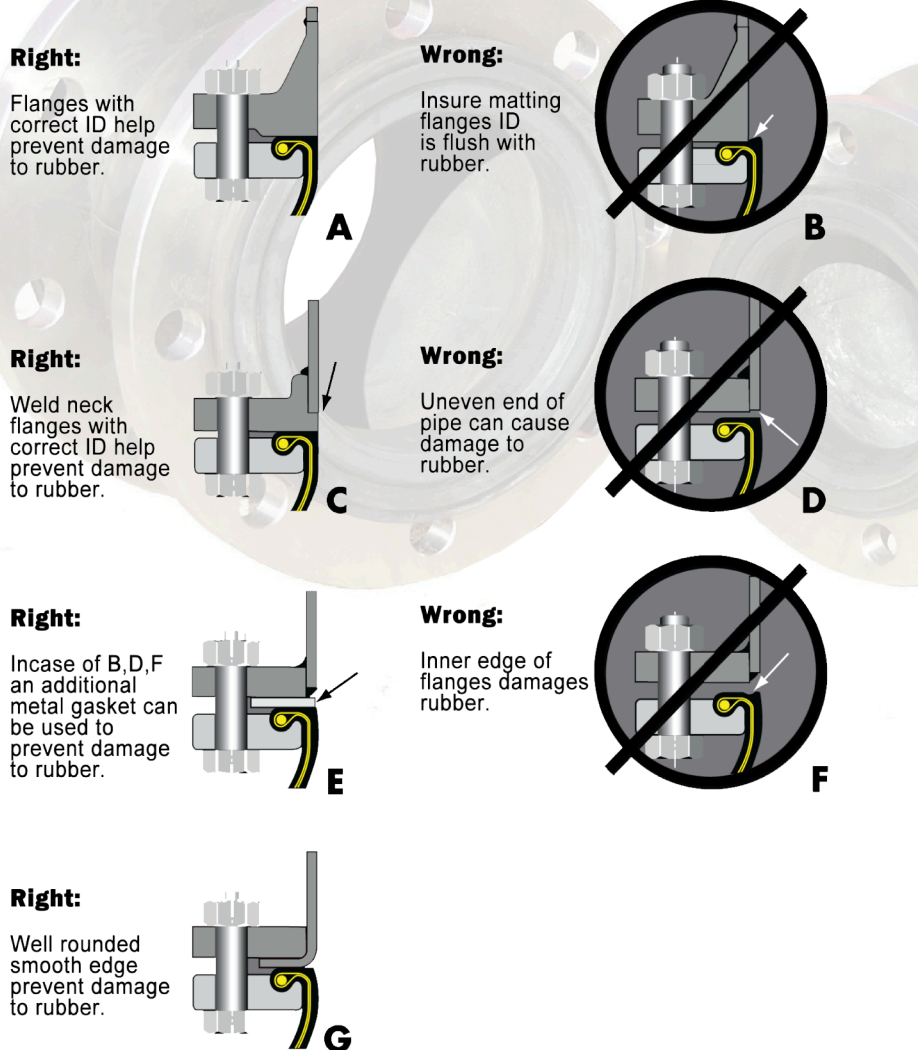


Installation Instructions for Non-Metallic Expansion Joints With Beaded End Flanges

Nominal Pipe Size Expansion Joint I.D. Inch / (mm)	Bolt-Torque				
	Step 1 FT-LBS (Nm)	Rest	Step 2 FT-LBS (Nm)	Rest	Step 3 FT-LBS (Nm)
1 (25)	18 (25)	30 Min	30 (40)	60 Min	45-60 (60-80)
1.25 (32)	18 (25)	30 Min	30 (40)	60 Min	45-60 (60-80)
1.5 (40)	18 (25)	30 Min	30 (40)	60 Min	45-60 (60-80)
2 (50)	18 (25)	30 Min	30 (40)	60 Min	45-60 (60-80)
2.5 (65)	18 (25)	30 Min	35 (50)	60 Min	50-60 (70-80)
3 (80)	25 (35)	30 Min	45 (60)	60 Min	60-75 (80-100)
3.5 (90)	25 (35)	30 Min	45 (60)	60 Min	60-75 (80-100)
4 (100)	25 (35)	30 Min	45 (60)	60 Min	60-75 (80-100)
5 (125)	25 (35)	30 Min	45 (60)	60 Min	60-75 (80-100)
6 (150)	30 (40)	30 Min	50 (70)	60 Min	60-75 (80-100)
8 (200)	30 (40)	30 Min	50 (70)	60 Min	60-75 (80-100)
10 (250)	30 (40)	30 Min	50 (70)	60 Min	75-85 (100-115)
12 (300)	30 (40)	30 Min	50 (70)	60 Min	75-85 (100-115)
14 (350)	30 (40)	30 Min	60 (80)	60 Min	75-95 (110-130)
16 (400)	30 (40)	30 Min	60 (80)	60 Min	75-95 (110-130)
18 (450)	30 (40)	30 Min	60 (80)	60 Min	90-95 (120-130)
20 (500)	30 (40)	30 Min	65 (90)	60 Min	95-185 (130-250)
24 (600)	30 (40)	30 Min	65 (90)	60 Min	95-185 (130-250)
30 (750)	30 (40)	30 Min	65 (90)	60 Min	95-220 (130-300)

Note: Bolt torque based on new bolts and nuts



Tighten opposing nuts/bolts gradually according to the following sequence

