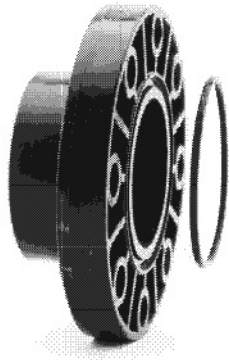




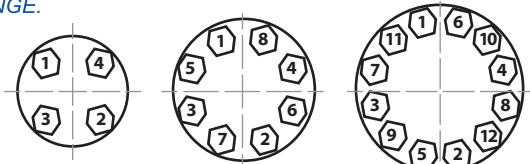
SCHEDULE 80 FLANGES



FLANGE MAKE-UP: Once a flange is joined to pipe, the method for joining two flanges is as follows:

- Piping runs joined to the flanges must be installed in a straight line position to the flange to avoid stress at the flange due to misalignment. Piping must also be secured to prevent lateral movement which can create stress and damage the flange.
- With gasket in place, align the bolt holes of the mating flanges by rotating the ring into position.
- Insert all bolts, washers (two standard flat washers and one lock washer per bolt), and nuts.
- Make sure the faces of the mating surfaces are flush against gasket prior to bolting down the flanges.
- Tighten the bolts on the plastic flanges by pulling down the nuts diametrically opposite each other using a torque wrench. Tighten bolts according to sequence shown in diagram. Complete tightening should be accomplished in stages and the final torque values followed according to the size of the flange. See chart for recommended torque. Uniform pressure across the flange will eliminate leaky gaskets.

CAUTION: UNNECESSARY OVER TORQUING WILL DAMAGE THE FLANGE.

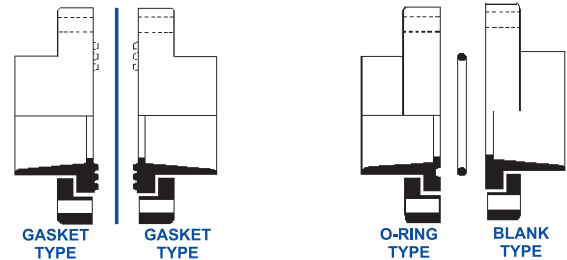


Bolt Tightening Sequences

- Follow standard guidelines for Solvent Weld or Threaded joint applications.
- Buna-N O-Rings are included with Van Stone Flanges.
- Recommended Gaskets: Full face, 1/8" thick, elastomeric, 50-70 Shore A hardness.
- Always use full size flat washers with bolts and nuts.
- Bolt threads should be well lubricated. Nut and bolt threads should be free running during assembly.
- Follow illustrated bolt tightening sequence.

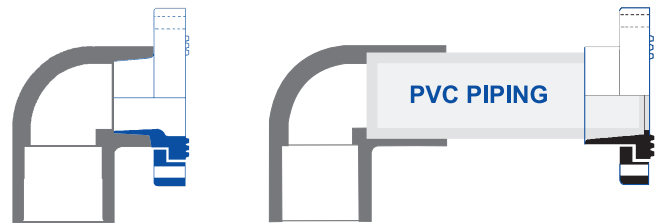
NOTE: Flanges conform to Ansi B 16.5, Class 150.
 Socket diameters conform to ASTM D 2467.
 Recommended working pressure: 150psi @ 73.4° F.

FLANGE TYPES MUST BE MATCHED AS FOLLOWS:



GASKET TO GASKET

O-RING TO BLANK



SPIGOT FLANGE

SLIP FLANGE

SIZE	NUMBER OF BOLTS	BOLT DIAMETER X LENGTH	TORQUE (Ft/Lbs)
1/2	4	1/2 x 2 1/2	15 - 20
3/4	4	1/2 x 2 1/2	15 - 20
1	4	1/2 x 2 1/2	15 - 20
1 1/4	4	1/2 x 2 1/2	15 - 20
1 1/2	4	1/2 x 2 1/2	15 - 20
2	4	5/8 x 2 3/4	20 - 30
2 1/2	4	5/8 x 3	20 - 30
3	4	5/8 x 3 1/2	20 - 30
4	8	5/8 x 3 3/4	20 - 30
5	8	3/4 x 4	25 - 35
6	8	3/4 x 4 1/2	30 - 45
8	8	3/4 x 4 3/4	30 - 45
10	12	7/8 x 5 3/4	35 - 50
12	12	7/8 x 6	35 - 50