

沟槽法兰安装指南

Installation Instruction For Grooved Flange



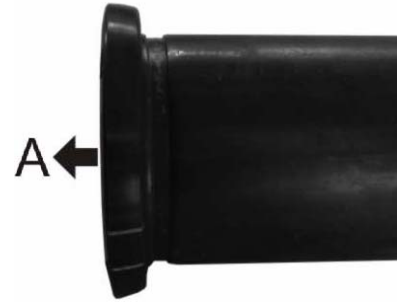
1. 管端检查 Pipe preparation

管端至沟槽的管道外表面必须清洁光滑，无毛刺，无凹陷、凸起（包括焊缝），无脱落油漆和滚制压痕等。安装前必须检查，确保无上述影响橡胶圈密封的缺陷。
Check pipe end for proper groove dimensions and to assure that pipe end is free of indentations and projections that would prevent proper sealing.



2. 检查并润滑橡胶圈 gasket Lubricate

检验橡胶圈，确保其适用于所用工况。在橡胶圈密封唇及外表面涂一薄层合适的润滑油，防止安装时挤橡胶圈。
Check gasket to be sure it's compatible for the intended service. Apply thin lubricant to the outside and sealing lips of the gasket.



3. 安装橡胶圈 gasket installation

将橡胶圈开口面朝A方向，缓慢套入并定位在钢管的管端处，确保橡胶圈的密封唇和管端平齐。
Slip the gasket over pipe end, with the gasket opening side towards "A". Make sure the gasket sealing lip is even with pipe end.



4. 安装法兰 Housing installation

将法兰两侧螺栓拆下，卡入已安装好橡胶圈的钢管端部沟槽内，然后先后插入两侧螺栓，手动拧紧螺母。
Remove bolts and nuts, place two housings over the gasket, making sure the housing keys fit into the pipe grooves. Re-insert the bolts and hand tighten the nuts.



5. 紧固两侧螺栓 Tighten nuts

首先用梅花扳手套进螺栓底部六角处，防止螺栓转动，然后用扭力扳手轮流并均匀地拧紧两侧螺母，以达到额定螺栓扭矩。
Securely tighten nuts alternatively and equally to the specified bolt torque by using spanner.



6. 连接配套法兰 mating flange Connect

将法兰螺栓孔与相配套的阀门的法兰面上的螺栓孔对准。将标准法兰螺栓分别插入螺栓孔，以对角交替的方式均匀拧紧螺母，直至达到标准法兰连接扭矩推荐值。安装完成。
Align flange bolt holes with mating flange (or valve) bolt holes. Insert a standard flange bolt through bolt hole and hand tighten a nut. Insert another bolt opposite the first and hand tighten a nut. Continue this until all bolt holes are fitted. Tighten nuts evenly to specified bolt torque, so flange faces remain parallel. Assembly completed.

注意/Caution

要达到额定性能，需要恰当的螺栓扭矩。螺栓扭矩过大会损坏铸件及螺栓（导致螺栓断裂），并致使连接脱落。螺栓扭矩过低会降低保压性能，减弱弯曲负荷能力，出现渗漏或导致连接脱落。一旦管子连接脱落，会造成重大的财产损失和严重的人身伤害！
Proper torquing of bolts is required to obtain specified performance.

- Over torquing the bolts may result in damage to the bolt and / or casting which could result in pipe joint separation.
- Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury.

额定螺栓扭矩 Specified Bolt Torque

公制螺栓/METRIC BOLTS		
螺栓尺寸/Bolt Size	额定螺栓扭矩/Specified Bolt Torque	
英寸/Inch	Lbs-Ft.	牛*米/N.m
M10	30-45	40-60
M12	80-100	110-135
M16	-	-
M20	-	-
M22	-	-
M24	-	-