

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 GRADE S275JR

END RING (Part 2)
STEEL to
BS EN10025-2 GRADE S275JR

CENTRE SLEEVE (Part 3)
STEEL to
BS EN10025-2 GRADE S355JR

GASKET (Part 4)
RUBBER 70 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

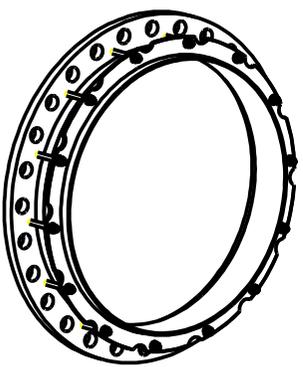
WASHERS (Part 7)
STAINLESS STEEL to
BS1449:PART 2 GRADE 304S15

FINISH SPECIFICATION

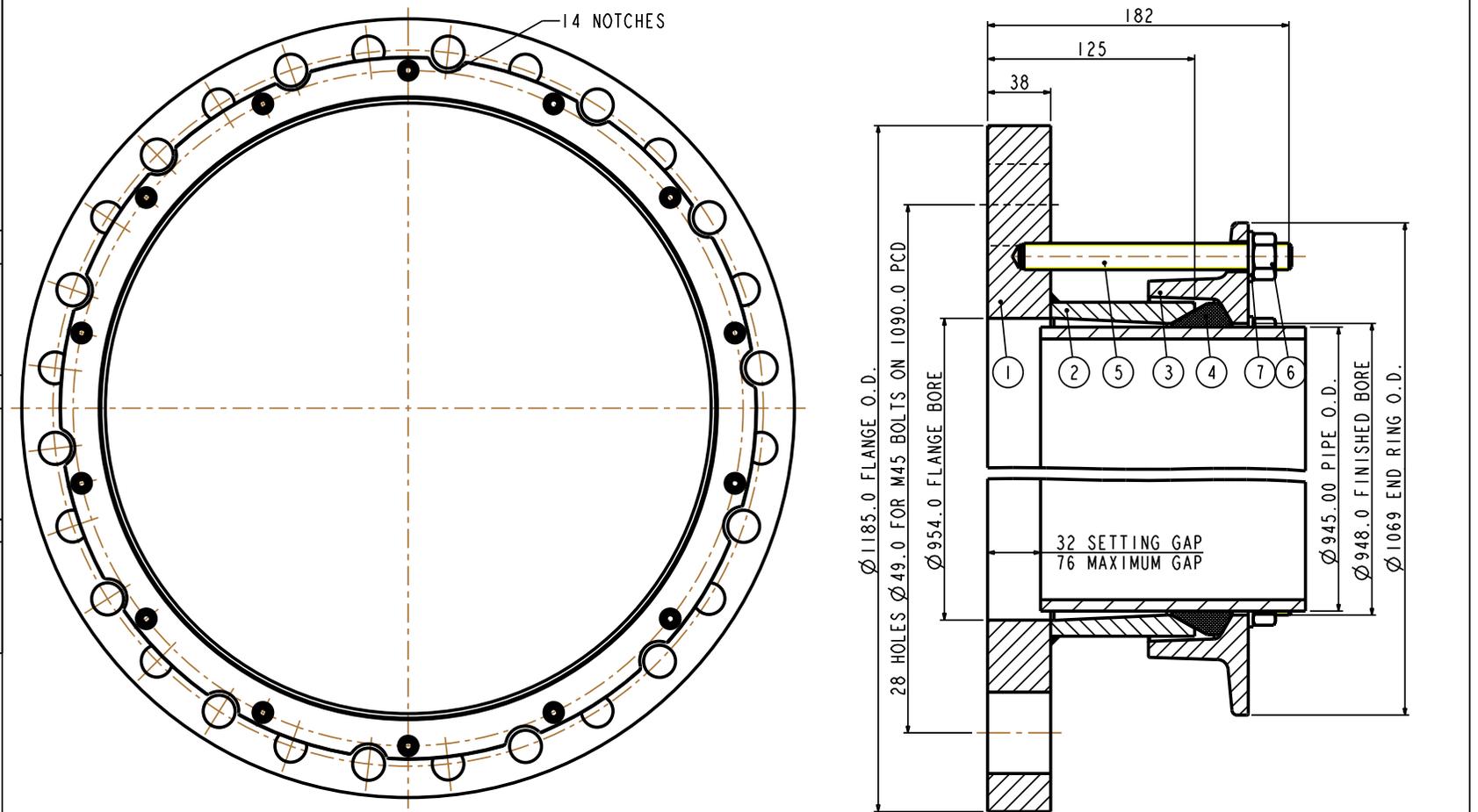
NOTES

STUD TORQUES
Torque to 95-120Nm or 70-90 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
		+	-									
945.00	DUCTILE IRON	1.00	5.00	900PN25	14-M16x160	J118M	14	25.0bar	37.5bar	A2E	156.1	6175_167

OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY
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CRANE A Crane Co Company

OVERALL DIMENSIONS OF
VIKING JOHNSON FLANGE ADAPTOR
A2E SECTION
FOR A 945.00mm PIPE O.D.
WITH A 900PN25 FLANGE DRILLING

RELEASE LEVEL: Manufacture

VIKING JOHNSON
World leaders in pipe joints and repair products

DRAWN	AUTO	SCALE	0.476
DATE	03/06/16	GENERIC	6175_A2E_ODIMS.1

DRG NO SKP2422-1