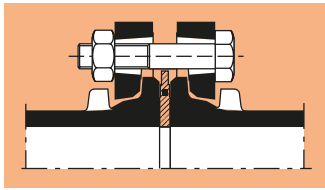
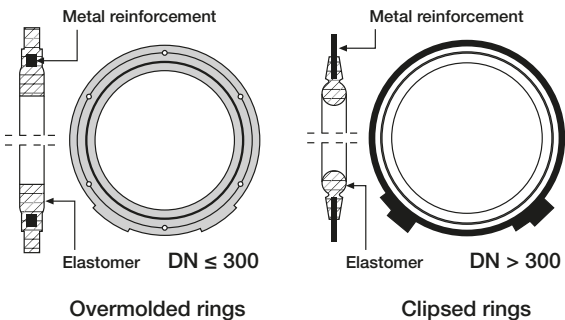


Flanged joint



The contractor is responsible for analyzing and eliminating any risks during installation (especially the use of personal protective equipment).

1 METAL-REINFORCED GASKETS

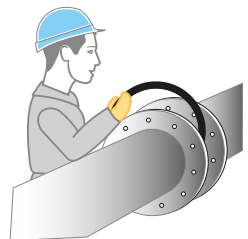


2 CLEAN AND ALIGN THE FLANGES

- **Check** the appearance and cleanliness of the flange and flange gasket
- **Align** the parts to be mounted.
- **Leave** a large enough **gap** for the flange gasket between the two flanges.

Flange gasket thickness:

DN ≤ 300: 10 mm; DN ≥ 300: 16 mm



Flanged joint

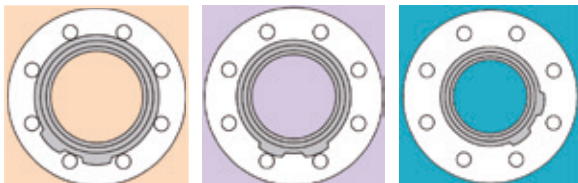
3 POSITION THE REINFORCED GASKET

Center the reinforced gasket according to the method specified in the tables:

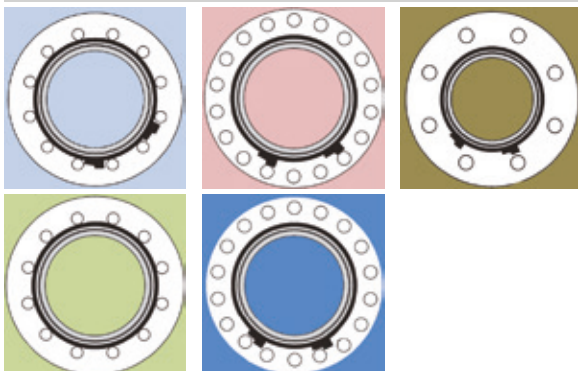
DN	PN 10	PN 16	PN 25	PN 40	PN 63
40					
50					
60					
65					
80					
100					
125					
150					
200					
250					
300					
350					
400					
450					
500					
600					
700					
800					
900					
1000					
1100					
1200					
1400					
1500					
1600					
1800					
2000					

Gasket resting on the bolts	Pins resting on the lower bolts	Visual centering
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Overmolded gaskets DN ≤ 300



Clipped gaskets DN > 300

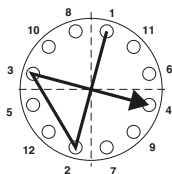


Flanged joint

4 TIGHTEN THE BOLTS

Insert the bolts.

Tighten the bolts in the order indicated in the diagram opposite and according to the recommended torque values.



Do not exert any tractive force on the junction when tightening the bolts.

5 COMPLY WITH THE TIGHTENING TORQUE VALUES

The recommended torque values are for greased threads (mechanical grease).

The bolts are only tightened to compress the reinforced gasket and not exert any tractive force on the pipeline elements.

Metal-reinforced gasket					
DN	Bolt tightening torque values for flanges				
	PN 10	PN 16	PN 25	PN 40	PN 63
	daN.m	daN.m	daN.m	daN.m	daN.m
40	4	4	4	4	4
50	4	4	4	4	4
60	4	4	4	4	6
65	4	4	4	4	6
80	4	4	4	4	6
100	4	4	6	6	8
125	4	4	8	8	12
150	6	6	8	8	15
200	6	6	8	12	18
250	6	8	12	15	18
300	6	8	12	15	18
350	6	8	15	18	30
400	8	12	18	30	40
450	8	12	18	30	
500	8	15	18	40	50
600	12	18	30	50	
700	12	18	40	60	
800	15	30	50		
900	15	30	50		
1000	18	40	60		
1100	18	40	60		
1200	30	50	60		
1400	40	50	70		
1500	40	60	70		
1600	50	60	70		
1800	50	60	80		
2000	50	70	80		

Flanged joint

6 SOCKET DIMENSIONS

DN	PN 10		PN 16		PN 25	
	Bolt	Socket	Bolt	Socket	Bolt	Socket
40	M16	24	M16	24	M16	24
50	M16	24	M16	24	M16	24
60	M16	24	M16	24	M16	24
65	M16	24	M16	24	M16	24
80	M16	24	M16	24	M16	24
100	M16	24	M16	24	M20	30
125	M16	24	M16	24	M24	36
150	M20	30	M20	30	M24	36
200	M20	30	M20	30	M24	36
250	M20	30	M24	36	M27	41
300	M20	30	M24	36	M27	41
350	M20	30	M24	36	M30	46
400	M24	36	M27	41	M33	50
450	M24	36	M27	41	M33	50
500	M24	36	M30	46	M33	50
600	M27	41	M33	50	M36	55
700	M27	41	M33	50	M39	60
800	M30	46	M36	55	M45	70
900	M30	46	M36	55	M45	70
1000	M33	50	M39	60	M52	80
1100	M33	50	M39	60	M52	80
1200	M36	55	M45	70	M52	80
1400	M39	60	M45	70	M56	85
1500	M39	60	M52	80	M56	85
1600	M45	70	M52	80	M56	85
1800	M45	70	M52	80	M64	95
2000	M45	70	M56	85	M64	95