

ALL PRODUCT DIMENSIONS ARE BEFORE COATING

MATERIAL SPECIFICATION REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES  DO NOT SCALE

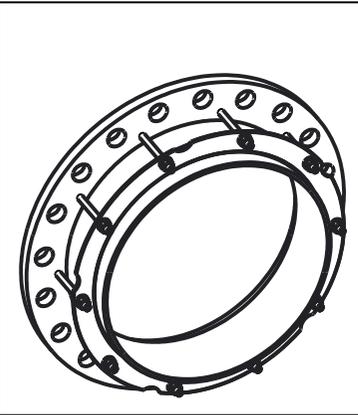
FLANGE (Part 1)
 STEEL to
 BS EN10025-2 GRADE S275JR
END RING (Part 2)
 STEEL to
 BS EN10025-2 GRADE S275JR
CENTRE SLEEVE (Part 3)
 STEEL to
 BS EN10025-2 GRADE S275JR
GASKET (Part 4)
 RUBBER 80 HARDNESS
 Grade to suit service
STUDS (Part 5)
 STEEL to
 BS EN ISO898-1 PROPERTY CLASS 4.8
NUTS (Part 6)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

FINISH SPECIFICATION

NOTES

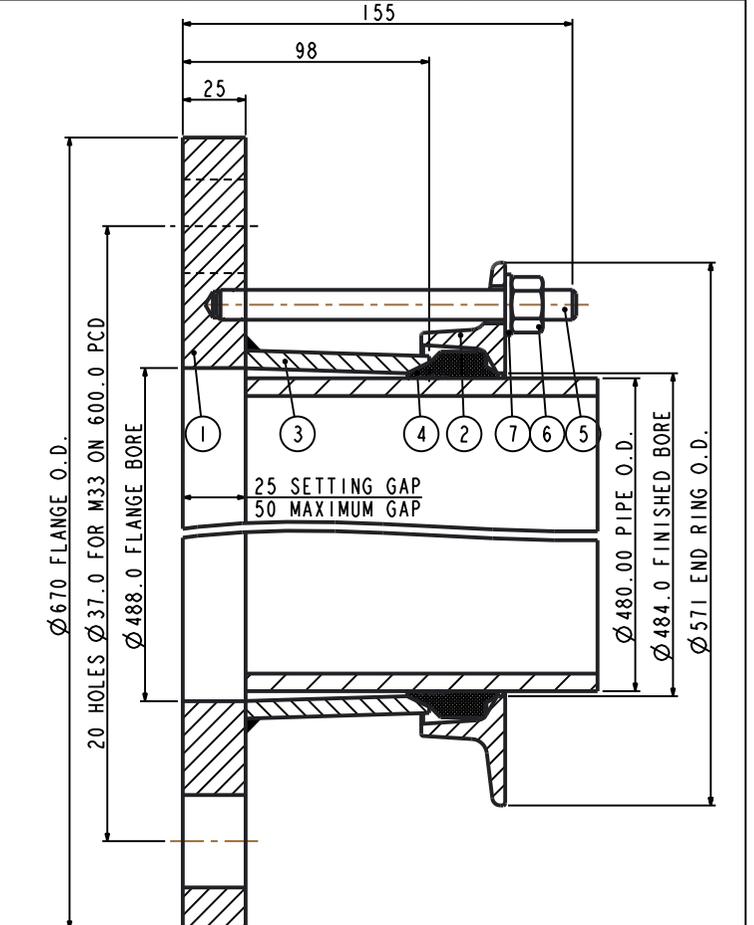
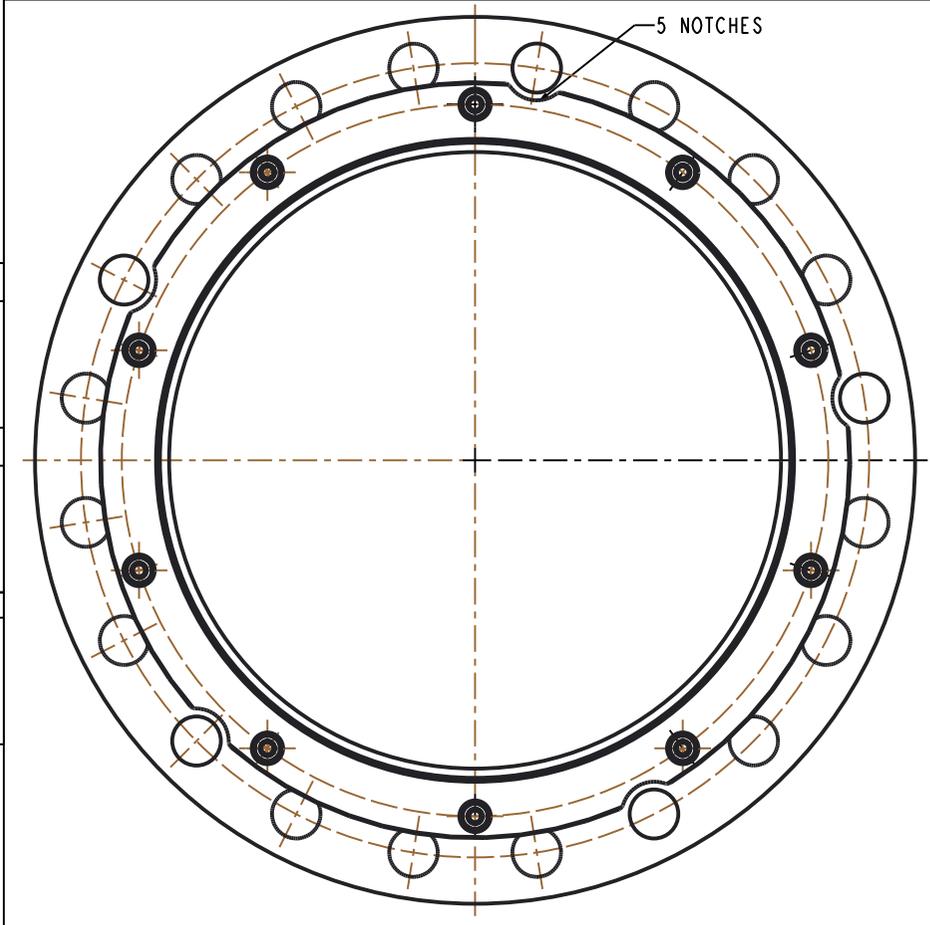
STUD TORQUES

Torque to 55-65Nm or 40-50 lbf ft



ISOMETRIC VIEW

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



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
		+	-									
480.00	STEEL	1.60	1.60	450PN25	10-M12x140	J56LS	5	25.0bar	37.5bar	L02	41.5	7600_168

OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY
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OVERALL DIMENSIONS OF
VIKING JOHNSON FLANGE ADAPTOR
 L02 SECTION
 FOR 480.00mm PIPE O.D.
 WITH A 450PN25 FLANGE DRILLING

RELEASE LEVEL: Released



DRAWN	AUTO	SCALE	0.143
DATE	14/03/19	GENERIC	7600_O.DIMS.1

DRG NO SKP13053-1