

# 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:

DN	Torgue (NN)	Screws
½"	25	4 x ½"
¾"	25	4 x ½"
1"	30	4 x ½"
1 ½"	60	4 x ½"
2"	80	4 x 5/8"
3"	94	4 x 5/8"
4"	70	8 x ¾"
6"	130	8 x ¾"
8"	180	8 x ¾"
10"	190	12 x 7/8"
12"	240	12 x 7/8"

#### 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® S58 PTFE gaskets between the flange connection. They are special designed for PTFE/PFA lined piping system

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