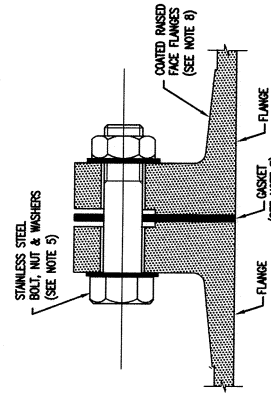
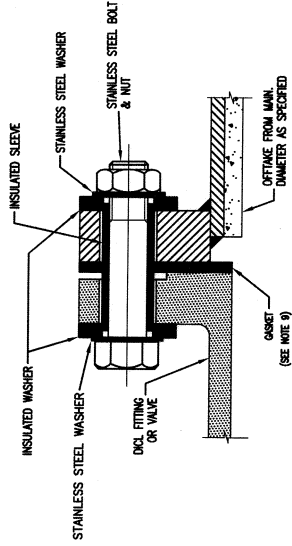


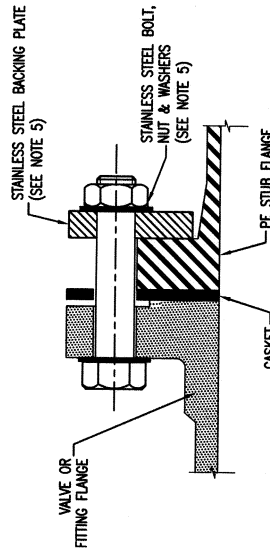
CORROSION PROTECTION PROCEDURE FOR BURIED DUCTILE IRON FLANGES WITH GALVANISED BOLTS
(SEE NOTE 2)



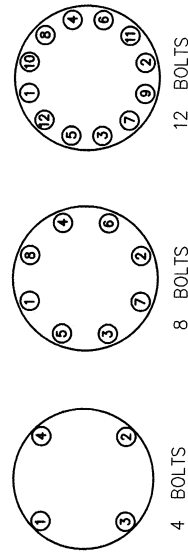
CORROSION PROTECTION PROCEDURE FOR DUCTILE IRON FLANGES WITH STAINLESS STEEL BOLTS
(SEE NOTE 3)



INSULATED FLANGED JOINT FOR STEEL MAINS
(SEE NOTE 6)



PE BOLTED CONNECTION DETAIL



TIGHTENING SEQUENCE

NOTES

1. ALL DIMENSIONS IN MILLIMETRES.
2. SLEEVE UNCOATED DUCTILE IRON FLANGES. USE GALVANISED BOLTS (SEE NOTE 4). APPLY TWO LAYERS OF SLEEVING OVER ALL BURIED BURTON COATED DUCTILE IRON FLANGES.
3. WHERE FLANGES ARE COATED WITH FUSION BONDED EPOXY OR NYLON THEY DO NOT REQUIRE SLEEVING, USE ONLY STAINLESS STEEL BOLTS (SEE NOTE 5). TAKE CARE TO PREVENT DAMAGE TO THE FLANGES' PROTECTIVE COATING.
4. BOLT SYSTEM - ONLY STAINLESS STEEL TO BE USED
 - (i) AFTER ASSEMBLY, COVER ALL BOLT HEADS AND NUTS WITH SEALING CAPS FILLED WITH CORROSION PREVENTION PRIMING PASTE.
 - (ii) WRAP THE ASSEMBLY WITH PETROLATUM TAPE OR WITH PE SLEEVING AND TAPED.
5. STAINLESS STEEL BOLT SYSTEM. ALL STAINLESS STEEL BOLTS, NUTS, WASHERS AND BACKING PLATES TO BE MANUFACTURED FROM 316 GRADE MATERIAL. COAT THE THREADED SECTIONS OF ALL STAINLESS STEEL BOLTS WITH AN ANTI-SIEZE LUBRICANT RECOMMENDED BY THE BOLT MANUFACTURER.
6. VERIFY THE INTEGRITY OF EACH INSULATED FLANGED JOINT AFTER ASSEMBLY.
7. USE SPECIAL HIGH RESISTIVITY (LOW CONDUCTIVITY) GASKET MATERIAL. NOT ALL ELASTOMERS ARE NON CONDUCTIVE.
8. ROUGHEN COATED RAISED FACE FLANGE SURFACES BEFORE ASSEMBLY. PERFORATION OF THE COATING DOES NOT MATTER ON THE CONTACT FLANGE FACES.
9. GASKET MATERIALS TO COMPLY WITH WSA 108.
10. TIGHTENING SEQUENCE SHOWN FOR AS 4087 FLANGES - ON450, LARGER SIZES TO FOLLOW SIMILAR PRINCIPLE.

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