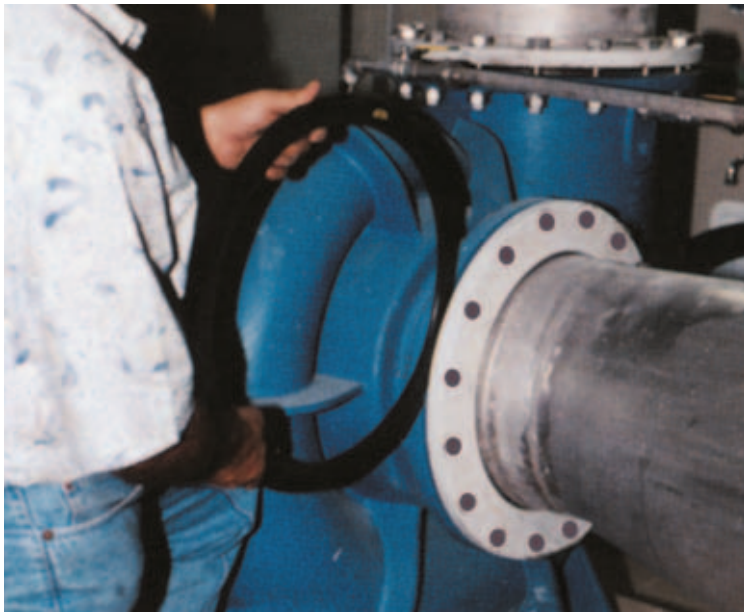
PSI Rubber Steel Gaskets Type G-S-S

Application Manual

- Flanges must be clean, dry and aligned in parallel before work starts.
- The gasket must not be damaged.
- Separating agents or lubricants containing grease should not come into contact with the rubber gasket.
- Tighten the screws evenly (crosswise) in multiple passes.
- The pipeline must be prevented from settling by the use of appropriate supporting material, otherwise the rubber gasket will be pinched on one side.
- Rubber/steel gaskets should not be used more than once.



Standard tightening torques for wedge-type rubber/steel flange gaskets					
ND	**PN 6**	**PN 10**	**PN 16**	**PN 25**	**PN 40**
15	6	11	11	11	11
20	10	16	16	16	16
25	13	21	21	21	21
32	22	36	36	36	36
40	28	45	45	45	45
50	31	58	58	58	58
65	42	77	77	38	38
80	70	45	45	45	45
100	74	49	49	70	70
125	50	64	64	105	105
150	54	89	89	124	124
200	76	123	82	123	155
250	65	102	127	177	234
300	105	105	160	177	245
350	136	133	177	264	345
400	111	160	223	340	515
500	120	188	316	370	437
600	173	250	480	500	

The torque specifications are based on a coefficient of friction of n = 0.12 and a maximum surface pressure of 15 N/mm^2, the number and sizes of screws complying with DIN standards 2632 to 2635.

The guideline values for tightening torques for flanges larger ND 600 can be calculated acc. to the following empirical formula:
PN 10: ND / 3 = torque in Nm
PN 16: ND / 1,5 = torque in Nm
PN 25: ND = torque in Nm
PN 40: ND * 2 = torque in Nm

If the raw materials consist of plastic, e.g. PE flanges, please note that the tightening torques must be adjusted or reduced according to the respective flange material.

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