



FLANGE FITTING INSTRUCTIONS

CAUTION: TAKE GREAT CARE IN TIGHTING UP BOLTS ON PLASTIC FLANGES. FLANGES ARE FABRICATED AND WELDS CAN BE CRACKED OR BROKEN. IF IMPROPERLY HANDLED.

SPECIAL NOTE: Use Teflon* tape between threaded fitting connections. Use Viton A* gaskets between flanged connections for best results. Washers should be used for tightening bolts and nuts on flanged connections. Bolts for flanges should be thoroughly lubricated and the following torques are recommended for tightening the bolts: 1 1/2 -inch flanges/10 to 15 ft. lb., 2 to 4-inch flanges/20 to 30 ft. lb. and 6-inch flanges/33 to 50 ft. lb. The following bolt tightening sequence should be utilized for flanges.

* Products of E.I. DuPont deNemours & Co. (Inc.)

Tightening Thermoplastic Flange Bolts

On plastic flanged valves and fittings, the flange bolts should be tightened by pulling down on the nuts diametrically opposite each other using a torque wrench and in the order as numbered (see illustration). All bolts should be pulled down gradually to a uniform tightness (see recommendations below). Uniform stress across the entire cross section of the flange eliminates a leaky gasket.

RECOMMENDED BOLT TORQUES

Flange Size	Bolt Diameter	Recommended Torque*
1/2" to 1-1/2"	1/2"	10-15 ft. lbs.
2" to 4"	5/8"	20-30 ft. lbs.
6" to 8"	3/4"	33-50 ft. lbs.
10"	7/8"	53-75 ft. lbs.
12"	1"	80-110 ft. lbs.

*Refers to a well lubricated bolt.

All piping connected to the tank(s) should be properly supported to prevent unnecessary stress at the outlet, inlet and vent connections on the tanks. In addition, entire system shall be installed in accordance to manufacturer's recommendations, the local plumbing code and good workmanlike practices.

Adapters are also available to connect tanks to many special piping systems (e.g., glass piping, high-silicon piping, cast iron piping and lead piping), upon request.

Bolt tightening sequence for 150 lb. ANSI flanges (HDPE or PP)

*NOTE: Teflon-envelope, neoprene filled gaskets may be used instead of Viton-A gaskets, for flanged connections.