

Installation Procedure - ANSI

PTFE/PFA lined piping systems

Tightening torques (for pressure rating Class P150)

When using smooth-running and greased bolts and nuts we recommend the tightening torques in the table below:

DN	Torgue (Nm)	Screws
1/2"	25	4 x 1/2"
3/4"	25	4 x 1/2"
1"	30	4 x 1/2"
1 1/2"	60	4 x 1/2"
2"	80	4 x 5/8"
3"	94	4 x 5/8"
4"	70	8 x 5/8"
6"	130	8 x 3/4"
8"	180	8 x 3/4"
10"	190	12 x 7/8"
12"	240	12 x 7/8"

1. Tightening the bolts:

- Insert the washers
- Clean and grease bolts
- Tighten nuts by hand
- We have taken a friction coefficient of 0.14 ($f=0.14$) in account.
- Tighten each bolt using a torque wrench, keeping to the torque values specified in the table.
- The torque wrench should be used in a cross manner.
- If a flange connection leaks, despite the fact that all bolts are tight, do not tighten further. Loose the connection, inspect the seal face and re-install.

2. Gaskets

It is a must to use MB-SURELINE® S58 PTFE gaskets between the flange connection. They are special designed for PTFE/PFA lined piping system

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