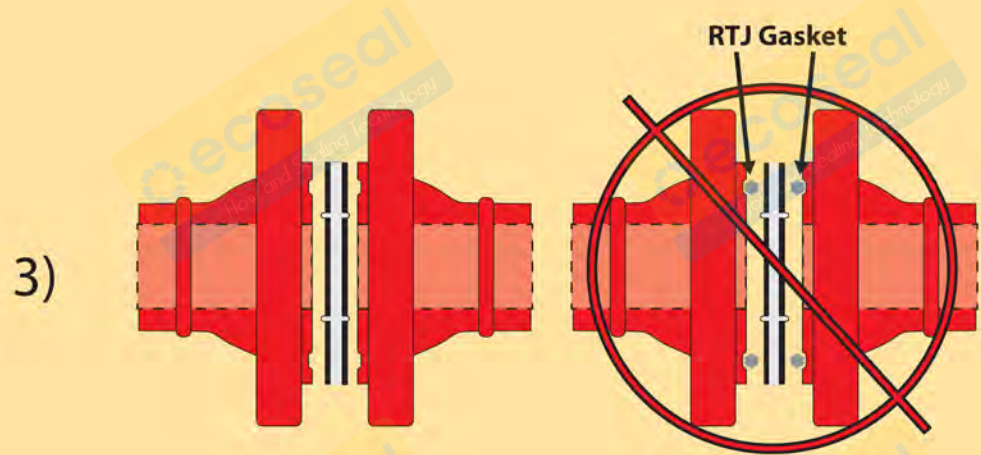
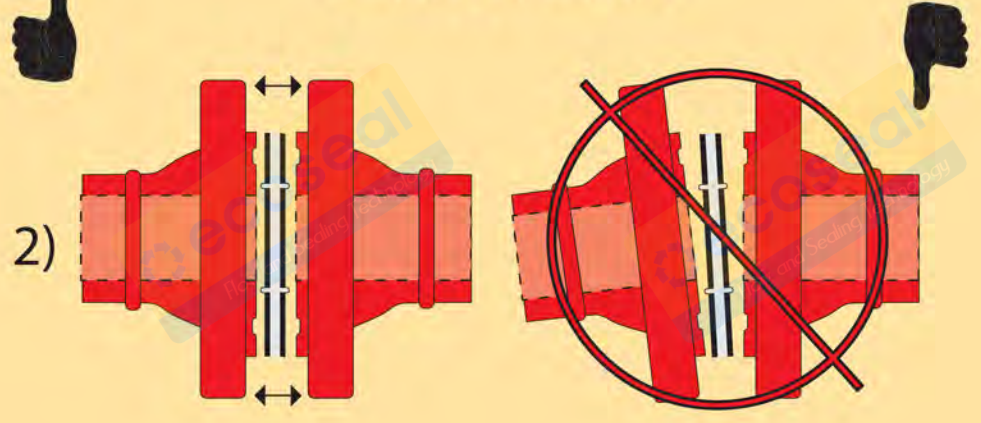


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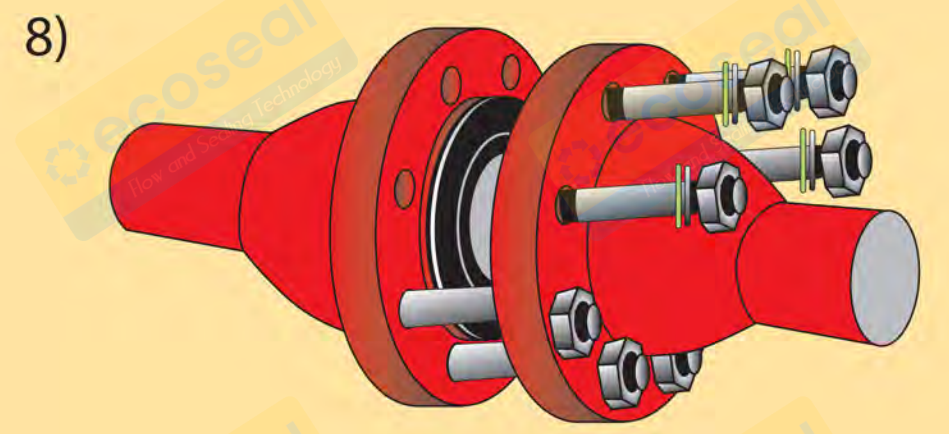
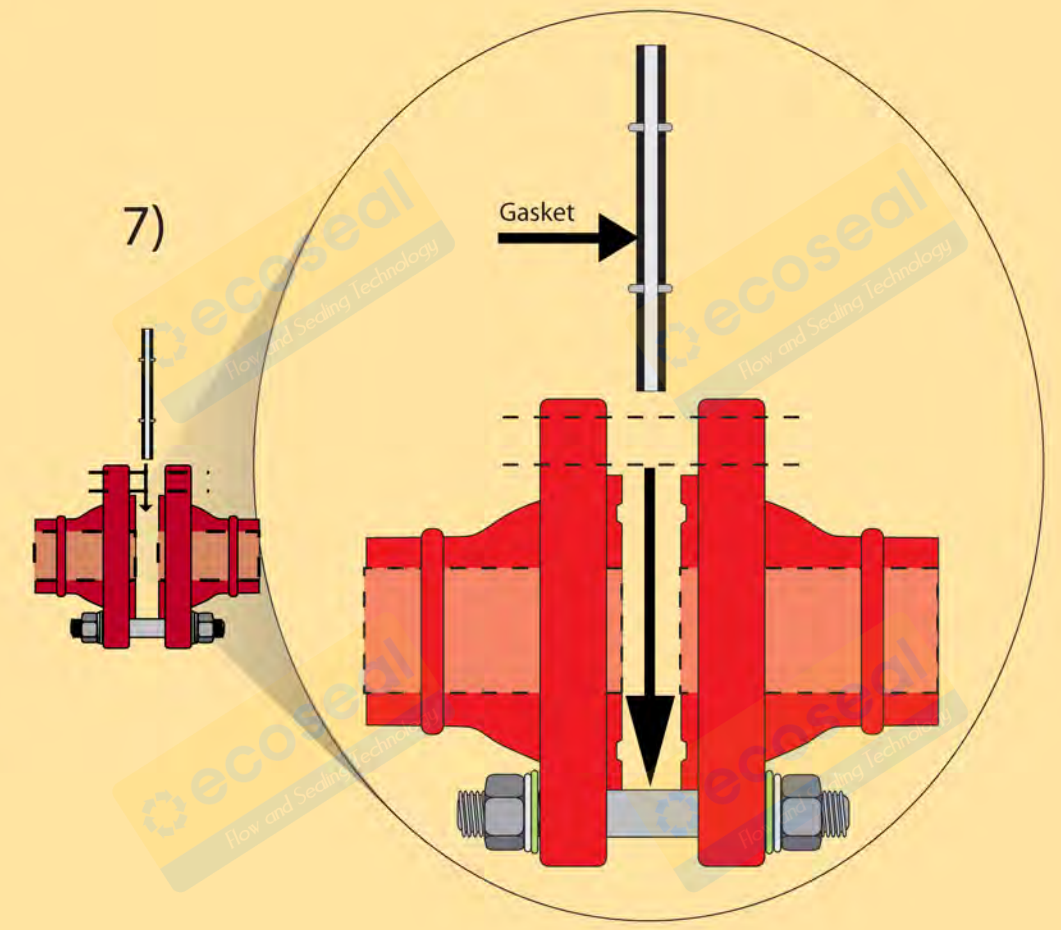
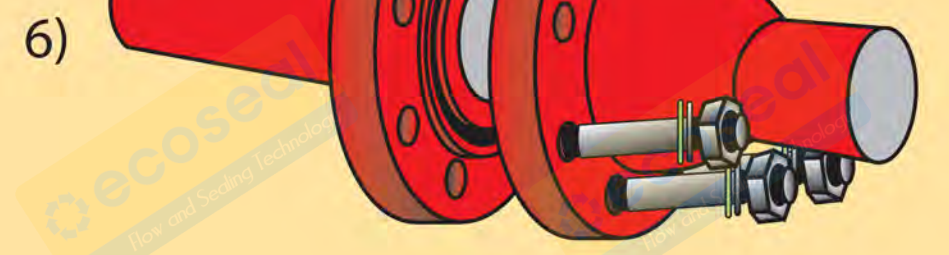
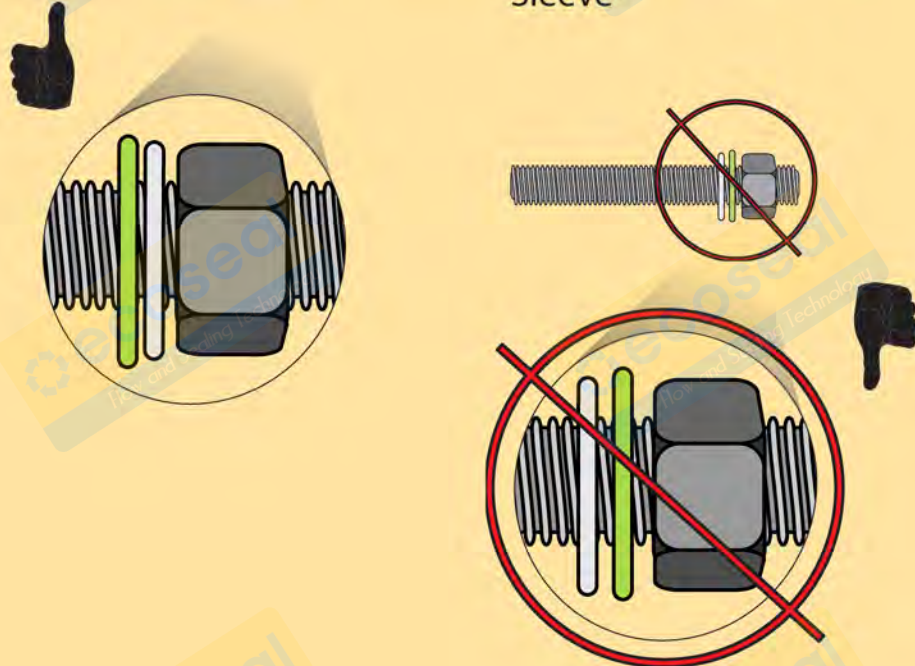
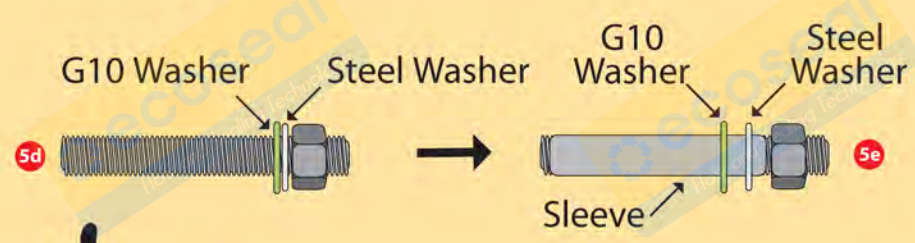
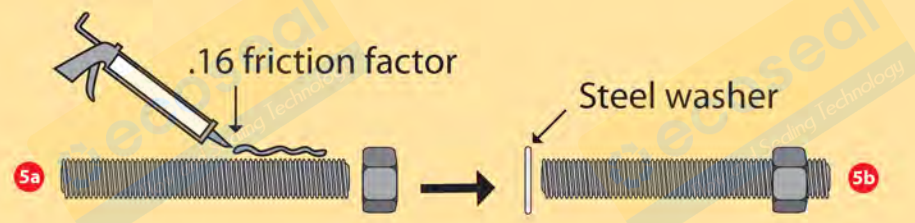
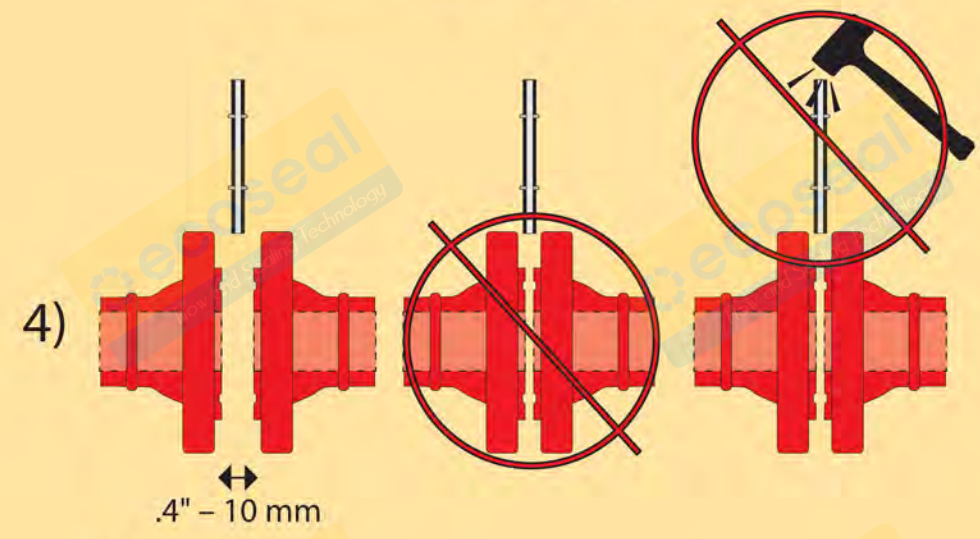
SURFACE FINISH



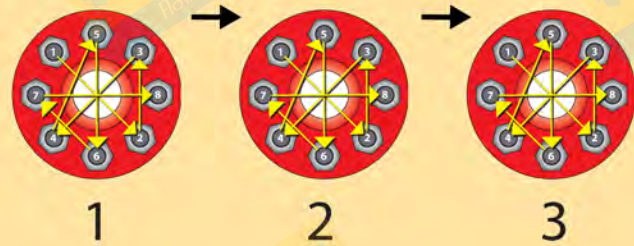
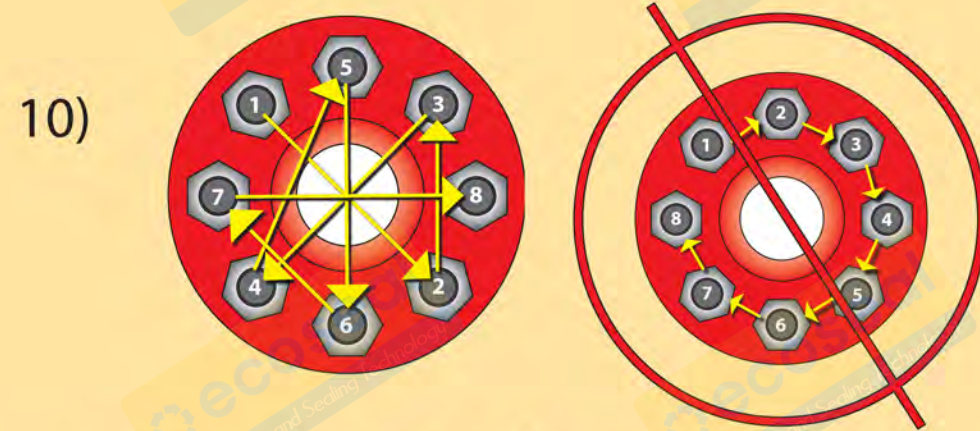
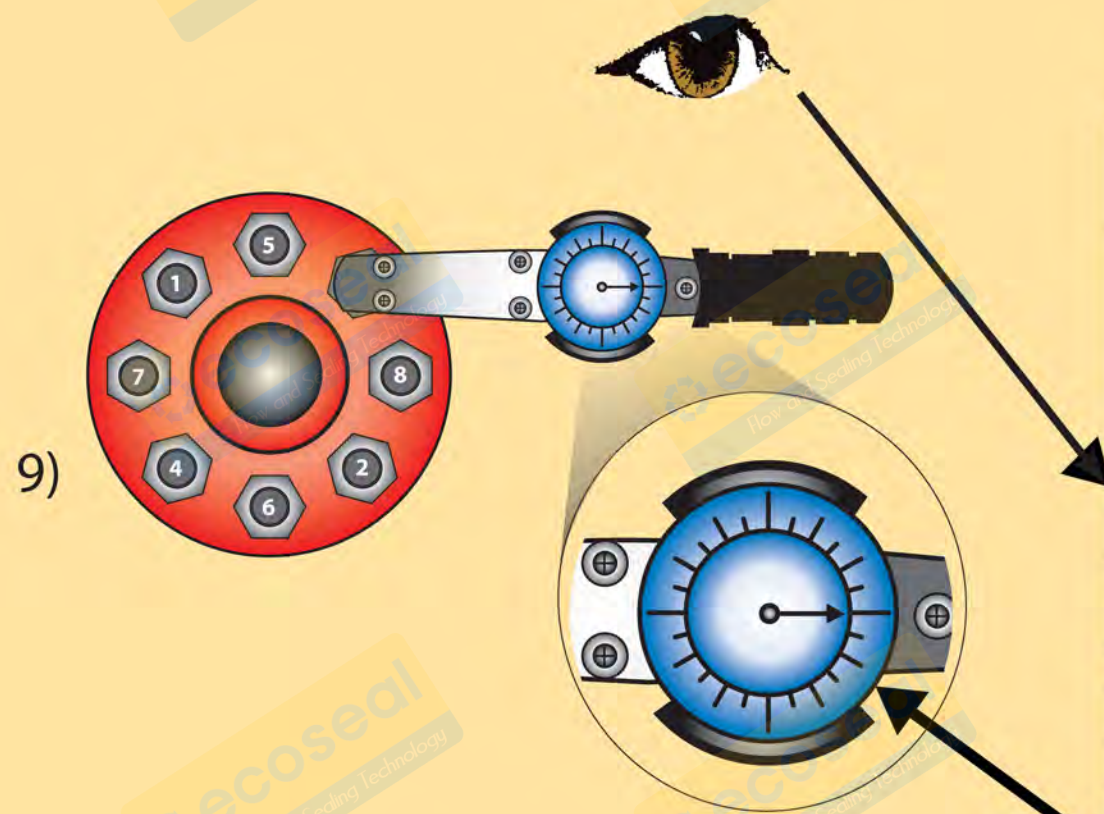
PARALLEL FLANGES



MINIMUM GAP - NO HAMMER



RECOMMENDED BOLT TORQUE VALUES



Equal Torque

Stress = 30,000 psi

Nominal Diameter of Bolt (inches)	Torque Value foot pounds (ft.lbs)	Torque Value Newton meter (Nm)
1/2	30	41
9/16	45	61
5/8	60	82
3/4	100	135
7/8	160	217
1	245	332
1-1/8	355	481
1-1/4	500	678
1-3/8	680	922
1-1/2	800	1085
1-5/8	1100	1491
1-3/4	1500	2034
1-7/8	2000	2712
2	2200	2983
2-1/4	3180	4312
2-1/2	4400	5966
2-3/4	5920	8026
3	7720	10465
3-1/4	8400	11389
3-1/2	9000	12202
3-3/4	9600	13016
4	10000	13558

Notes:

- 1) Recommended bolt torque is based on deriving a minimum gasket seating stress of 7,500 psi.
- 2) Bolt torque values listed assume a lubricated stud bolt resulting in a .16 friction factor.
- 3) Recommended torque values are based on using weld-neck (integral) flanges.
- 4) Blind or other flange types may require different seating loads.
- 5) 30 ksi bolt stress may exceed the design allowable stress levels for certain stud bolt materials.



INSTALLATION INSTRUCTIONS

