



Technical Information

Tolerances for connection flanges and installation dimensions for fabric expansion joints

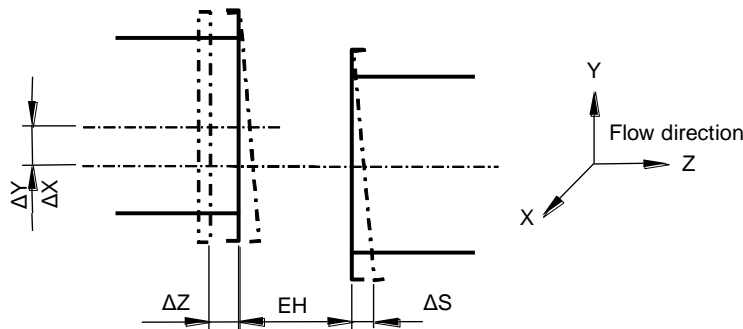
RAL-GZ 719

TI-013

Rev. 4

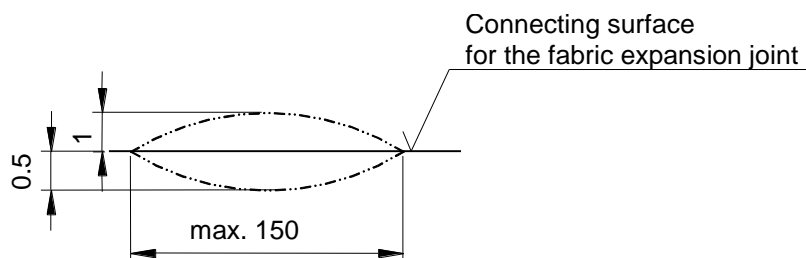
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1. Max. allowable tolerances for the connection flanges of fabric expansion joints



Installation length [EH]	$\Delta Z = -10\text{mm}, +5\text{mm}$
Lateral offset both directions	$\Delta X, \Delta Y = \pm 10\text{mm}$
Misalignment of flanges	$\Delta S = \pm 7\text{mm}$
Accumulated tolerances	$\Sigma = \sqrt{\max. (\Delta X^2; \Delta Y^2) + \Delta S^2} + \Delta Z \leq 10\text{mm}$

2. Max. allowable tolerances for the connecting surface of fabric expansion joints



Between measured distance of max. 150 mm may be either a smooth deepening of 0.5mm or a smooth superelevation of 1 mm compared with the theoretical shape.

Waviness of the duct flange max. ± 1 mm over a distance of 1000 mm.

Max. Roughness of flanges $R_t = 150 \mu\text{m}$.

Offset is not allowed at the splicing part of the flange area.

The connecting surface must be free of ridge, groove, notch, weld spatter.

**Edited by the Quality Committee of the Quality Association
for Fabric Expansion Joints**

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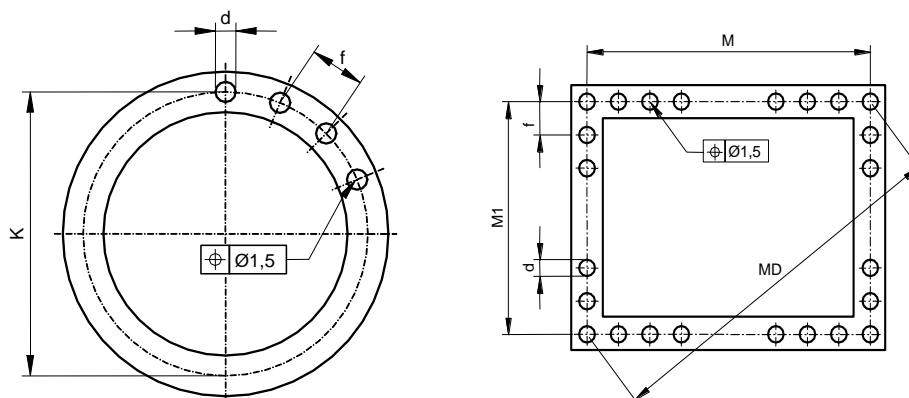
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3. Max. allowable tolerances for the hole pattern of fabric expansion joints



Pitch circle diameter <4000 mm
 Pitch circle diameter >4000 mm
 Centre distance <4000 mm
 Centre distance >4000 mm
 Diagonal distance <4000 mm
 Diagonal distance >4000 mm
 Pitch
 Hole diameter

K = ISO 2768-1 tolerance class m
 K = ISO 2768-1 tolerance class c
 M, M1 = ISO 2768-1 tolerance class m
 M, M1 = ISO 2768-1 tolerance class c
 MD = ISO 2768-1 tolerance class m
 MD = ISO 2768-1 tolerance class c
 f = ISO 2768-1 tolerance class c
 d = EN 20273-1 tolerance class g

All holes in the connecting flanges must be deburred on both sides.

4. General tolerances

Tolerances for length dimensions (compare ISO 2768-1)

Tolerance class	>6	>30	>120	>400	>1000	>2000	>4000	>8000	>12000	>16000
m	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6
c	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8

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