ALL PRODUCT DIMENSIONS ARE BEFORE COATING

| MATERIAL SPECIFICATION | REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES | | | ⊏⊐ ⊕ | DO NOT SCALE |

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	47-60	35-45
ALL OTHERS	95-120	70-90

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/mm^2	FLANGES WITH 16 HOLES OR LESS	4	CALCULATED USING A YIELD OF 725N/mm^2
			FLANGES WITH MORE THAN 16 HOLES	QUARTER THE NUMBER OF FLANGE HOLES	CALCULATED USING A YIELD OF 725N/mm^2

14 NOTCHES

Ø1230.0 FLANGE O.D.
28 HOLES Ø37.0 FOR M33 BOLTS ON 1160.0 PCD
Ø1056.0 FLANGE BORE

169
112
25

32 SETTING GAP
76 MAXIMUM GAP

Ø1048.00 PIPE O.D.
Ø1050.0 FINISHED BORE
Ø1156 END RING O.D.

PIPE O.D.	PIPE MATERIAL	PIPE TOLERANCE		FLANGE DRILLING	STUDS NO-SIZE	GASKET MOULD	NO OF NOTCHES	WORKING PRESSURE	TEST PRESSURE	SECTION	WEIGHT KG	ASSEMBLY DRG NO
		+	-									
1048.00	DUCTILE IRON	1.00	5.00	1000PN10	14-M16x160	J7ILS	14	10.0bar	15.0bar	YF2	102.9	7880_17

ISOMETRIC VIEW

CRANE   A Crane Co Company   ©

OVERALL DIMENSIONS OF
VIKING JOHNSON FLANGE ADAPTOR
YF2 SECTION
FOR A 1048.00mm PIPE O.D.
WITH A 1000PN10 FLANGE DRILLING

RELEASE LEVEL: Manufacture

SHEET 1 OF 1

VIKING JOHNSON
World leaders in pipe joints and repair products

DRAWN	AUTO	SCALE	0.476
DATE	15/02/08	GENERIC	7880

DRG NO SKP656-1