

Figure 71 Flange Adapters (ANSI Class 125/150)


The Figure 71 Flange Adapter is capable of pressures up to *300 psi (20,7 bar)* depending on pipe size and wall thickness. It provides a direct transition from flanged components to a grooved piping system. I.P.S. size flange bolt patterns conform to ANSI Class 125 and 150.

The gasket seal is designed with an optimal amount of rubber to provide a dependable seal and to avoid the gasket pocket from overfilling, which may cause assembly difficulties.



For detailed Listing / Approval information contact GRINNELL Mechanical Products.

Ductile Iron Housing Specifications

- ASTM A 536 – Standard specification for ductile iron castings, Grade 65-45-12
- ASTM A 153 – Standard specification for hot-dip galvanizing

Bolt/Nut Specifications

- **ANSI:** Carbon steel oval neck bolts and nuts are heat-treated and conform to the physical properties of ASTM A 183 Grade 2 and SAE J429 Grade 5 with a minimum tensile strength of 110,000 psi (*7584 bar*). Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 183 Grade 2 and SAE J995 Grade 5. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- **Metric:** Carbon steel oval neck track head bolts (Gold color coded) are heat treated and conform to the physical properties of ASTM F 568 M with a minimum tensile strength of 760 MPa. Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 563 M Class 9. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- Stainless steel bolts and nuts are available upon request.

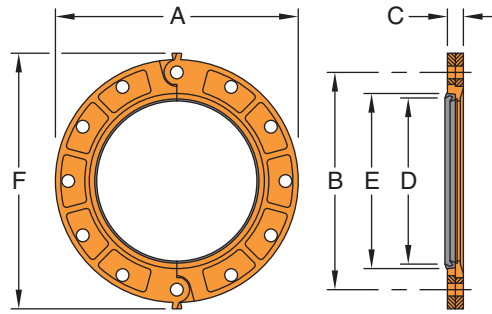
Coatings

- Orange – Non-lead paint (standard)
- Hot-Dipped, Zinc Galvanized (optional)

Gasket Specifications

- **Grade "E" EPDM** gaskets have a Green stripped color code identification and conform to ASTM D 2000 for service temperatures from -30°F to 230°F (*-34°C to 110°C*). They are recommended for hot water not to exceed 230°F (*110°C*), plus a variety of dilute acids, oil free air, and many chemical services. They are not recommended for petroleum services. For low temperature and vacuum systems, a **Tri-Seal Grade "E" EPDM gasket** with a rigid coupling is recommended.
- **Grade "T" Nitrile** gaskets have an Orange stripped color code identification and conform to ASTM D 2000 for service temperatures from -20°F to 180°F (*-29°C to 82°C*). They are recommended for petroleum products, vegetable oils, mineral oils, and air with oil vapors.

| PROJECT INFORMATION: | | APPROVAL STAMP: |
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| Project: | | |
| Date: | Phone: | |
| Architect / Engineer: | | |
| Contractor: | | |
| Address: | | |
| Notes: | | |

Figure 71 Flange Adapters (ANSI Class 125/150)


Sizes 2" - 12" (50mm - 300mm)

| Pipe Size | | Max † Pressure psi bar | Max End Load † Lbs. N | Dimensions - Inches mm | | | | | | Recommended Flange Mating Bolts ‡ | | Approx. Wt. Lbs kg |
|-------------------------|----------------------|---------------------------------|--------------------------------|------------------------|--------------|-------------|--------------|--------------|--------------|--|-----------|-----------------------------|
| Nominal Inches mm | O.D. Inches mm | | | A | B | C | *D | *E | F | Size Dia. x Lg Inches mm | Qty. | |
| 2 | 2.375 | 300 | 1,324 | 6.38 | 4.75 | 0.75 | 2.38 | 3.41 | 7.25 | $\frac{5}{8} \times 3$ | 4 | 30 |
| 50 | 60,3 | 20,7 | 5889 | 162,1 | 120,7 | 19,1 | 60,5 | 86,6 | 184,2 | — | 4 | 1,4 |
| 2½ | 2.875 | 300 | 1,948 | 7.00 | 5.50 | 0.88 | 2.88 | 3.91 | 7.88 | $\frac{5}{8} \times 3$ | 4 | 5.0 |
| 65 | 73,0 | 20,7 | 8665 | 178,0 | 140,0 | 22,0 | 73,0 | 99,0 | 200,0 | — | 4 | 2,3 |
| 76,1mm | 3.000 | 300 | 2,121 | 7.28 | 5.71 | 0.88 | 3.00 | 4.03 | 8.08 | $\frac{5}{8} \times 3$ | 4 | 5.8 |
| 65 | 76,1 | 20,7 | 9435 | 184,9 | 145,0 | 22,0 | 76,1 | 102,4 | 205,2 | — | 4 | 2,6 |
| 3 | 3.500 | 300 | 2,886 | 7.50 | 6.00 | 0.94 | 3.50 | 4.53 | 9.88 | $\frac{5}{8} \times 3$ | 4 | 5.6 |
| 80 | 88,9 | 20,7 | 12838 | 190,5 | 152,4 | 23,9 | 88,9 | 115,1 | 251,0 | — | 4 | 2,5 |
| 4 | 4.500 | 300 | 4,771 | 9.00 | 7.50 | 0.94 | 4.50 | 5.53 | 9.90 | $\frac{5}{8} \times 3$ | 8 | 7.0 |
| 100 | 114,3 | 20,7 | 21,222 | 228,6 | 190,5 | 23,9 | 114,3 | 140,5 | 251,5 | — | 8 | 3,2 |
| 139,7mm | 5.500 | 300 | 7,127 | 9.84 | 8.27 | 1.00 | 5.50 | 6.66 | 10.64 | $\frac{3}{4} \times 3\frac{1}{2}$ | 8 | 9.2 |
| 125 | 139,7 | 20,7 | 31,702 | 249,9 | 210,1 | 25,4 | 139,7 | 169,2 | 270,3 | — | 8 | 4,2 |
| 5 | 5.563 | 300 | 7,292 | 10.00 | 8.50 | 1.00 | 5.56 | 6.72 | 11.38 | $\frac{3}{4} \times 3\frac{1}{2}$ | 8 | 9.2 |
| 125 | 141,3 | 20,7 | 32,436 | 254,0 | 215,9 | 25,4 | 141,2 | 170,7 | 289,1 | — | 8 | 4,2 |
| 165,1mm | 6.500 | 300 | 9,955 | 11.22 | 9.45 | 1.00 | 6.50 | 7.66 | 12.10 | $\frac{3}{4} \times 3\frac{1}{2}$ | 8 | 11.0 |
| 150 | 165,1 | 20,7 | 44,282 | 285,0 | 240,6 | 25,4 | 165,1 | 194,6 | 307,3 | — | 8 | 5,0 |
| 6 | 6.625 | 300 | 10,341 | 11.00 | 9.50 | 1.00 | 6.62 | 7.78 | 11.88 | $\frac{3}{4} \times 3\frac{1}{2}$ | 8 | 10.0 |
| 150 | 168,3 | 20,7 | 45,999 | 279,4 | 241,3 | 25,4 | 168,1 | 197,6 | 301,8 | — | 8 | 4,5 |
| 8 | 8.625 | 300 | 17,528 | 13.50 | 11.75 | 1.13 | 8.62 | 9.94 | 14.38 | $\frac{3}{4} \times 3\frac{1}{2}$ | 8 | 16.6 |
| 200 | 219,1 | 20,7 | 77,968 | 342,9 | 298,5 | 28,7 | 218,9 | 252,5 | 365,3 | — | 8 | 7,5 |
| 10 | 10.750 | 300 | 27,229 | 16.00 | 14.25 | 1.19 | 10.75 | 12.31 | 16.88 | $\frac{7}{8} \times 4$ | 12 | 21.8 |
| 250 | 273,0 | 20,7 | 121,121 | 406,4 | 362,0 | 30,2 | 273,1 | 312,7 | 428,8 | — | 12 | 9,9 |
| 12 | 12.750 | 300 | 38,303 | 19.00 | 17.00 | 1.25 | 12.75 | 14.31 | 20.00 | $\frac{7}{8} \times 4$ | 12 | 24.2 |
| 300 | 323,9 | 20,7 | 170,380 | 482,6 | 431,8 | 31,8 | 323,9 | 363,5 | 508,0 | — | 12 | 11,0 |
| 14 | 14.000 | 300 | 46,181 | 21.00 | 18.76 | 1.44 | 14.00 | 15.03 | 24.00 | $1 \times 4\frac{1}{4} \bullet$ | 12 | 25.0 |
| 350 | 355,6 | 20,7 | 205,423 | 533,4 | 476,5 | 36,5 | 355,6 | 381,8 | 609,6 | — | 12 | 11,3 |
| 16 | 16.000 | 300 | 60,315 | 23.50 | 21.26 | 1.50 | 16.00 | 17.00 | 26.50 | $1 \times 4\frac{1}{4} \bullet$ | 16 | 31.0 |
| 400 | 406,4 | 20,7 | 268,294 | 596,9 | 540,0 | 38,10 | 406,4 | 431,7 | 673,1 | — | 16 | 14,0 |
| 18 | 18.000 | 300 | 76,455 | 25.00 | 22.76 | 1.63 | 18.00 | 19.01 | 29.00 | $1\frac{1}{8} \times 4\frac{3}{4} \bullet$ | 16 | 35.0 |
| 450 | 457,2 | 20,7 | 340,089 | 635,0 | 578,1 | 41,3 | 457,2 | 482,8 | 736,6 | — | 16 | 15,8 |
| 20 | 20.000 | 300 | 94,245 | 27.50 | 25.00 | 1.75 | 20.00 | 21.03 | 31.50 | $1\frac{1}{8} \times 4\frac{3}{4} \bullet$ | 20 | 45.0 |
| 500 | 508,0 | 20,7 | 419,223 | 698,5 | 635,0 | 44,5 | 508,0 | 534,2 | 800,1 | — | 20 | 20,4 |
| 24 | 24.000 | 250 | 135,720 | 32.00 | 29.50 | 1.93 | 24.00 | 25.05 | 36.00 | $1\frac{1}{4} \times 5\frac{1}{2} \bullet$ | 20 | 59.0 |
| 600 | 609,6 | 17,2 | 603,713 | 812,8 | 749,3 | 49,0 | 609,6 | 636,3 | 914,4 | — | 20 | 26,8 |

* Dimensions D and E represent minimum and maximum sealing surfaces.

• Metric segment bolt are available upon request.

† Maximum Pressure and End Load are total from all loads based on standard weight steel pipe. Pressure ratings and end loads may differ on other pipe materials and/or wall thickness. Contact GRINNELL Mechanical Products for details.

‡ Mating bolts and nuts are not supplied. Flange mating bolts must be at least SAE J429, Grade 5 or stronger. Bolt lengths are standard; responsibility lies with the purchaser to verify the correct length for the intended application.

For information on larger sizes, contact GRINNELL Mechanical Products.

See page 17 for coupling specifications and pages 247 - 254 for gasket information.

See page 35 for Flange Adapter Washers and page 292 Flange Drilling Specifications.

Figure 71 Flange Adapters (PN10/PN16)


The Figure 71 Flange Adapter is capable of pressures up to 300 psi (20,7 bar) depending on pipe size and wall thickness. It provides a direct transition from flanged components to a grooved piping system. I.P.S. size flange bolt patterns conform to PN10/PN16

The gasket seal is designed with an optimal amount of rubber to provide a dependable seal and to avoid the gasket pocket from overfilling, which may cause assembly difficulties.



For detailed Listing / Approval information contact GRINNELL Mechanical Products.

Ductile Iron Housing Specifications

- ASTM A 536 – Standard specification for ductile iron castings, Grade 65-45-12
- ASTM A 153 – Standard specification for hot-dip galvanizing

Bolt/Nut Specifications

- **ANSI:** Carbon steel oval neck bolts and nuts are heat-treated and conform to the physical properties of ASTM A 183 Grade 2 and SAE J429 Grade 5 with a minimum tensile strength of 110,000 psi (7584 bar). Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 183 Grade 2 and SAE J995 Grade 5. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- **Metric:** Carbon steel oval neck track head bolts (Gold color coded) are heat treated and conform to the physical properties of ASTM F 568 M with a minimum tensile strength of 760 MPa. Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 563 M Class 9. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- Stainless steel bolts and nuts are available upon request.

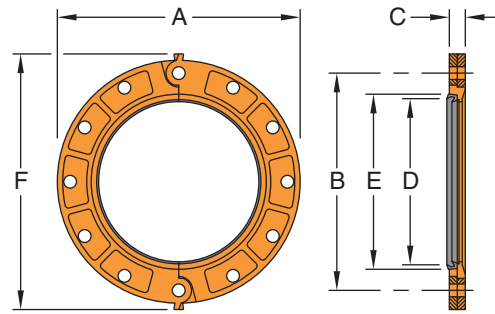
Coatings

- Orange – Non-lead paint (standard)
- Hot-Dipped, Zinc Galvanized (optional)

Gasket Specifications

- **Grade "E" EPDM** gaskets have a Green stripped color code identification and conform to ASTM D 2000 for service temperatures from -30°F to 230°F (-34°C to 110°C). They are recommended for hot water not to exceed 230°F (110°C), plus a variety of dilute acids, oil free air, and many chemical services. They are not recommended for petroleum services. For low temperature and vacuum systems, a **Tri-Seal Grade "E" EPDM gasket** with a rigid coupling is recommended.
- **Grade "T" Nitrile** gaskets have an Orange stripped color code identification and conform to ASTM D 2000 for service temperatures from -20°F to 180°F (-29°C to 82°C). They are recommended for petroleum products, vegetable oils, mineral oils, and air with oil vapors.

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Figure 71 Flange Adapters (PN10/PN16)


Sizes 2" - 12" (50mm - 300mm)

| Pipe Size | | PN10/ PN16 | Max † End Load Lbs. N | Dimensions - Inches mm | | | | | | Recommended Flange Mating Bolts ‡ | | Approx. Wt. Lbs kg |
|-------------------------|----------------------|------------------------|-----------------------------------|------------------------|--------------|-------------|--------------|--------------|--------------|--------------------------------------|-----------|-----------------------------|
| Nominal Inches mm | O.D. Inches mm | | | A | B | C | *D | *E | F | Size Dia. x Lg Inches mm | Qty. | |
| 2 | 2.375 | PN10 / PN16 | 1,324 | 6.38 | 4.92 | 0.75 | 2.38 | 3.41 | 7.25 | – | 4 | 3.0 |
| 50 | 60,3 | | 5889 | 162,1 | 125,0 | 19,1 | 60,5 | 86,6 | 184,2 | M16 x 76 | | 1,4 |
| 2½ | 2.875 | PN10 / PN16 | 1,948 | 7.00 | 5.50 | 0.88 | 2.88 | 3.91 | 5.13 | – | 4 | 5.4 |
| 65 | 73,0 | | 8665 | 177,8 | 139,7 | 22,4 | 73,6 | 99,3 | 130,3 | M16 x 76 | | 2,4 |
| 76,1mm | 3.000 | PN10 / PN16 | 1,948 | 7.28 | 5.70 | 0.88 | 3.00 | 4.03 | 8.09 | – | 4 | 5.0 |
| 65 | 76,1 | | 8665 | 184,9 | 144,8 | 22,4 | 76,1 | 102,4 | 205,5 | M16 x 76 | | 2,3 |
| 3** | 3.500 | PN10 | 2,886 | 7.88 | 6.30 | 0.94 | 3.50 | 4.53 | 8.75 | – | 4 | 5.6 |
| 80 | 88,9 | | 12,838 | 200,2 | 160,0 | 23,9 | 88,9 | 115,1 | 222,3 | M16 x 76 | | 2,5 |
| 3** | 3.500 | PN16 | 2,886 | 7.88 | 6.30 | 0.94 | 3.50 | 4.53 | 8.75 | – | 8 | 5.6 |
| 80 | 88,9 | | 12,838 | 200,2 | 160,0 | 23,9 | 88,9 | 115,1 | 222,3 | M16 x 76 | | 2,5 |
| 4 | 4.500 | PN10 / PN16 | 4,771 | 9.00 | 7.09 | 0.94 | 4.50 | 5.53 | 9.90 | – | 8 | 7.0 |
| 100 | 114,3 | | 21,222 | 228,6 | 180,1 | 23,9 | 114,3 | 140,5 | 251,5 | M16 x 76 | | 3,2 |
| 139,7mm | 5.500 | PN10 / PN16 | 7,292 | 9.84 | 8.27 | 1.00 | 5.50 | 6.53 | 10.69 | – | 8 | 9.2 |
| 125 | 139,7 | | 32,436 | 249,9 | 210,1 | 25,4 | 139,7 | 165,9 | 271,5 | M16 x 89 | | 4,2 |
| 165,1mm | 6.500 | PN10 / PN16 | 10,341 | 11.25 | 9.45 | 1.00 | 6.50 | 7.53 | 12.12 | – | 8 | 10.0 |
| 150 | 165,1 | | 45,999 | 285,8 | 240,0 | 24,5 | 165,1 | 191,3 | 307,8 | M20 x 89 | | 4,5 |
| 6 | 6.625 | PN10 / PN16 | 17,528 | 11.00 | 9.49 | 1.00 | 6.62 | 7.78 | 11.88 | – | 8 | 16.6 |
| 150 | 168,3 | | 77,968 | 279,4 | 241,1 | 25,4 | 168,1 | 197,6 | 301,8 | M20 x 89 | | 7,5 |
| 8** | 8.625 | PN10 | 27,229 | 13.38 | 11.61 | 1.13 | 8.62 | 9.94 | 14.31 | – | 8 | 21.8 |
| 200 | 219,1 | | 121,121 | 339,9 | 294,9 | 28,7 | 218,9 | 254,5 | 363,5 | M20 x 89 | | 9,9 |
| 8** | 8.625 | PN16 | 27,229 | 13.38 | 11.61 | 1.13 | 8.62 | 9.94 | 14.31 | – | 12 | 21.8 |
| 200 | 219,1 | | 121,121 | 339,9 | 294,9 | 28,7 | 218,9 | 254,5 | 363,5 | M20 x 89 | | 9,9 |
| 10** | 10.750 | PN10 | 38,303 | 15.56 | 13.78 | 1.19 | 10.75 | 12.31 | 16.50 | – | 12 | 22.5 |
| 250 | 273,0 | | 170,380 | 395,2 | 350,0 | 30,2 | 273,1 | 312,4 | 419,1 | M20 x 102 | | 10,2 |
| 10** | 10.750 | PN16 | 38,303 | 16.00 | 13.98 | 1.19 | 10.75 | 12.31 | 16.88 | – | 12 | 24.2 |
| 250 | 273,0 | | 170,380 | 406,4 | 355,1 | 30,2 | 273,1 | 312,7 | 428,8 | M22 x 102 | | 11,0 |
| 12** | 12.750 | PN10 | 29,621 | 17.52 | 17.52 | 1.25 | 12.75 | 14.31 | 16.56 | – | 12 | 27.5 |
| 300 | 323,9 | | 131,754 | 445,0 | 445,0 | 31,8 | 323,9 | 363,5 | 420,6 | M20 x 102 | | 12,5 |
| 12** | 12.750 | PN16 | 29,621 | 18.12 | 18.12 | 1.25 | 12.75 | 14.31 | 19.14 | – | 12 | 28.0 |
| 300 | 323,9 | | 131,754 | 460,2 | 460,2 | 31,8 | 323,9 | 363,5 | 486,2 | M22 x 102 | | 12,7 |

Maximum Pressure rating is 300 psi (20,7 bar).

* Dimensions D and E represent minimum and maximum sealing surfaces.

** For noted sizes, PN10 and PN16 dimensional values differ.

† Maximum End Load is total from all loads based on standard weight steel pipe. Pressure ratings and end loads may differ on other pipe materials and/or wall thickness. Contact GRINNELL Mechanical Products for details.

‡ Mating Bolts and Nuts are not supplied. Flange Mating Bolts must be at least SAE J429, Grade 5 or stronger. Bolt lengths are standard; responsibility lies with the purchaser to verify the correct length for the intended application.

For information on larger sizes, contact GRINNELL Mechanical Products.

See page 17 for coupling specifications and pages 247 - 254 for gasket information.

See page 35 for Flange Adapter Washers and page 292 Flange Drilling Specifications.

Figure 71 Flange Adapters (AS2129 Table E)


The Figure 71 Flange Adapter is capable of pressures up to *300 psi (20,7 bar)* depending on pipe size and wall thickness. It provides a direct transition from flanged components to a grooved piping system. I.P.S. size flange bolt patterns conform to AS2129 Table E.

The gasket seal is designed with an optimal amount of rubber to provide a dependable seal and to avoid the gasket pocket from overfilling, which may cause assembly difficulties.

Ductile Iron Housing Specifications

- ASTM A 536 – Standard specification for ductile iron castings, Grade 65-45-12
- ASTM A 153 – Standard specification for hot-dip galvanizing

Bolt/Nut Specifications

- **ANSI:** Carbon steel oval neck bolts and nuts are heat-treated and conform to the physical properties of ASTM A 183 Grade 2 and SAE J429 Grade 5 with a minimum tensile strength of 110,000 psi (*7584 bar*). Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 183 Grade 2 and SAE J995 Grade 5. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- **Metric:** Carbon steel oval neck track head bolts (Gold color coded) are heat treated and conform to the physical properties of ASTM F 568 M with a minimum tensile strength of 760 MPa. Carbon Steel heavy hex nuts conform to the physical properties of ASTM A 563 M Class 9. Bolts and nuts are zinc-electroplated conforming to ASTM B 633.
- Stainless steel bolts and nuts are available upon request.

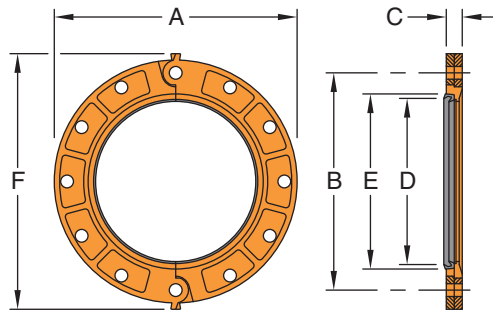
Coatings

- Orange – Non-lead paint (standard)
- Hot-Dipped, Zinc Galvanized (optional)

Gasket Specifications

- **Grade “E” EPDM** gaskets have a Green stripped color code identification and conform to ASTM D 2000 for service temperatures from -30°F to 230°F (*-34°C to 110°C*). They are recommended for hot water not to exceed 230°F (*110°C*), plus a variety of dilute acids, oil free air, and many chemical services. They are not recommended for petroleum services. For low temperature and vacuum systems, a **Tri-Seal Grade “E” EPDM gasket** with a rigid coupling is recommended.
- **Grade “T” Nitrile** gaskets have an Orange stripped color code identification and conform to ASTM D 2000 for service temperatures from -20°F to 180°F (*-29°C to 82°C*). They are recommended for petroleum products, vegetable oils, mineral oils, and air with oil vapors.

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| Contractor: | | |
| Address: | | |
| Notes: | | |

Figure 71 Flange Adapters (AS2129 Table E)


Sizes 3" - 8" (80mm - 200mm)

| Pipe Size | | Max † End Load Lbs. N | Dimensions - Inches mm | | | | | | Recommended Flange Mating Bolts ‡ | | Approx. Wt. Lbs kg |
|-------------------------|----------------------|--------------------------------|------------------------|--------------|-------------|-------------|-------------|--------------|--------------------------------------|-----------|-----------------------------|
| Nominal Inches mm | O.D. Inches mm | | A | B | C | *D | *E | F | Size Dia. x Lg Inches mm | Qty. | |
| 3 | 3.500 | 2,886 | 7.88 | 6.30 | 0.94 | 3.50 | 4.53 | 8.75 | – | 8 | 6.4 |
| 80 | 88,9 | 12,838 | 200,2 | 160,0 | 23,9 | 88,9 | 115,1 | 222,3 | M16 x 76 | 8 | 2,9 |
| 4 | 4.500 | 4,771 | 9.00 | 7.09 | 0.94 | 4.50 | 5.53 | 9.90 | – | 8 | 7.7 |
| 100 | 114,3 | 21,222 | 228,6 | 180,1 | 23,9 | 114,3 | 140,5 | 251,5 | M16 x 76 | 8 | 3,5 |
| 6 | 6.625 | 10,341 | 11.25 | 9.45 | 1.00 | 6.50 | 7.53 | 12.12 | – | 8 | 10.6 |
| 150 | 168,3 | 45,999 | 285,8 | 240,0 | 25,4 | 165,1 | 191,3 | 307,8 | M20 x 89 | 8 | 4,8 |
| 8 | 8.625 | 27,229 | 13.38 | 11.61 | 1.13 | 8.62 | 9.94 | 14.31 | – | 12 | 15.0 |
| 200 | 219,1 | 121,121 | 339,9 | 294,9 | 28,7 | 218,9 | 252,5 | 363,5 | M20 x 89 | 12 | 6,8 |

* Dimensions D and E represent minimum and maximum sealing surfaces.

† Maximum End Load is total from all loads based on standard weight steel pipe. Pressure ratings and end loads may differ on other pipe materials and/or wall thickness. Contact GRINNELL Mechanical Products for details.

‡ Mating Bolts and Nuts are not supplied. Flange Mating Bolts must be at least SAE J429, Grade 5 or stronger. Bolt lengths are standard; responsibility lies with the purchaser to verify the correct length for the intended application.

Maximum Pressure rating is 300 psi (20,7 bar).

For information on larger sizes, contact GRINNELL Mechanical Products.

See page 17 for coupling specifications and pages 247 - 254 for gasket information.

See page 35 for Flange Adapter Washers and page 292 Flange Drilling Specifications.