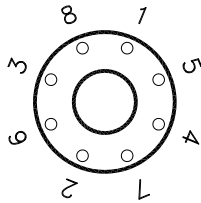
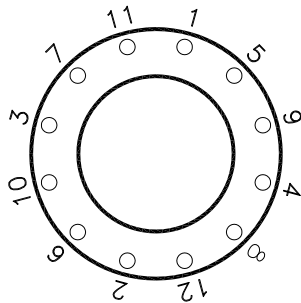


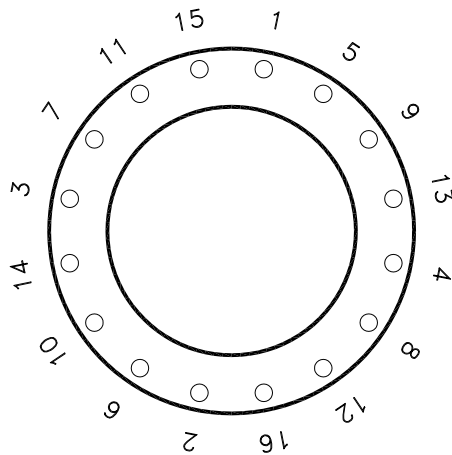
TYP. FOR 1" - 1.5"



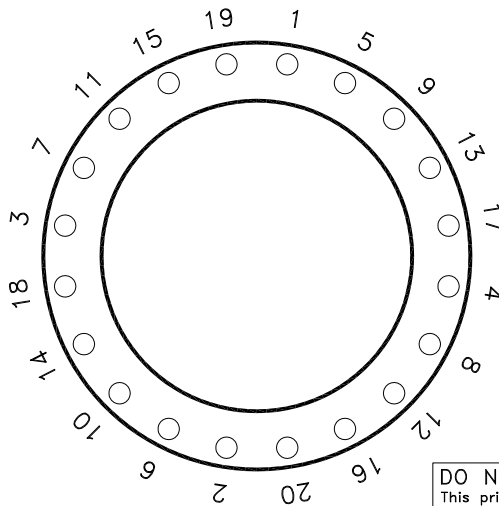
TYP. FOR 2" - 4"



TYP. FOR 6" - 8"



TYP. FOR 10" - 12"



TYP. FOR 14" - 16"

Bolt Size	Hvy Hex Socket Size
5/8"	1 1/16"
3/4"	1 1/4"
5/8"	1 1/16"
3/4"	1 1/4"
3/4"	1 1/4"
3/4"	1 1/4"
7/8"	1 7/16"
1"	1 5/8"
1 1/8"	1 3/4"
1 1/8"	1 3/4"
1 1/4"	2"
1 1/4"	2"
1 1/4"	2"
1 1/2"	2 3/8"

300# Bolt Torque (ft-lbs) - FLAT GASKETS				
Size	Hydrotest Pressure (psig)			
	225	300	348	435
1"Ø	45-68	47-71	47-71	50-75
1.5"Ø	57-86	60-90	62-93	66-99
2"Ø	21-32	22-33	23-35	25-38
3"Ø	28-42	31-47	33-50	37-56
4"Ø	52-78	57-86	59-89	65-98
6"Ø	43-65	52-78	52-78	60-90
8"Ø	58-87	67-101	71-107	83-125
10"Ø	72-108	83-125	88-132	103-155
12"Ø	88-132	102-153	108-162	126-199
14"Ø	84-126	99-149	106-159	
16"Ø	119-179	139-209	147-221	
18"Ø	111-167	131-197	140-210	
20"Ø	158-237	185-278	195-293	
24"Ø	218-327	249-374	265-398	

Example of reading these tables:
For a 6" flange connection with a flat rubber gasket hydrotested to 225psig, it is recommended to apply 43 to 65 ft-lbs of torque.

300# Bolt Torque (ft-lbs) - O-RING GASKETS				
Size	Hydrotest Pressure (psig)			
	225	300	348	435
1"Ø	40-60	40-60	41-62	41-62
1.5"Ø	49-74	49-74	49-74	50-75
2"Ø	16-24	17-26	17-26	17-26
3"Ø	20-30	21-32	21-32	21-32
4"Ø	40-60	41-62	41-62	42-63
6"Ø	28-42	29-44	29-44	31-47
8"Ø	34-51	36-54	37-56	39-59
10"Ø	46-69	48-72	49-74	52-78
12"Ø	54-81	57-86	59-74	63-95
14"Ø	48-72	51-77	53-80	
16"Ø	71-107	76-114	78-117	
18"Ø	64-96	70-105	72-108	
20"Ø	98-147	106-159	110-165	
24"Ø	127-191	139-209	145-218	

NOTE:

1. Typical sizes are based on ANSI B16.5 300#.
2. Hydrotest pressure is 1.5 times the design pressure.
3. If torque values higher than these published values are required, it is recommended that the connection should be unbolted and resealed with a new gasket.
4. When bolting to raised-face (RF) flanges, do not exceed the torque for o-ring gaskets.
5. 1ft-lb = 1.356N-m.
6. Values based on a "K" torque coefficient of 0.2.
7. Torque values below 40 ft-lbs may be insufficient, regardless of the pressure and rating. It is acceptable to apply a minimum of 40 ft-lbs to any size.

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DRAWING: Torque Sequences #4 - 300#

FILENAME: IS-E10-TRQ4

REV: R5 - SEP-23-2010

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