


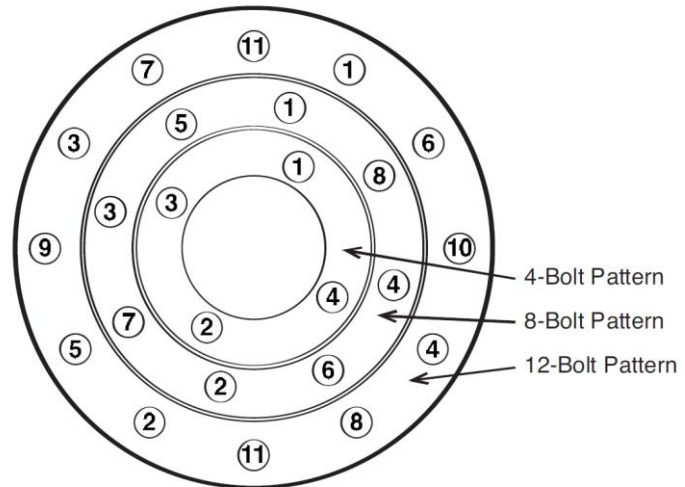


## FLANGE BOLT TORQUE TABLE

Flange assembly must be done with proper care. This document presents the recommended bolt torque in accordance with size and flange material:

	PVC and CPVC p.1
	HDPE p.2
	PP and PVDF p.3

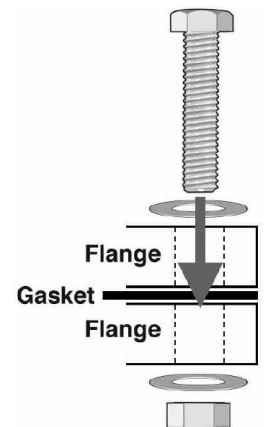
The bolt tightening sequence is common to all flange, regardless of the material.



Flanges in PVC and CPVC	
Flange size (in) ANSI/ASME B16.5	Recommended bolt torque. (ft/lb)
1/2	10-15
3/4	10-15
1	10-15
1-1/4	10-15
1-1/2	10-15
2	20-30
2-1/2	20-30
3	20-30
4	20-30
6	33-50
8	33-50
10	33-50
12	33-50
The recommended bolt torque in this table is for flange-to-flange connection.	

Note:

- 1-Do not exceed the recommended bolt torque.
- 2-Follow the bolt tightening sequence.
- 3-Make sure the piping is properly aligned.
- 4-Flanges should not be used to draw piping assemblies together.
- 5-A washer must be used under each bolt head and nut.
- 6-A final tightening after 24 hours is recommended.



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HDPE flange bolt torque table prescribes the use of a flat gasket in between the flanges. Flange bolting is done in multiple passes. The final tightening sequence should be done 24 hours after the previous one.

DO NOT EXCEED THE RECOMMENDED BOLT TORQUE.

Flanges in HDPE				
Flange size ANSI/ASME B16.5 Ø in inch	Recommended bolt torque. (ft/lb)			
	1st	2nd	3rd	4th
1	5	11	-	-
2	7	14	28	-
3	11	22	33	47
4	8	15	30	-
6	10	20	30	45
8	15	30	40	52
10	15	30	45	56
12	18	36	50	64
14	18	36	50	66
16	20	40	60	75
18	30	60	90	120
20	35	75	115	140
22	53	106	144	160
24	59	119	162	180

The recommended bolt torque in this table is for flange-to-flange connection.



When assembling flanges of different material together, you must consider the **lowest** bolt torque.

If using **stainless steel** bolt and nut, anti-seize lubricant must be used to prevent high friction and seizing.

PP and PVDF flange bolt torque table prescribes the use of a flat gasket in between the flanges. Flange bolting is done in multiple passes.

The final tightening sequence should be done 24 hours after the previous one.

**DO NOT EXCEED THE RECOMMENDED BOLT TORQUE.**

<b>Flanges in PP and PVDF</b>				
Flange size ANSI/ASME B16.5 Ø in inch	Recommended bolt torque. (ft/lb)			
	1st	2nd	3rd	4th
1/2	4	7	-	-
3/4	5	9	-	-
1	5	11	-	-
1-1/4	7	14	-	-
1-1/2	7	16	-	-
2	7	14	28	-
2-1/2	10	20	30	43
3	11	22	33	47
4	8	15	30	-
6	10	20	30	45
8	15	30	40	52
10	15	30	45	56
12	18	36	50	64
14	18	36	50	66
16	20	40	60	75
18	30	60	90	120
20	35	75	115	140
The recommended bolt torque in this table is for flange-to-flange connection.				