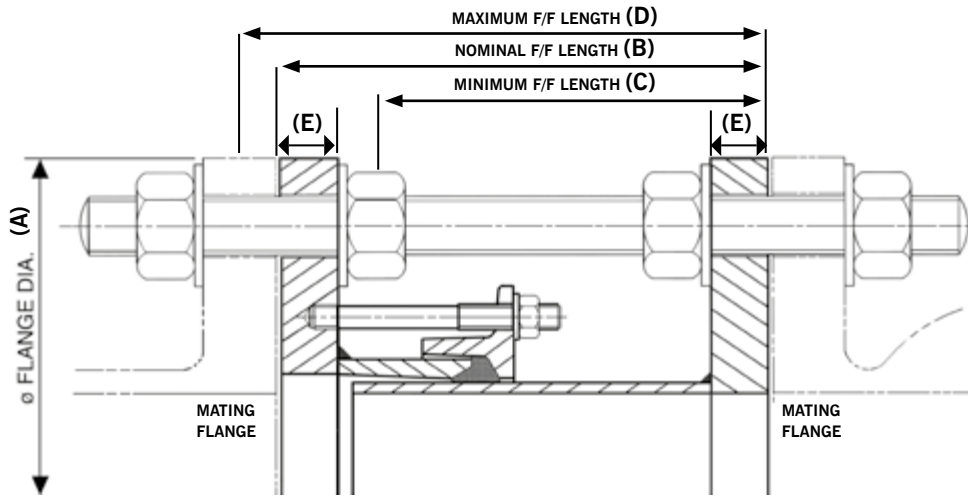


# Dismantling Joints DN350 to DN2400 (PN10)

## Dismantling Joint

(For diameters over DN2400 contact Viking Johnson)



**Note:** Maximum Longitudinal F/F Adjustment = Maximum F/F Length – Minimum F/F Length

## Dismantling Joints (Standard Product)

Table provides details of standard product – for products offering longer flange dimensions and / or increased longitudinal adjustment contact Viking Johnson.

Flange Details		Flange To Flange Details					Tie Rod Details					
Nom	Drilling	Flange Thickness	Flange OD	Nominal Length	Minimum Length	Maximum Length	Steel Tie Rod			Stainless Steel Tie Rod		
		E (mm)	A (mm)	B (mm)	C (mm)	D (mm)	Dia x Length (mm)	No.	Total Weight of DJ (kg)	Dia x Length (mm)	No.	Total Weight of DJ (kg)
350	PN10	18	505	295	270	320	M20 x 430	4	57.7	M20 x 430	4	57.7
400	PN10	18	565	295	270	320	M24 x 440	4	68.9	M24 x 440	4	68.9
450	PN10	23	615	300	275	325	M24 x 450	5	87.2	M24 x 450	5	87.2
500	PN10	23	670	300	275	325	M24 x 460	5	97.1	M24 x 460	5	97.1
550	PN10	23	730	300	275	325	M27 x 470	5	112.0	M27 x 470	5	112.0
600	PN10	23	780	300	275	325	M27 x 470	5	120.0	M27 x 470	5	120.0
650	PN10	23	835	300	275	325	M27 x 480	6	132.0	M27 x 480	6	132.0
700	PN10	23	895	300	275	325	M27 x 480	6	146.0	M27 x 480	6	146.0
800	PN10	23	1015	300	275	325	M30 x 500	6	167.0	M30 x 500	8	169.0
900	PN10	25	1115	307	277	337	M30 x 520	7	211.0	M30 x 520	8	215.6
1000	PN10	25	1230	307	277	337	M33 x 530	7	246.0	M33 x 530	8	251.0
1100	PN10	25	1340	307	277	337	M33 x 540	8	276.0	M33 x 540	10	286.0
1200	PN10	38	1455	320	290	350	M36 x 570	8	414.0	M36 x 570	10	426.0
1300	PN10	38	1575	320	290	350	M39 x 590	8	475.0	M39 x 590	10	491.0
1400	PN10	38	1675	320	290	350	M39 x 600	9	509.0	M39 x 600	12	533.0
1500	PN10	38	1785	320	290	350	M39 x 610	9	606.0	M39 x 610	12	631.0
1600	PN10	38	1915	320	290	350	M45 x 630	10	731.0	M45 x 630	10	731.0
1800	PN10	38	2115	320	290	350	M45 x 650	11	829.0	M45 x 650	14	866.0
2000	PN10	60	2325	462	412	512	M45 x 830	12	1,412.0	M45 x 830	16	1,470.0
2200	PN10	60	2550	462	412	512	M52 x 860	13	1,699.0	M52 x 950	14	1,775.0
2400	PN10	60	2760	462	412	512	M52 x 880	14	1,878.0	M52 x 970	18	2,032.0

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# Dismantling Joints DN350 to DN2400 (PN10)

Datasheet

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## Technical Information

### Working Pressure Rating

Water - In accordance with the flange rating  
Gas 6 bar

### Vacuum Pressure

Capable of accommodating a vacuum pressure of -0.7 bar

### Site Test Pressure

1.5 times working pressure for short duration (2 hours)

### Angularity

Dismantling joints are in essence double flanged pipe where the flange to flange dimension can be adjusted, and therefore are not able to accommodate any angularity.

### Bolt Torque/Spanner

M12; Torque 55-65Nm on every bolt  
M16; Torque 95-110Nm on every bolt

### Tie rods

Torque is a function of the flange connecting gasket, not supplied by Viking Johnson; consult flange gasket supplier.

### Temperature Rating of Product

EPDM -20°C to +90°C  
Nitrile -20°C to +90°C

For use on applications with fluctuating and / or elevated temperatures (> 60°C) may require regular maintenance to re-tighten the bolts and must be included in any maintenance schedule.

### Approvals

The following water contact materials used in Dismantling Joints are approved for use with potable water:-

Rilsan Nylon 11:

- WRAS, DVGW, W270, ACS & KIWA

EPDM Gaskets:

- WRAS

In addition to the above, the flange adaptor component in the Dismantling Joint has as a finished product KIWA certification verifying that it complies with the requirements of the Water Supply (Water Fittings) Regulations for England and Wales 1999, the Water Byelaws 2000, Scotland and the Water Regulations Northern Ireland.

## Materials & Relevant Standards

### Flange Drilling

BS EN1092-1  
(formerly BS4504), ISO7005

### Fabricated Flange Adaptor Body

Rolled Steel to BS EN 10025-2:  
Grade S275

### End Rings & Sleeve Options

- Rolled Steel to BS EN 10025-2:  
Grade S275
- Rolled Steel to BS EN 10025-2:  
Grade S355  
(depending on section)

### Flange

Rolled Steel to BS EN 10025-2:  
Grade S275

### Spigot Options:

- Steel Tube to BS10216-1:  
Grade P265TR1
- Rolled steel to BS EN10025-2:  
Grade S275

### Gaskets

Standard:

- EPDM to BS EN681-1: Type WA
- Other gasket grades are available contact Viking Johnson.

### Coatings

Flange Adaptor, Spigot & End Ring:

- Rilsan Nylon 11 to  
WIS 4-52-01 Part 1

Option 1 Flange Adaptor bolts & Nuts:

- Sheraplex to WIS 4-52-03

Steel Tie Rods/Nuts:

- Zn<sup>3</sup> Zinc coated

### Tie Rods, Studs, Nuts and Washers

The following two options are as standard variants:-

#### Option 1: Zinc Plated Steel

##### Tie Rods

ASTM A193 (Grade B7/MB7) equivalent to BS EN10269:+A1: Name 42CrMo4 (Yield 725N/mm<sup>2</sup>)

##### Tie Rod Nuts

ASTM A194 Grade 2H/M2H equivalent to BS EN20898-2: Property Class 8.00

##### Flange Adaptor Studs

Steel to BS EN ISO898-1: Property Class 4.8

##### Flange Adaptor Nuts

Steel to BS4190: Grade 4

##### Flange Adaptor Washers

Stainless Steel to BS1449:Part 2: Grade 304S15

#### Option 2: Stainless Steel

##### Tie Rods

Stainless Steel to BS EN3506-1: Grade A4 Property Class 70 (Yield 450N/mm<sup>2</sup>)

##### Tie Rod Nuts

Stainless Steel to BS EN3506-2: Grade A4 Property Class 80

##### Flange Adaptor Studs

Stainless Steel to BS EN ISO 3506-1: grade A4 property class 50

##### Flange Adaptor Nuts

Stainless Steel to BS EN ISO 3506-2: grade A4 property class 80

##### Flange Adaptor Washers

Stainless Steel to BS1449: Part 2: Grade 304S15