

ALL PRODUCT DIMENSIONS ARE BEFORE COATING

MATERIAL SPECIFICATION	REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES						⚠	⊕	DO NOT SCALE								
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 S275JR GASKET (Part 4) RUBBER 80 HARDNESS Grade to suit service STUDS (Part 5) STEEL to BS EN ISO898-1:1999 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	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/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												
FINISH SPECIFICATION																	
NOTES																	
STUD TORQUES																	
PIPE MATERIAL	Nm	lbf ft															
GRP	27-33	20-25															
ALL OTHERS	54-65	40-50															
ISOMETRIC VIEW																	
OVERALL DIMENSIONS DRAWING FOR REFERENCE ONLY VIKING JOHNSON RESERVE THE RIGHT TO AMEND DETAILS WITHOUT PRIOR NOTIFICATION									OVERALL DIMENSIONS OF VIKING JOHNSON FLANGE ADAPTOR L02 SECTION								
<small>This drawing is the exclusive property of VIKING JOHNSON and is confidential and must not be reproduced or disclosed to a third party without written consent. It must be used only for the purpose which it has been issued and is returnable on request.</small>									FOR 378.00mm PIPE O.D. WITH A 350PN16 FLANGE DRILLING						<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">DRAWN</td> <td style="width: 15%;">AUTO</td> <td style="width: 15%;">SCALE</td> <td style="width: 15%;">0.143</td> </tr> <tr> <td>DATE</td> <td>10/03/09</td> <td>GENERIC</td> <td>7600_O.DIMS.1</td> </tr> </table>		DRAWN
DRAWN	AUTO	SCALE	0.143														
DATE	10/03/09	GENERIC	7600_O.DIMS.1														
A Crane Co Company		RELEASE LEVEL: Manufacture						SHEET 1 OF 1									
								DRG NO SKP671-1									