



# INSTALLATION INSTRUCTION

## TYPE 80

### 1. Protective covers

These serve to protect the beading sealing surface against mechanical damage and must only be removed directly prior to assembly. If removal for the purpose of inspection is necessary, the protective covers must subsequently be bolted tight.

**2. Welding, soldering and brazing** on the lined components is not permitted as this can damage the high-quality lining and give rise to the release of highly toxic gases.

**3.** The use of seals between PTFE/PTFE sealing faces is unnecessary. For connections to glass, ceramics, enamel and other components, an approximately 5 mm thick PTFE seal is recommended.

### 4. Installation

To prevent deformation of the sealing faces through over tightened bolts, the following torques should be referred to as a guide during assembly (The values apply to flanged joints up to PN 25 for bolts with lubricated thread).

### 5. Painting/insulation

These serve to protect the beading sealing surface against mechanical damage and must only be removed directly prior to assembly. If removal for the purpose of inspection is necessary, the protective covers must subsequently be bolted tight.

The bellows must not be painted or insulated.

### 6. Commissioning

After reaching operating temperature, the flange connections should be retightened with the specified torque. In case of leakages, the flange connections must be checked for parallelism or soiling or damage of the sealing face. Minor indentations or damage can be removed with emery cloth.

### 7. Installation of expansion joints

In addition to the aforementioned, the tie rods must not be removed after adjustment to maximum expansion or after installation.

DN	PN10			PN 25		
	Quantity	Thread	Md Nm	Quantity	Thread	Md NM
20	4	M12	10	4	M12	10
25	4	M12	20	4	M12	20
32	4	M16	30	4	M16	30
40	4	M16	40	4	M16	40
50	4	M16	50	4	M16	50
65	4	M16	70	8	M16	40
80	8	M16	40	8	M16	40
100	8	M16	40	8	M20	50
125	8	M16	50	8	M24	80
150	8	M20	60	8	M24	90
200	8	M20	90	12	M24	100
250	12	M20	60	12	M27	120
300	12	M20	70			
350	16	M20	110			
400	16	M24	160			
500	20	M24	180			
600	20	M24	240			
700	24	M27	260			