

# ALL PRODUCT DIMENSIONS ARE BEFORE COATING

MATERIAL SPECIFICATION	REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES						DO NOT SCALE																																							
<b>FLANGE (Part 1)</b> STEEL to BS EN10025-2:2004 GRADE S275JR <b>END RING (Part 2)</b> STEEL to BS EN10025-2:2004 GRADE S275JR <b>CENTRE SLEEVE (Part 3)</b> STEEL to BS EN10025-2:2004 GRADE S275JR <b>GASKET (Part 4)</b> RUBBER 80 HARDNESS Grade to suit service <b>STUDS (Part 5)</b> STEEL to BS EN ISO898-1:1999 PROPERTY CLASS 4.8 <b>NUTS (Part 6)</b> STEEL to BS4190:2001 GRADE 4 <b>WASHERS (Part 7)</b> STAINLESS STEEL to BS1449:PART 2:1983 GRADE 304S15	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 <sup>2</sup>	FLANGES WITH 16 HOLES OR LESS	4	CALCULATED USING A YIELD OF 725N/mm <sup>2</sup>																																									
			FLANGES WITH MORE THAN 16 HOLES	QUARTER THE NUMBER OF FLANGE HOLES	CALCULATED USING A YIELD OF 725N/mm <sup>2</sup>																																									
FINISH SPECIFICATION																																														
NOTES																																														
STUD TORQUES																																														
PIPE MATERIAL	Nm	lbf ft																																												
GRP	27-33	20-25																																												
ALL OTHERS	54-65	40-50																																												
ISOMETRIC VIEW	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>PIPE O.D.</th> <th>PIPE MATERIAL</th> <th colspan="2">PIPE TOLERANCE</th> <th>FLANGE DRILLING</th> <th>STUDS NO-SIZE</th> <th>GASKET MOULD</th> <th>NO OF NOTCHES</th> <th>WORKING PRESSURE</th> <th>TEST PRESSURE</th> <th>SECTION</th> <th>WEIGHT KG</th> <th>ASSEMBLY DRG NO</th> </tr> <tr> <td></td> <td></td> <td style="text-align: center;">+</td> <td style="text-align: center;">-</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </thead> <tbody> <tr> <td style="text-align: center;">355.60</td> <td style="text-align: center;">STEEL</td> <td style="text-align: center;">1.60</td> <td style="text-align: center;">1.60</td> <td style="text-align: center;">350PN16</td> <td style="text-align: center;">8-M12x140</td> <td style="text-align: center;">J51LS</td> <td style="text-align: center;">4</td> <td style="text-align: center;">16.0bar</td> <td style="text-align: center;">24.0bar</td> <td style="text-align: center;">L02</td> <td style="text-align: center;">24.1</td> <td style="text-align: center;">7600_1</td> </tr> </tbody> </table>						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			+	-										355.60	STEEL	1.60	1.60	350PN16	8-M12x140	J51LS	4	16.0bar	24.0bar	L02	24.1	7600_1	
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	OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY VIKING JOHNSON RESERVE THE RIGHT TO AMEND DETAILS WITHOUT PRIOR NOTIFICATION																																													
	OVERALL DIMENSIONS OF VIKING JOHNSON FLANGE ADAPTOR L02 SECTION FOR 355.60mm PIPE O.D. WITH A 350PN16 FLANGE DRILLING																																													
	<small>This drawing is the exclusive property of VIKING JOHNSON and is confidential and must not be reproduced or disclosed to a third party without written consent. It must be used only for the purpose which it has been issued and is returnable on request.</small>																																													
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