

# 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>738.00</td> <td>DUCTILE IRON</td> <td style="text-align: center;">+</td> <td style="text-align: center;">-</td> <td>700PN16</td> <td>12-M12x140</td> <td>J63LS</td> <td>12</td> <td>16.0bar</td> <td>24.0bar</td> <td>L02</td> <td>53.1</td> <td>7600_45</td> </tr> </thead> </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	738.00	DUCTILE IRON	+	-	700PN16	12-M12x140	J63LS	12	16.0bar	24.0bar	L02	53.1	7600_45	
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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 738.00mm PIPE O.D. WITH A 700PN16 FLANGE DRILLING																														
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.			RELEASE LEVEL: Manufacture						<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="font-size: x-small;">DRAWN</td> <td style="font-size: x-small;">AUTO</td> <td style="font-size: x-small;">SCALE</td> <td style="font-size: x-small;">0.143</td> </tr> <tr> <td style="font-size: x-small;">DATE</td> <td style="font-size: x-small;">26/03/08</td> <td style="font-size: x-small;">GENERIC</td> <td style="font-size: x-small;">7600</td> </tr> </table>			DRAWN	AUTO	SCALE	0.143	DATE	26/03/08	GENERIC	7600														
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CRANE A Crane Co Company			SHEET 1 OF 1						DRG NO SKP867-1																								