

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 EN10025-2:2004 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	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			
FINISH SPECIFICATION								
NOTES								
STUD TORQUES								
PIPE MATERIAL	Nm	lbf ft						
GRP	27-33	20-25						
ALL OTHERS	54-65	40-50						
ISOMETRIC VIEW	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 532.00mm PIPE O.D. WITH A 500PN25 FLANGE DRILLING							
OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY VIKING JOHNSON RESERVE THE RIGHT TO AMEND DETAILS WITHOUT PRIOR NOTIFICATION								
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DRAWN: AUTO SCALE: 0.143 DATE: 30/10/08 GENERIC: 7600	RELEASE LEVEL: Manufacture						SHEET 1 OF 1	DRG NO SKP851-1