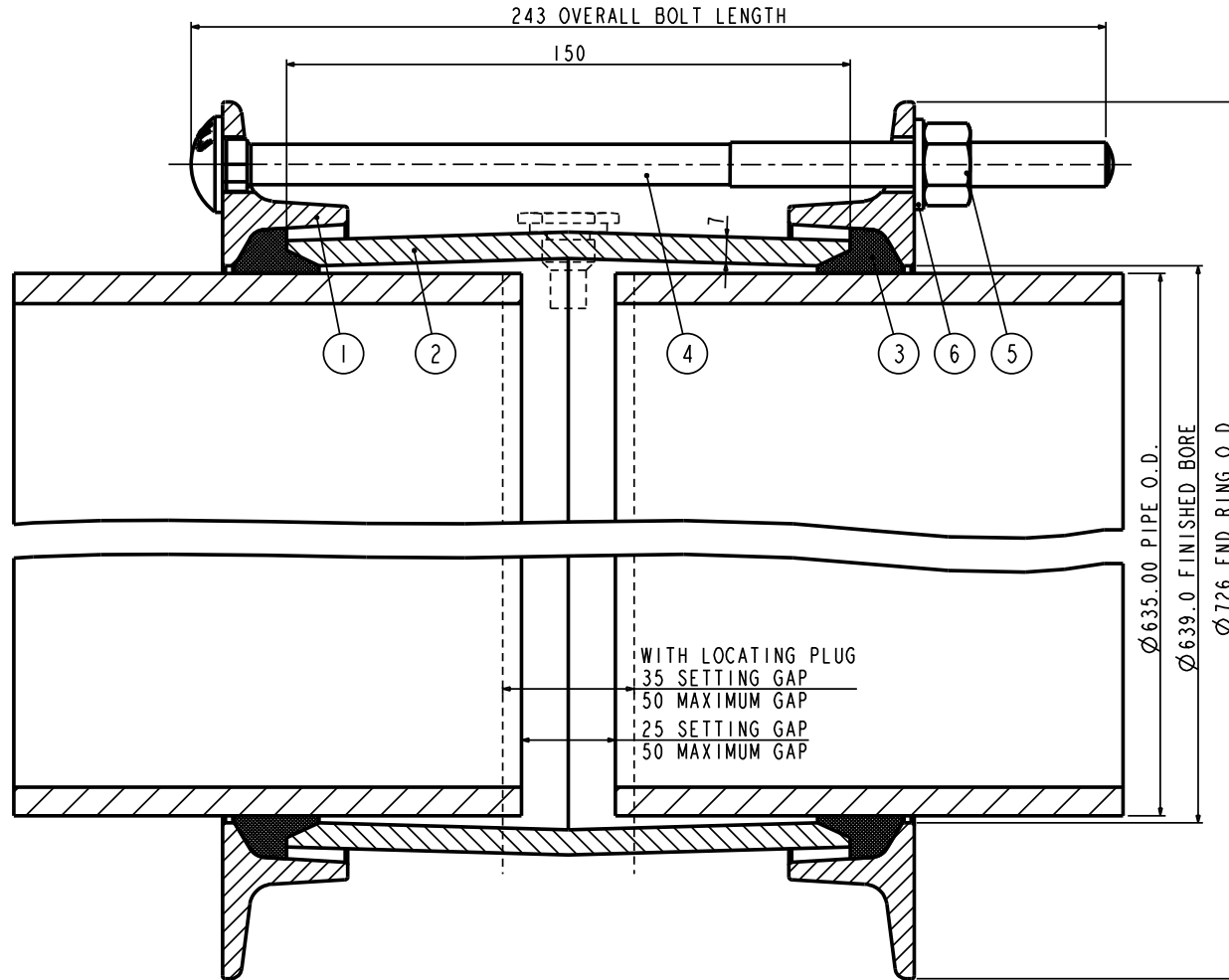
Locating Plugs/Pin Register.  
If Locating Plugs/Pins are required,  
3 Plugs/Pins are to be supplied.

## 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
		+	-						
635.00	DUCTILE IRON	3.20	4.50	10-M12x235	J61LS	22.0bar	33.0bar	33.9	7829_347

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 635.00mm O.D. PIPE

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



DRAWN	AUTO	SCALE	N.T.S.
DATE	12/02/08	GENERIC	7829

DRG NO SKP323-1