

Fitting Instructions

1. Cleaning and Inspection

Remove all foreign material and debris from the seating surfaces, bolts or studs, nuts and washers. Please pay attention that you do not damage the sealing surface and please use a suitable tool.

Bolts, nuts and washers must be checked for burrs or cracks. Furthermore the sealing surfaces must be examined for faults and radial scratches. Damaged components must be replaced.

Material and dimensions of the flat gasket to be used, has to correspond to the specifications.



2. Fitting of the Flat Gasket

Insert the gasket smoothly into the space between the two flanges. The flanges should be aligned without using excessive force and the sealing surfaces must be positioned in plane-parallel to each other. Each and every deviation from the ideal adjustment must be corrected.



The gasket must be well centered by the stud-bolt and be fitted in clean, dry and without “jointing compounds” (lubricants). **Attention:** Especially graphite gaskets must not be wet before and during assembly!

3. Lubrication and Tightening of the Bolts

Use only specified or approved (check operating temperature!) lubricants. Apply lubricant uniformly to all thread, nut and load-bearing surfaces. Ensure lubricant does not contaminate either flange or gasket surface. We recommend using nitride washers.



Always use calibrated torque wrench or other controlled tensioning device.

The bolts are always tightened crosswise. After tightening the bolts by hand (**Attention:** after all for graphite gaskets the first bolt should never been tightened too much), you should use the torque-wrench three times for each bolt while every time raising the assembly torque a bit more (first time: 30%, second time: 60%, third time: 100%). Finally each bolt should be checked one after the other clockwise.



Make it absolutely sure to install the gasket with sufficient surface pressure!

4. Further Instructions

Never retighten elastomer-bonded asbestos-free gaskets after they having been exposed to high temperatures. Every retightening should only be made under ambient temperature and without pressure.

Removed soft gaskets should never be fitted again.

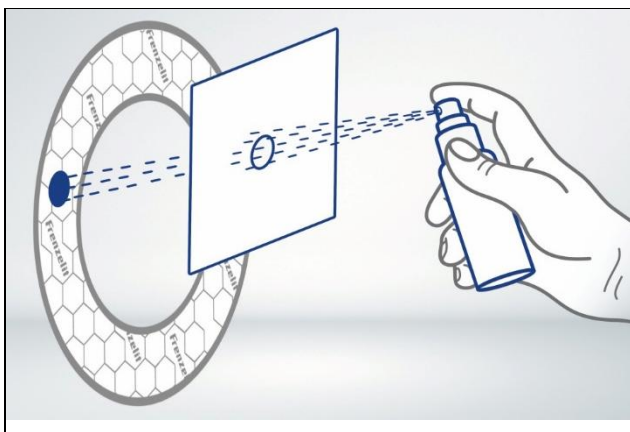
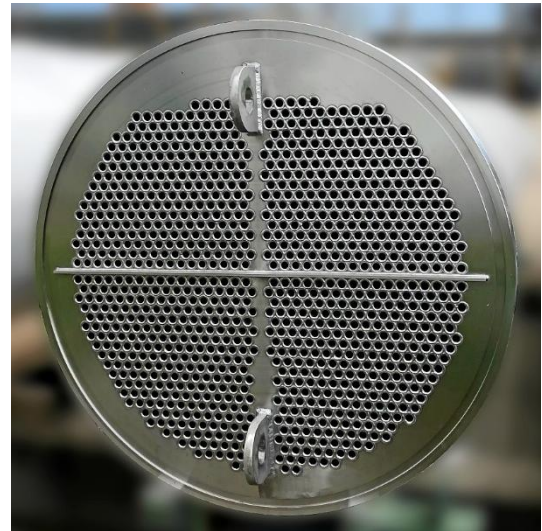


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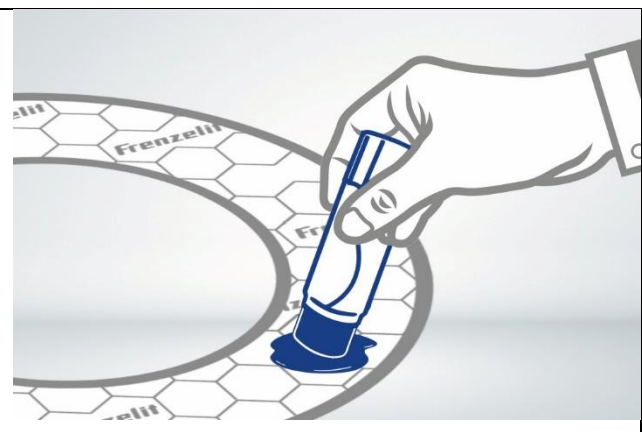
5. Assembly aid for complex installation situations

Gaskets must be correctly positioned before tightening the bolts. With standardized flanges, the bolt hole circle or grooves ensure the correct installation position. In the absence of such design features, the installation position of the gasket must be fixed in some other way. The same applies to vertical or overhead installation situations.

The correct positioning of the gasket can be ensured with a dosed use of adhesive. In order to avoid full-surface contamination of the gasket surface with the bonding agent, a small number of locally limited adhesive dots should be applied. The layer of adhesive dots should be as thin as possible. Ideally, this can be achieved using a template and suitable spray adhesive. Alternatively, a standard glue stick can be used. If possible, the adhesive dots should not cover the entire width of the gasket.



Application with spraying glue and template



Application with glue stick

Application engineering questions?

We help you at: gaskets@frenzelit.com, Phone: +49 9273 72-140

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