

ISSUE	ALTERATION	DATE & INITIAL	ATO NO
A	ISSUED TO CUSTOMER	14/3/19 MF	

SPECIFICATION DRAWING ONLY. NOT TO BE USED FOR INSPECTION PURPOSES.
ALL PRODUCT DIMENSIONS ARE BEFORE COATING



DO NOT SCALE

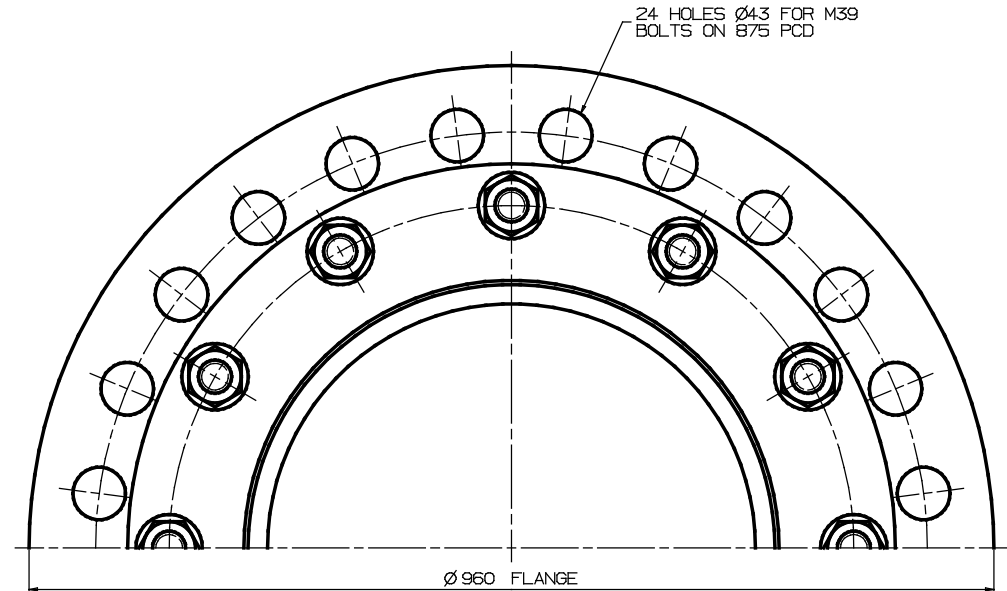
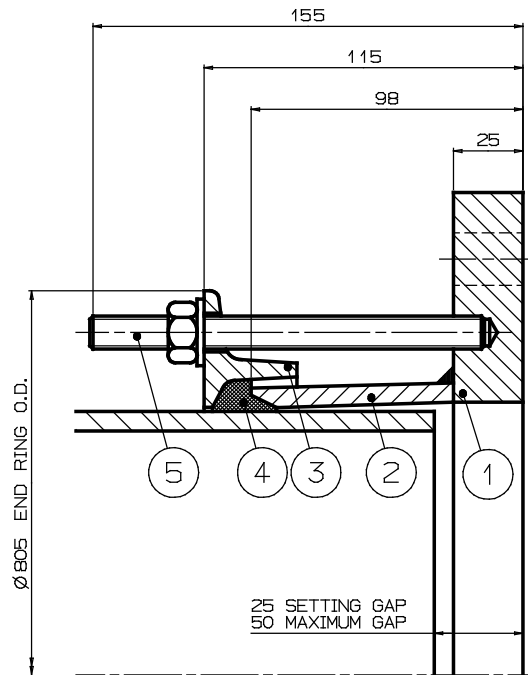
MATERIAL SPECIFICATION

FLANGE (Part 1)
Steel to BS EN10025-2 Grade S275JR
PART CENTRE SLEEVE (Part 2)
Steel to BS EN10025-2 Grade S275JR
END RING (Part 3)
Steel to BS EN10025-2 Grade S275JR
GASKET (Part 4)
80 IRHD Moulded Compound
Grade to suit service
STUDS, NUTS & WASHERS (Part 5)
STUDS
Steel to BS EN ISO898-1
Property Class 4.8
NUTS
Steel to BS4190 Grade 4
WASHERS
Stainless Steel to BS1449:Part 2
Grade 304S15

FINISH SPECIFICATION

STUD TORQUES

PIPE MATERIAL	Nm	lbf ft
GRP	27-33	20-25
ALL OTHERS	54-65	40-50



Pipe O.D. includes a Coating of 1.5mm thick. Un-Coated Pipe is 711mm O.D.

O.D.	PIPE MATERIAL	TOLERANCE	FLANGE DRILLING	STUDS	GASKET MOULD	WORKING PRESSURE	TEST PRESSURE	SECTION	WEIGHT KG	ASSEMBLY DRAWING NO
714	STEEL	±1.6	700 PN25	12-M12x140	J63LS	25bar	37.5bar	L02	73.6	7600/555

5	STUDS, NUTS & WASHERS		12
4	GASKET		1
3	END RING		1
2	SLEEVE		1
1	FLANGE		1
PART	DESCRIPTION	DRG NO	NO OFF

OVERALL DIMENSIONS FOR
REFERENCE ONLY
VIKING JOHNSON RESERVE THE
RIGHT TO AMEND DETAILS
WITHOUT PRIOR NOTIFICATION

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.

CRANE A Crane Co Company



TITLE

OVERALL DIMENSIONS OF
V.J. FLANGE ADAPTOR
FOR 714mm O.D. PIPES
700 NOM PN25 FLANGE



DRAWN	CAD	DATE
SCALE N.T.S.	MF	14/3/19
CHECKED		APPROVED

DRG NO. SKC30614-1

ISSUE
A