

Installation Procedure - DIN

PTFE/PFA lined piping systems

Tightening torques (for pressure rating Class PN 10/16)

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

DN	Torgue (Nm)	Screws
15	38	4 x M12
20	38	4 x M12
25	38	4 x M12
32	53	4 x M16
40	53	4 x M16
50	68	4 x M16
65	69	4 x M16
80	72	8 x M16
100	75	8 x M16
125	120	8 x M16
150	135	8 x M20
200	172	8 x M20
250	143	12 x M20
300	172	12 x M20
350	210	12 x M20
400	233	16 x M24
500	240	20 x M27

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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