

ALL PRODUCT DIMENSIONS ARE BEFORE COATING

REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

MATERIAL SPECIFICATION

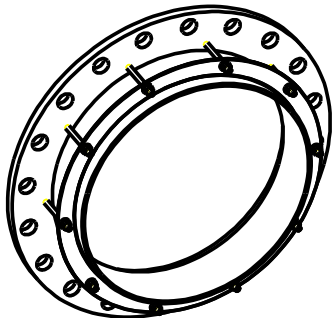
FLANGE (Part 1)
STEEL to
BS EN10025-2:2004 GRADE S275JR
END RING (Part 2)
STEEL to
BS EN10025-2:2004 GRADE S275JR
CENTRE SLEEVE (Part 3)
STEEL to
BS EN10025-2:2004 GRADE S275JR
GASKET (Part 4)
RUBBER 80 HARDNESS
Grade to suit service
STUDS (Part 5)
STEEL to
BS EN ISO898-1:1999 PROPERTY CLASS 4.8
NUTS (Part 6)
STEEL to
BS4190:2001 GRADE 4
WASHERS (Part 7)
STAINLESS STEEL to
BS1449:PART 2:1983 GRADE 304S15

FINISH SPECIFICATION

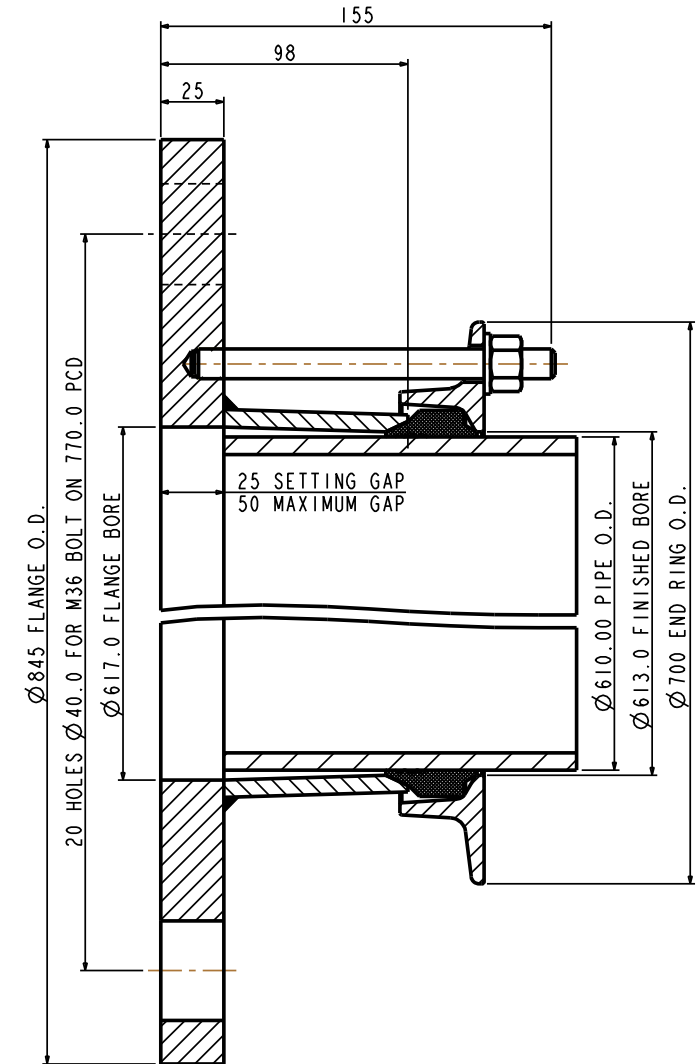
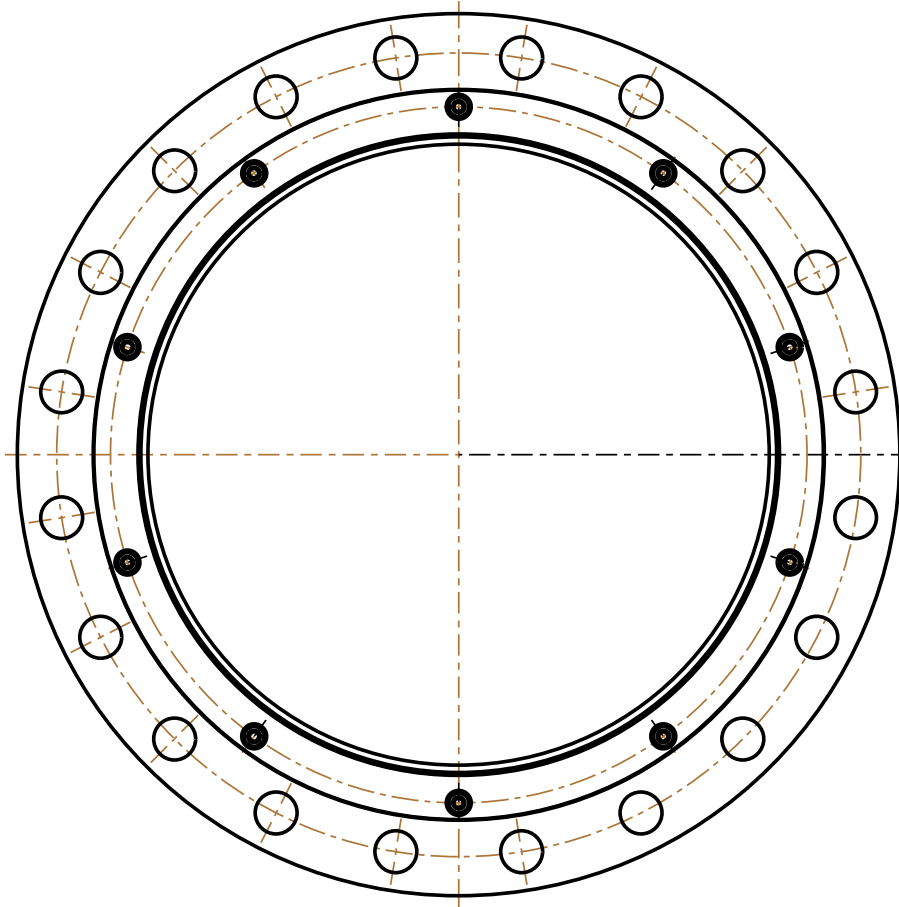
NOTES

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
		+	-									
610.00	STEEL	1.60	1.60	600PN25	10-M12x140	J60LS	NOT REQUIRED	25.0bar	37.5bar	L02	62.7	7600_186

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 610.00mm PIPE O.D.
WITH A 600PN25 FLANGE DRILLING

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



DRAWN	AUTO	SCALE	0.143
DATE	21/07/08	GENERIC	7600

DRG NO SKP910-1