
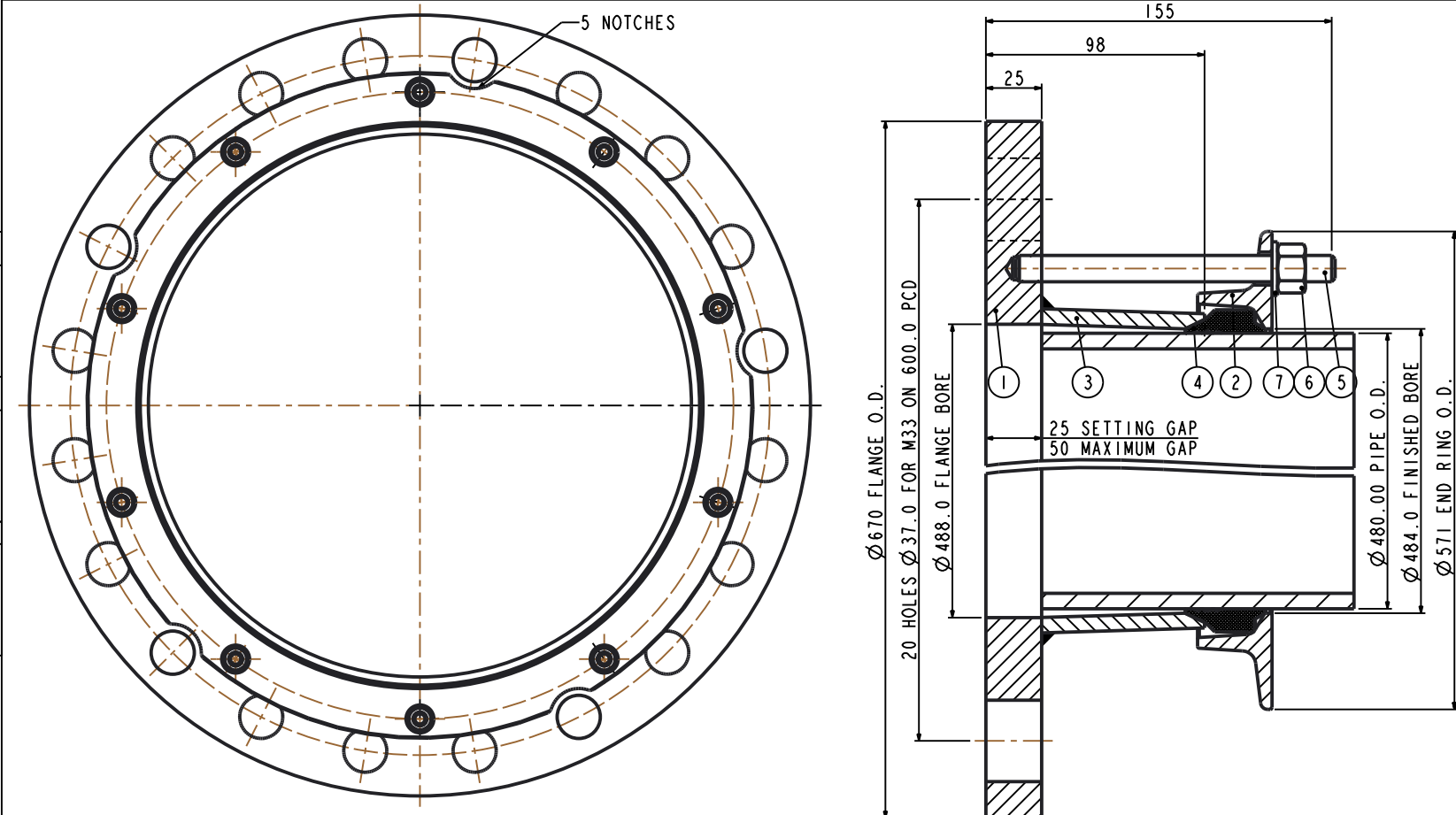
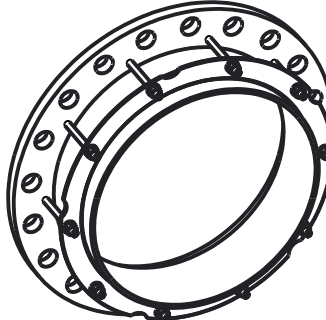


ALL PRODUCT DIMENSIONS ARE BEFORE COATING

MATERIAL SPECIFICATION		REFERENCE DRAWING ONLY - NOT TO BE USED FOR INSPECTION PURPOSES										 DO NOT SCALE			
FLANGE (Part 1)		FOR HARNESSING ARRANGEMENT THIS PRODUCT WILL REQUIRE NOTCHING, AS SHOWN. UN-NOTCHED END RINGS WILL BE SUPPLIED UNLESS REQUESTED OTHERWISE													
STEEL to BS EN10025-2 GRADE S275JR		NOTCHING REQUIREMENTS FOR CAST AND DUCTILE IRON PIPE MATERIALS						NOTCHING REQUIREMENTS FOR ALL OTHER PIPE MATERIALS							
END RING (Part 2)		FLANGE HOLES		MINIMUM		CALCULATED MINIMUM		FLANGE HOLES		MINIMUM		CALCULATED MINIMUM			
STEEL to BS EN10025-2 GRADE S275JR		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			
CENTRE SLEEVE (Part 3)								FLANGES WITH MORE THAN 16 HOLES		QUARTER THE NUMBER OF FLANGE HOLES		CALCULATED USING A YIELD OF 725N/mm ²			
STEEL to BS EN10025-2 GRADE S275JR															
GASKET (Part 4)															
RUBBER 80 HARDNESS															
Grade to suit service															
STUDS (Part 5)															
STEEL to BS EN ISO898-1 PROPERTY CLASS 4.8															
NUTS (Part 6)															
STEEL to BS4190 GRADE 4															
WASHERS (Part 7)															
STAINLESS STEEL to BS1449:PART 2 GRADE 304S15															
FINISH SPECIFICATION															
NOTES															
STUD TORQUES															
Torque to 55-65Nm or 40-50 lbf ft															
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 FOR 480.00mm PIPE O.D. WITH A 450PN25 FLANGE DRILLING													
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.		RELEASE LEVEL: Released													
CRANE A Crane Co Company		SHEET 1 OF 1													
		DRG NO SKPI3053-1													