

# Installation Procedure - ANSI

## *PTFE/PFA lined piping systems*

### Tightening torques (for pressure rating Class 150#)

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

Inch	Bolts	Tightening torques (Nm)
1/2"	4 x 1/2"	25
3/4"	4 x 1/2"	25
1"	4 x 1/2"	30
1 1/2"	4 x 1/2"	60
2"	4 x 5/8"	80
3"	4 x 5/8"	120
4"	8 x 5/8"	70
6"	8 x 3/4"	130
8"	8 x 3/4"	180
10"	12 x 7/8"	190
12"	12 x 7/8"	240

#### 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® Fluor gaskets between the flange connection. They are special designed for PTFE/PFA lined piping systems.

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