

# 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 S355JR  
**GASKET (Part 3)**  
RUBBER 70 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

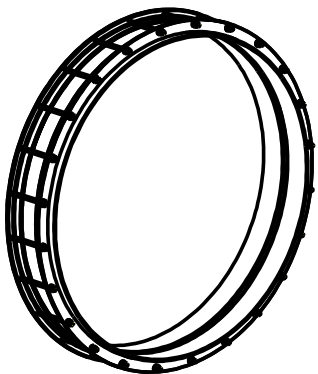
## FINISH SPECIFICATION

## NOTES

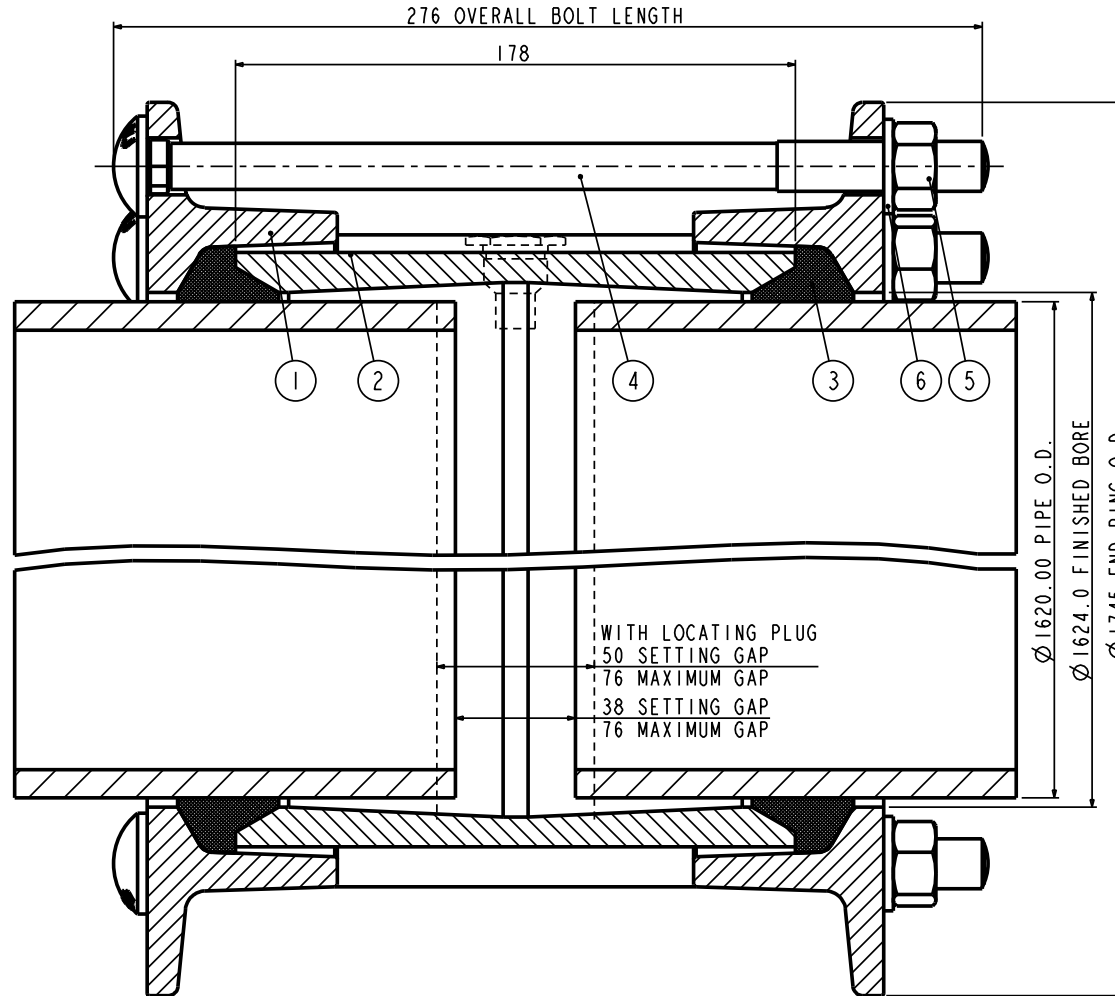
Locating Plugs/Pin Register  
If Locating Plugs/Pins are required  
3 Plugs/Pins are to be supplied.

## BOLT TORQUES

PIPE MATERIAL	Nm	lbf ft
GRP/GRP	47-60	35-45
GRP/ALL OTHERS	47-60	35-45
ALL OTHERS	95-120	70-90



ISOMETRIC VIEW



PIPE O.D.	PIPE MATERIAL	PIPE TOLERANCE		BOLTS	GASKET MOULD	WORKING PRESSURE	TEST PRESSURE	WEIGHT KG	ASSEMBLY DRG NO
		+	-						
1620.00	STEEL	3.00	3.00	24-M16x265	J127M	20.3bar	30.5bar	194.21	8144_4

OVERALL DIMENSIONS DRAWING  
FOR REFERENCE ONLY  
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CRANE A Crane Co Company

OVERALL DIMENSIONS OF  
VIKING JOHNSON  
COUPLING ASSEMBLY  
'A2E' SECTION  
FOR 1620.00mm PIPE O.D.

RELEASE LEVEL: Manufacture

SHEET 1 OF 1



DRAWN	AUTO	SCALE	N.T.S.
DATE	05/11/09	GENERIC	8144_ODIMS_1

DRG NO SKP367-1