

## ASSEMBLY INSTRUCTIONS FOR LOOSE FLANGE CONNECTIONS



### RECOMMENDED SEALS

DN 80 - DN 315: Seal ring for clamping rings  
from DN 350: Seal ring for 10 mm lip

### STEP 1

In order to mount the seal ring, the flange must be pushed back on one side of the flange connection. The seal ring can then be pulled over the lip.

### STEP 2

In the next step, the flange is pushed back to the seal ring.

The pipe parts to be connected must now be put together and the flange holes aligned to one another.

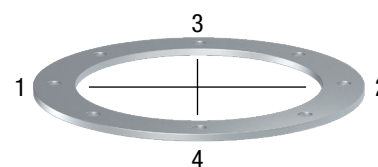
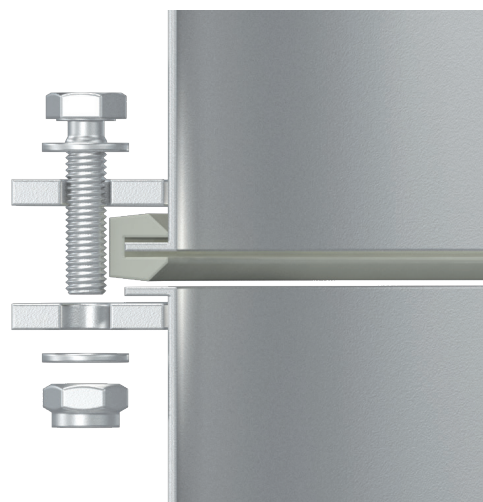
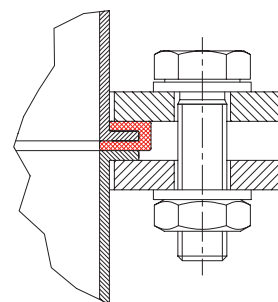
### STEP 3

Fit a washer to the first hexagonal head bolt, push it through both flange holes and fix it on the lower side with a washer and a hexagonal nut.

The bolted connections should be assembled in the specified order (1-2-3-4). The other bolted connections can be mounted in any order.

### STEP 4

Following the assembly, the M10 bolted connections should be tightened to a torque of 40 Nm (M12 to 60 Nm, M16 to 80 Nm). The bolted connections should be tightened in the same order in which they were assembled.



## WELDED FLANGE CONNECTIONS

### RECOMMENDED SEAL: FLAT SEAL

In the case of welded flanges, a flat seal is mounted instead of the seal ring for 10 mm lip. The rest of the assembly is done in the same order as listed above.

