ALL PRODUCT DIMENSIONS ARE BEFORE COATING

## MATERIAL SPECIFICATION

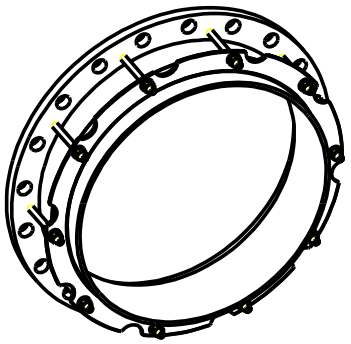
FLANGE (Part 1)
STEEL to
BS EN10025-2:2004 GRADE S275JR
END RING (Part 2)
STEEL to
BS EN10025-2:2004 GRADE S275JR
CENTRE SLEEVE (Part 3)
STEEL to
BS EN10025-2:2004 GRADE S275JR
GASKET (Part 4)
RUBBER 80 HARDNESS
Grade to suit service
STUDS (Part 5)
STEEL to
BS EN ISO898-1:1999 PROPERTY CLASS 4.8
NUTS (Part 6)
STEEL to
BS4190:2001 GRADE 4
WASHERS (Part 7)
STAINLESS STEEL to
BS1449:PART 2:1983 GRADE 304S15

## FINISH SPECIFICATION

## NOTES

### STUD TORQUES

| PIPE MATERIAL | Nm | lbf ft |
|---|---|---|
| GRP | 27-33 | 20-25 |
| ALL OTHERS | 54-65 | 40-50 |



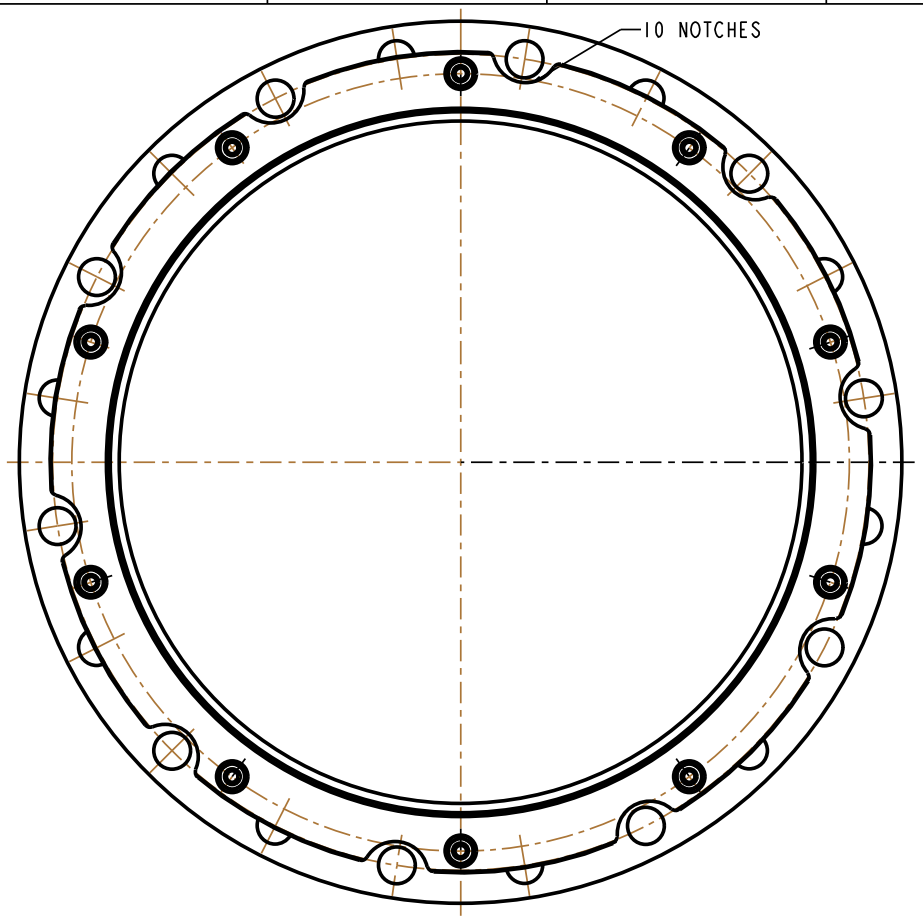
ISOMETRIC VIEW

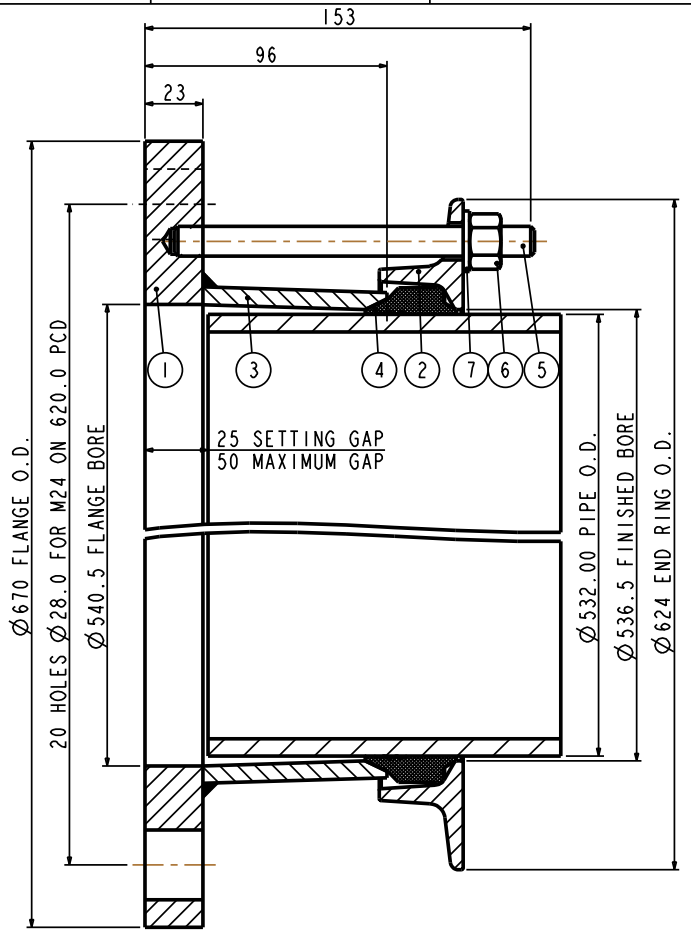
REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

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

| NOTCHING REQUIREMENTS FOR CAST AND DUCTILE IRON PIPE MATERIALS | | | NOTCHING REQUIREMENTS FOR ALL OTHER PIPE MATERIALS | | |
|---|---|---|---|---|---|
| FLANGE HOLES | MINIMUM | CALCULATED MINIMUM | FLANGE HOLES | MINIMUM | CALCULATED MINIMUM |
| ALL FLANGE DRILLINGS | HALF THE NUMBER OF FLANGE HOLES | CALCULATED USING A YIELD OF 725N/mm² | FLANGES WITH 16 HOLES OR LESS | 4 | CALCULATED USING A YIELD OF 725N/mm² |
| | | | FLANGES WITH MORE THAN 16 HOLES | QUARTER THE NUMBER OF FLANGE HOLES | CALCULATED USING A YIELD OF 725N/mm² |




| PIPE O.D. | PIPE MATERIAL | PIPE TOLERANCE + | PIPE TOLERANCE - | FLANGE DRILLING | STUDS NO-SIZE | GASKET MOULD | NO OF NOTCHES | WORKING PRESSURE | TEST PRESSURE | SECTION | WEIGHT KG | ASSEMBLY DRG NO |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 532.00 | DUCTILE IRON | 3.00 | 4.00 | 500PN10 | 10-M12x140 | J58LS | 10 | 10.0bar | 15.0bar | L02 | 34.3 | 7600_36 |

OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY
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CRANE A Crane Co Company ©

# OVERALL DIMENSIONS OF VIKING JOHNSON FLANGE ADAPTOR L02 SECTION FOR 532.00mm PIPE O.D. WITH A 500PN10 FLANGE DRILLING

RELEASE LEVEL: Manufacture

SHEET 1 OF 1

VIKING JOHNSON
World leaders in pipe joints and repair products

| | | | |
|---|---|---|---|
| DRAWN | AUTO | SCALE | 0.143 |
| DATE | 11/02/08 | GENERIC | 7600 |

DRG NO SKP1247-1