

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	Bolts	Tightening torques (Nm)
25	4 x M12	30
40	4 x M16	60
50	4 x M16	80
65	4 x M16	100
80	4 x M16	60
100	8 x M16	70
125	8 x M16	90
150	8 x M20	130
200	8 x M20	180
250	12 x M20	160
300	12 x M20	210

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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