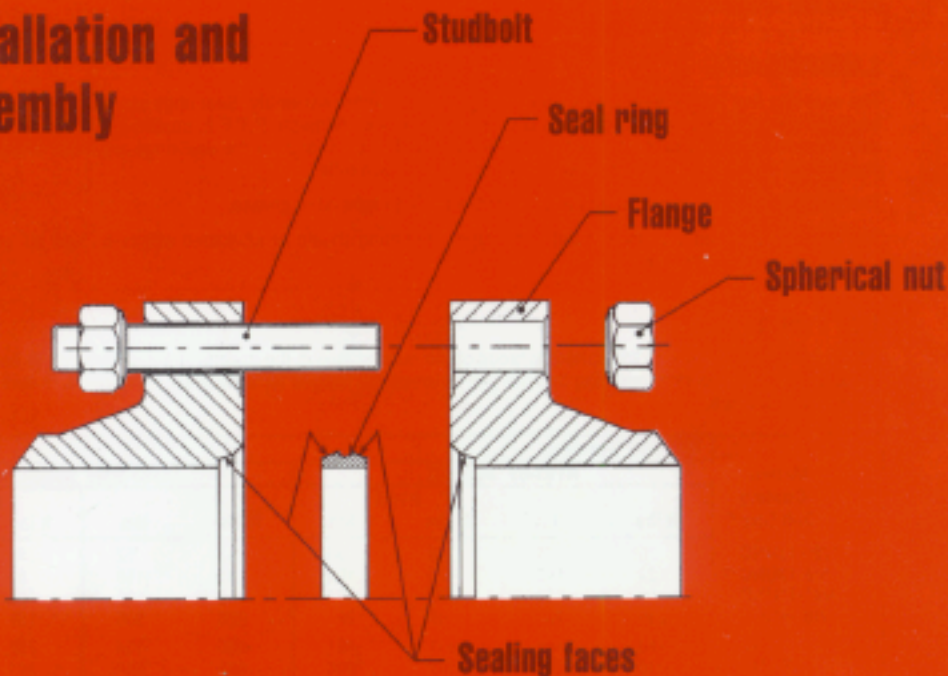


DESTEC 'DEFLEX' COMPACT FLANGE CONNECTIONS

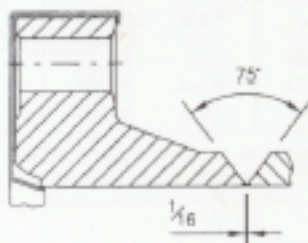
installation and assembly



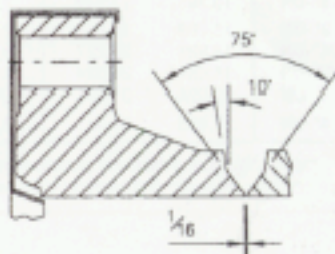
1 WELDING OF FLANGES TO PIPE ENDS

The standard flange is provided with a weld preparation for welding from the outside only. Protect the flange seat with the metal guards provided, and against oxidation, by using Berkatect No. 12 or equivalent.

If flanges welded to pipe lengths are not to be assembled immediately, remove metal guards and coat flanges with grease or lanolin preservative. Replace metal guards for storage.



UP TO $\frac{7}{16}$ " WALL THICKNESS



OVER $\frac{7}{16}$ " WALL THICKNESS

ASSEMBLY

2

CLEAN

Remove grease and preservative from flange and seat faces.

3

INSPECT

Check all sealing surfaces for mechanical damage and rust. Small scratches should be removed by polishing, more serious defects may mean remachining of the component or component replacement. Destec should be contacted for advice and information.

4

LUBRICATE

The seal ring and flange sealing faces must be lubricated before assembly. Seal rings are supplied coated with lubricant either P.T.F.E. or Molybdenum Disulphide. If the seal rings are P.T.F.E. coated the flange seat must be clean and uncoated or it may be coated with a thin even coat of clean light oil. If the seal rings are MoS₂ coated the flange seat should be sprayed with a thin coat of Molybdenum Disulphide.

The bolting if P.T.F.E. coated may be lubricated with clean light oil or grease.

The bolting if supplied uncoated or with other types of coating should be lubricated with clean light oil, grease or proprietary anti-scuffing agent.

5

FITTING

Fit the flanges together with the spherical faces of the nuts located in the special seating. Tighten the bolting evenly to the torques recommended, ensuring that the gap between the flanges remains reasonably constant during the tightening sequence.

Material Coating Bolt Size	Bolting Torques							
	A193-B7 A320-L7				A193-B7M A320-L7M			
			PTFE				PTFE	
	ft.lbs	Nm	ft.lbs	Nm	ft.lbs	Nm	ft.lbs	Nm
1/2"-13UNC	55	74	39	53	42	57	30	40
5/8"-11UNC	107	145	76	103	81	110	58	78
3/4"-10UNC	186	252	132	178	142	192	100	136
7/8"-9UNC	296	401	209	283	225	305	159	216
1"-UNC	440	596	311	421	335	454	237	321
1.1/8"-UN	636	862	447	606	485	657	341	462
1.1/4"-UN	883	1,198	618	837	673	912	471	638
1.3/8"-UN	1,187	1,609	827	1,121	905	1,226	630	854
1.1/2"-UN	1,554	2,106	1,079	1,462	1,184	1,605	822	1,114
1.5/8"-UN	1,988	2,695	1,377	1,866	1,515	2,054	1,049	1,422
1.3/4"-UN	2,497	3,385	1,725	2,338	1,902	2,579	1,314	1,781
1.7/8"-UN	3,085	4,183	2,126	2,883	2,351	3,187	1,620	2,196
2"-UN	3,760	5,096	2,586	3,506	2,864	3,883	1,970	2,671
2.1/8"-UN	4,525	6,134	3,108	4,213	3,448	4,674	2,368	3,210
2.1/4"-UN	5,388	7,304	3,695	5,008	4,105	5,565	2,815	3,816
2.3/8"-UN	6,354	8,614	4,351	5,898	4,841	6,563	3,315	4,494
2.1/2"-UN	7,429	10,071	5,081	6,888	5,660	7,673	3,871	5,248
2.5/8"-UN	7,798	10,571	5,327	7,221	6,567	8,902	4,486	6,081
2.3/4"-UN	8,984	12,178	6,131	8,311	7,565	10,250	5,163	6,998
2.7/8"-UN	10,283	13,940	7,011	9,504	8,660	11,739	5,904	8,003
3"-UN	11,703	15,864	7,971	10,806	9,855	13,359	6,713	9,100
3.1/4"-UN	14,921	20,227	10,148	13,757	12,565	17,033	8,546	11,584
3.1/2"-UN	18,681	25,324	12,688	17,200	15,731	21,326	10,684	14,484
3.3/4"-UN	23,024	31,211	15,619	21,173	19,389	26,283	13,153	17,830
4"-UN	27,993	37,947	18,970	25,716	23,573	31,956	15,975	21,655

Tightened properly the connection will remain tight and leak-proof under the most severe conditions of vibration and temperature change. Periodic retightening may be necessary on connections operating at elevated temperatures.



DESTEC ENGINEERING LTD.,

FIVE MILE LANE, WASHINGTONBOROUGH, LINCOLN, LN4 1AF.
Telephone: Lincoln (01522) 791721 Fax: Lincoln (01522) 790033
E-mail: sales@destec.co.uk www.destec.co.uk