

# ALL PRODUCT DIMENSIONS ARE BEFORE COATING

REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

## MATERIAL SPECIFICATION

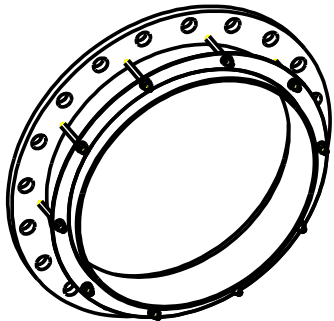
**FLANGE (Part 1)**  
STEEL to  
BS EN10025-2:2004 GRADE S275JR  
**END RING (Part 2)**  
STEEL to  
BS EN10025-2:2004 GRADE S275JR  
**CENTRE SLEEVE (Part 3)**  
STEEL to  
BS EN10025-2:2004 GRADE S275JR  
**GASKET (Part 4)**  
RUBBER 80 HARDNESS  
Grade to suit service  
**STUDS (Part 5)**  
STEEL 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

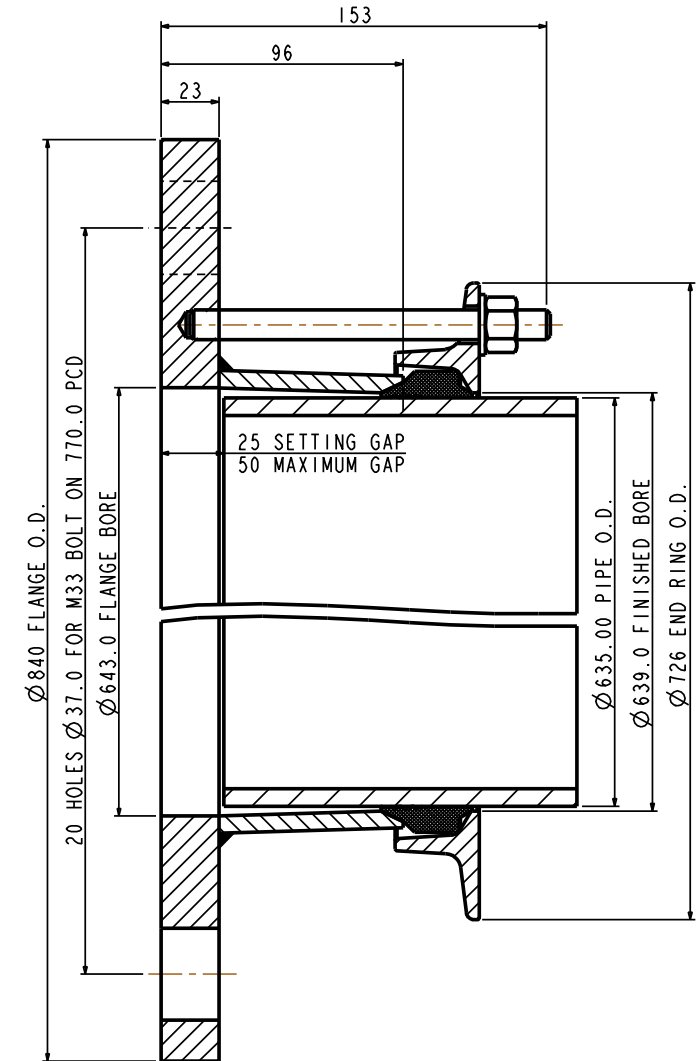
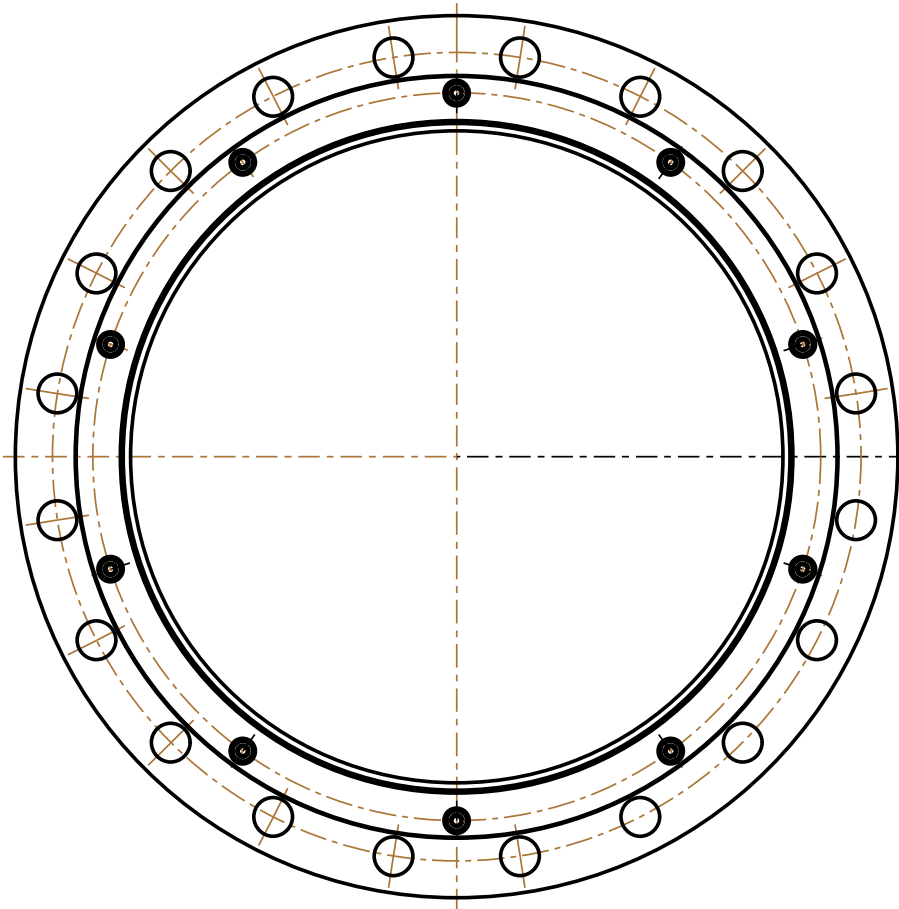
## NOTES

### STUD TORQUES

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



ISOMETRIC VIEW



| 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 |
|-----------|---------------|----------------|------|-----------------|---------------|--------------|---------------|------------------|---------------|---------|-----------|-----------------|
|           |               | +              | -    |                 |               |              |               |                  |               |         |           |                 |
| 635.00    | DUCTILE IRON  | 3.20           | 4.50 | 600PN16         | 10-M12x140    | J61LS        | NOT REQUIRED  | 16.0bar          | 24.0bar       | L02     | 54.5      | 7600_40         |

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 635.00mm PIPE O.D.  
WITH A 600PN16 FLANGE DRILLING

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



|       |          |         |       |
|-------|----------|---------|-------|
| DRAWN | AUTO     | SCALE   | 0.143 |
| DATE  | 12/02/08 | GENERIC | 7600  |

DRG NO SKP703-1