ALL PRODUCT DIMENSIONS ARE BEFORE COATING

MATERIAL SPECIFICATION

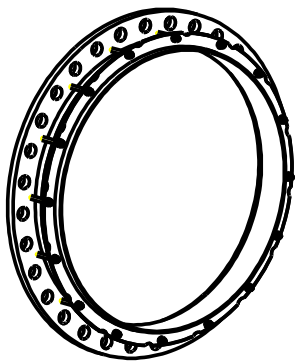
FLANGE (Part 1)
STEEL to
BS EN10025-2:2004 GRADE S275JR
END RING (Part 2)
STEEL to
BS EN10025-2:2004 GRADE S275JR
CENTRE SLEEVE (Part 3)
STEEL to
BS EN10025-2:2004 GRADE S355JR
GASKET (Part 4)
RUBBER 70 HARDNESS
Grade to suit service
STUDS (Part 5)
STEEL to
BS EN ISO898-1:2009 PROPERTY CLASS 4.8
NUTS (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

Torque to 95-120Nm or 70-90 lbf ft



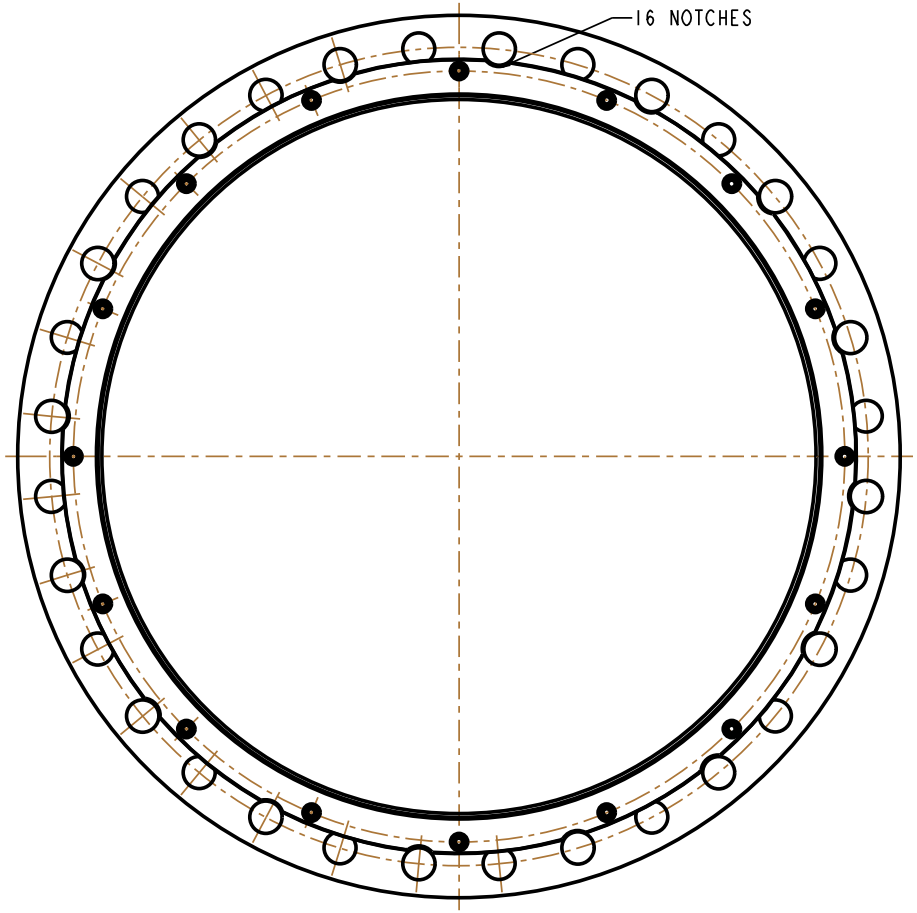
ISOMETRIC VIEW

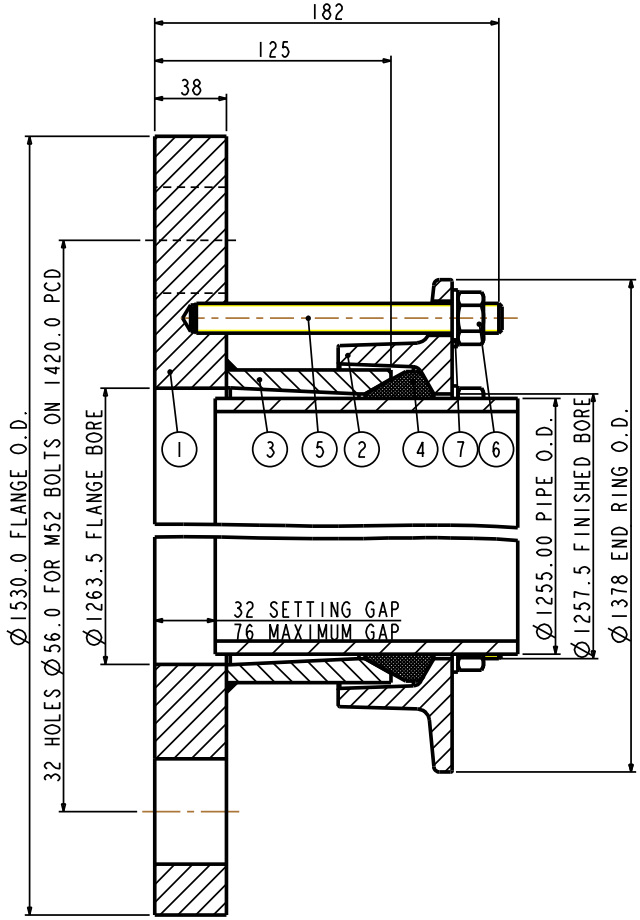
REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

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/mm²	FLANGES WITH 16 HOLES OR LESS	4	CALCULATED USING A YIELD OF 725N/mm²
			FLANGES WITH MORE THAN 16 HOLES	QUARTER THE NUMBER OF FLANGE HOLES	CALCULATED USING A YIELD OF 725N/mm²





PIPE O.D.	PIPE MATERIAL	PIPE TOLERANCE +	PIPE TOLERANCE -	FLANGE DRILLING	STUDS NO-SIZE	GASKET MOULD	NO OF NOTCHES	WORKING PRESSURE	TEST PRESSURE	SECTION	WEIGHT KG	ASSEMBLY DRG NO
1255.00	DUCTILE IRON	1.00	6.00	1200PN25	16-M16x160	J122M	16	25.0bar	37.5bar	A2E	224.8	6175_296

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 1255.00mm PIPE O.D. WITH A 1200PN25 FLANGE DRILLING

RELEASE LEVEL: Manufacture

SHEET 1 OF 1

VIKING JOHNSON
World leaders in pipe joints and repair products

DRAWN	AUTO	SCALE	0.476
DATE	09/02/12	GENERIC	6175_A2E_ODIMS_1

DRG NO SKP1576-1