

INSTALLATION GUIDE

Dismantling Joint

Type A / Type B installation

Type A: DN50–DN300 · Type B: DN350–DN1200 | AQF-IG-DJ-001 | R3

Type A · DN50–DN300

Type A installation sequence. Tie-rod torque must be specified for the rod size, material grade and composition.

01 Set the minimum length

Position the spigot inside the flange adaptor until the front edge of the spigot is flush with the face of the flange adaptor. This is the minimum flange-to-flange distance.

02 Position between the mating flanges

Position the dismantling joint between the two flanges to which it connects. Withdraw the spigot until all free play is taken up, ensuring the maximum flange-to-flange dimension is not exceeded.

03 Check the gasket and lubrication

Check that the gasket grade is suitable for the conveyed medium. Check that the rubber seal is sufficiently lubricated where it contacts the adaptor barrel. If not, apply a suitable lubricant.

04 Fit the flange gaskets and bolts

Position the flange-connecting gaskets (not supplied) between both flange sets and loosely assemble the flange-connecting bolts.

05 Install the tie rods

Remove all nuts and washers from the tie rods and insert the rods from one side in their appropriate positions. Thread the nuts and washers back onto each tie rod in sequence as it is installed.

06 Tighten the flange connections

Tighten the flange-connecting bolts (not supplied) and tie rods in accordance with standard procedures.

07 Tighten the adaptor tie rods

Tighten diametrically opposed flange-adaptor tie rods, giving the nuts one or two turns at a time to draw up the end ring evenly. Tighten thoroughly, working around the flange adaptor as many times as necessary. Rubber may be seen to extrude into the gap between the end ring and spigot pipe.

Setting gap

Minimum	Nominal	Maximum
0 mm	25 mm	50 mm

At a 25 mm setting gap, overall length C equals C nom. Obtain the nominal overall length for the selected size from the corresponding product drawing.

Type A tightening requirement

To compress the rubber seal correctly, tighten in diametrically opposite pairs. The source torque section specifies 2 or 3 turns at a time to the prescribed torque. Tie-rod torque must be specified for the tie-rod size, material grade and composition. Do not apply the Type B stud table to the tie rods.

Type B · DN350–DN1200

01 Set the minimum length

Position the spigot inside the flange adaptor until the front edge of the spigot is flush with the face of the flange adaptor. This is the minimum flange-to-flange distance.

02 Position between the mating flanges

Position the dismantling joint between the two flanges to which it connects. Withdraw the spigot until all free play is taken up, ensuring the maximum flange-to-flange dimension is not exceeded.

03 Check the gasket and lubrication

Check that the gasket grade is suitable for the conveyed medium. Check that the rubber seal is sufficiently lubricated where it contacts the adaptor barrel. If not, apply a suitable lubricant.

04 Fit the flange gaskets and bolts

Position the flange-connecting gaskets (not supplied) between both flange sets and loosely assemble the flange-connecting bolts.

05 Install the tie rods

Remove all nuts and washers from the tie rods and insert the rods from one side in their appropriate positions. Thread the nuts and washers back onto each tie rod in sequence as it is installed.

06 Tighten the flange connections

Tighten the flange-connecting bolts (not supplied) and tie rods in accordance with standard procedures.

07 Tighten the adaptor studs

Tighten diametrically opposed flange-adaptor studs, giving the nuts one or two turns at a time to draw up the end ring evenly. Tighten thoroughly, working around the flange adaptor as many times as necessary. Rubber may be seen to extrude into the gap between the end ring and spigot pipe.

Setting gap

Minimum	Nominal	Maximum
0 mm	25 mm	50 mm

At a 25 mm setting gap, overall length C equals C nom. Obtain the nominal overall length for the selected size from the corresponding product drawing.

Type B sealing-stud torque

Stud size	Torque (Nm)
M12	70–80
M14	90–100
M16	100–120

Applies to the Type B flange-adaptor studs, not automatically to the tie rods or mating-flange bolts. Tighten opposite pairs evenly; the source torque section specifies 2 or 3 turns per pass.

Tie rods are separate

Tie-rod torque depends on size, material grade and composition. The 70–80 / 90–100 / 100–120 Nm stud ratings above do not establish tie-rod torque.