

# ALL PRODUCT DIMENSIONS ARE BEFORE COATING

REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES

DO NOT SCALE

## MATERIAL SPECIFICATION

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

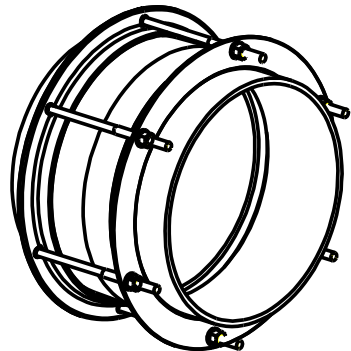
## FINISH SPECIFICATION

## NOTES

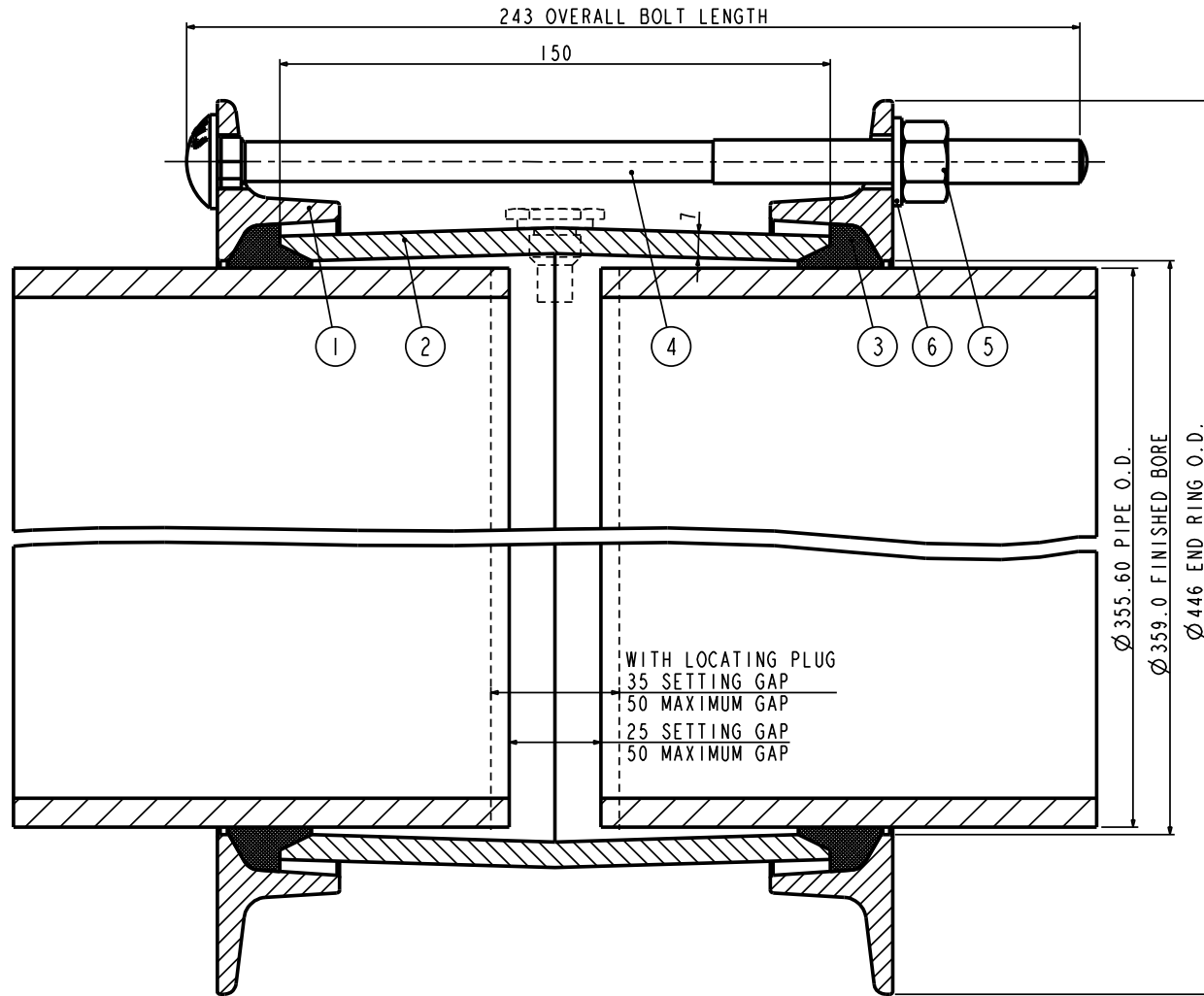
Locating Plugs/Pin Register.  
If Locating Plugs/Pins are required,  
2 Plugs/Pins are to be supplied.

## BOLT TORQUES

PIPE MATERIAL	Nm	lbf ft
GRP/GRP	27-33	20-25
GRP/ALL OTHERS	27-33	20-25
ALL OTHERS	54-65	70-90



ISOMETRIC VIEW



PIPE O.D.	PIPE MATERIAL	PIPE TOLERANCE		BOLTS NO-SIZE	GASKET MOULD	WORKING PRESSURE	TEST PRESSURE	WEIGHT KG	ASSEMBLY DRG NO
		+	-						
355.60	STEEL	1.60	1.60	6-M12x235	J51LS	23.2bar	34.9bar	19.6	7829_223

OVERALL DIMENSIONS DRAWING  
FOR REFERENCE ONLY  
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**CRANE** A Crane Co Company

OVERALL DIMENSIONS OF  
VIKING JOHNSON COUPLING ASSEMBLY  
'L02' SECTION  
FOR 355.60mm O.D. PIPE

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



DRAWN	drawn_by	SCALE	N.T.S.
DATE	30/05/08	GENERIC	7829

DRG NO SKP14-1