



TECHNICAL

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Details for Bolting BS and ASA Pipe Flanges

Nominal Flange Size		150lb (1/16" Raised Face)			300lb (1/16" Raised Face)		
		Number of Studbolts	Diameter of Studbolts	Length of Studbolts	Number of Studbolts	Diameter of Studbolts	Length of Studbolts
mm	inches		inches	inches		inches	inches
15	1/2"	4	1/2"	2 1/4"	4	1/2"	2 1/2"
20	3/4"	4	1/2"	2 1/4"	4	5/8"	2 3/4"
25	1"	4	1/2"	2 1/4"	4	5/8"	3"
32	1 1/4"	4	1/2"	2 1/2"	4	5/8"	3"
40	1 1/2"	4	1/2"	2 3/4"	4	3/4"	3 1/2"
50	2"	4	5/8"	3"	8	5/8"	3 1/4"
65	2 1/2"	4	5/8"	3 1/4"	8	3/4"	3 3/4"
80	3"	4	5/8"	3 1/2"	8	3/4"	4"
90	3 1/2"	8	5/8"	3 1/2"	8	3/4"	4 1/4"
100	4"	8	5/8"	3 1/2"	8	3/4"	4 1/4"
125	5"	8	3/4"	3 3/4"	8	3/4"	4 1/2"
150	6"	8	3/4"	3 3/4"	12	3/4"	4 3/4"
200	8"	8	3/4"	4"	12	7/8"	5 1/4"
250	10"	12	7/8"	4 1/2"	16	1"	6"
300	12"	12	7/8"	4 1/2"	16	1 1/8"	6 1/2"
350	14"	12	1"	5"	20	1 1/8"	6 3/4"
400	16"	16	1"	5 1/4"	20	1 1/4"	7 1/4"
450	18"	16	1 1/8"	5 3/4"	24	1 1/4"	7 1/2"
500	20"	20	1 1/8"	6"	24	1 1/4"	8"
600	24"	20	1 1/4"	6 3/4"	24	1 1/2"	9"
750	30"	28	1 1/4"	7 1/2"	28	1 3/4"	11 1/2"
900	36"	32	1 1/2"	8 1/2"	32	2"	12 3/4"



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Details for Bolting BS and ASA Pipe Flanges

Nominal Flange Size		400lb (1/4" Raised Face)			600lb (1/4" Raised Face)		
		Number of Studbolts	Diameter of Studbolts	Length of Studbolts	Number of Studbolts	Diameter of Studbolts	Length of Studbolts
mm	inches		inches	inches		inches	inches
15	1/2"	For these sizes 600lb Flanges are used			4	1/2"	3
20	3/4"				4	5/8"	3 1/4"
25	1"				4	5/8"	3 1/2"
32	1 1/4"				4	5/8"	3 3/4"
40	1 1/2"				4	3/4"	4"
50	2"				8	5/8"	4"
65	2 1/2"				8	3/4"	4 1/2"
80	3"				8	3/4"	4 3/4"
90	3 1/2"				8	7/8"	5 1/4"
100	4"				8	7/8"	5 1/4"
125	5"	8	7/8"	5 1/2"	8	1"	6 1/4"
150	6"	12	7/8"	5 3/4"	12	1"	6 1/2"
200	8"	12	1"	6 1/2"	12	1 1/8"	7 1/2"
250	10"	16	1 1/8"	7 1/4"	16	1 1/4"	8 1/4"
300	12"	16	1 1/4"	7 3/4"	20	1 1/4"	8 1/2"
350	14"	20	1 1/4"	8"	20	1 3/8"	9"
400	16"	20	1 3/8"	8 1/2"	20	1 1/2"	9 3/4"
450	18"	24	1 3/8"	8 3/4"	20	1 5/8"	10 1/2"
500	20"	24	1 1/2"	9 1/2"	24	1 5/8"	11 1/4"
600	24"	24	1 3/4"	10 1/2"	24	1 7/8"	12 3/4"
750	30"				28	2"	14"
900	36"				28	2 1/2"	15 3/4"



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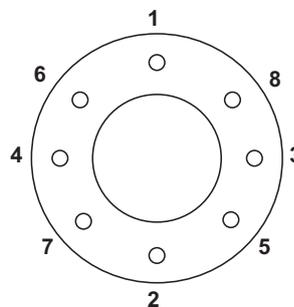
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Details for Bolting BS and ASA Pipe Flanges

Nominal Flange Size		900lb (1/16" Raised Face)			1500lb (1/4" Raised Face)			2500lb (1/4" Raised Face)		
mm	inches	Number of Studbolts	Diameter of Studbolts inches	Length of Studbolts inches	Number of Studbolts	Diameter of Studbolts inches	Length of Studbolts inches	Number of Studbolts	Diameter of Studbolts	Length of Studbolts
15	1/2"	For these sizes 1500lb Flanges are used			4	3/4"	4"	4	3/4"	4 3/4"
20	3/4"				4	3/4"	4 1/4"	4	3/4"	4 3/4"
25	1"				4	7/8"	4 3/4"	4	7/8"	5 1/4"
32	1 1/4"				4	7/8"	4 3/4"	4	1"	5 3/4"
40	1 1/2"				4	1"	5 1/4"	4	1 1/8"	6 1/2"
50	2"				8	7/8"	5 1/2"	8	1"	6 3/4"
65	2 1/2"				8	1"	6"	8	1 1/8"	7 1/2"
80	3"	8	7/8"	5 1/2"	8	1 1/8"	6 3/4"	8	1 1/4"	8 1/2"
90	3 1/2"	-	-	-	-	-	-	-	-	-
100	4"	8	1 1/8"	6 1/2"	8	1 1/4"	7 1/2"	8	1 1/2"	9 3/4"
125	5"	8	1 1/4"	7 1/4"	8	1 1/2"	9 1/2"	8	1 3/4"	11 1/2"
150	6"	12	1 1/8"	7 1/2"	12	1 3/8"	10"	8	2"	13 1/2"
200	8"	12	1 3/8"	8 1/2"	12	1 5/8"	11 1/4"	12	2"	15"
250	10"	16	1 3/8"	9"	12	1 7/8"	13 1/4"	12	2 1/2"	19"
300	12"	20	1 3/8"	9 3/4"	16	2"	14 3/4"	12	2 3/4"	21"
350	14"	20	1 1/2"	10 1/2"	20	2 1/4"	16"			
400	16"	20	1 5/8"	11"	20	2 1/2"	17 1/2"			
450	18"	20	1 7/8"	12 3/4"	20	2 3/4"	19 1/4"			
500	20"	20	2"	13 1/2"	20	3"	21"			
600	24"	20	2 1/2"	17"	20	3 1/2"	24"			

Flange Tightening

The correct tightening sequence is important in achieving flange integrity. The most reliable results are achieved by tightening diagonally opposite studbolts. Final tightening should be achieved in 3 to 4 complete cycles ensuring all studbolts are evenly tightened.



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