

Laying Instructions

for ductile cast iron pressure pipes and fittings DN 1200, 1400 and 1600

with bolted-gland socket joints
as per German standard DIN 28602

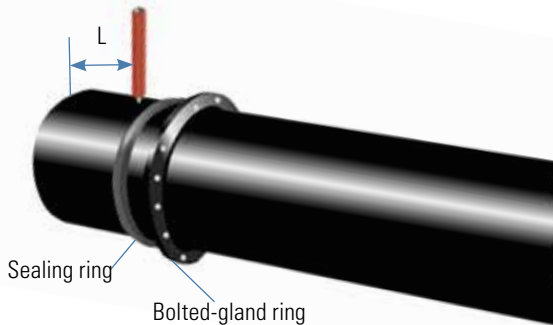
Laying Instructions for Bolted-Gland Socket Joints

Necessary parts for one bolted gland socket joint:

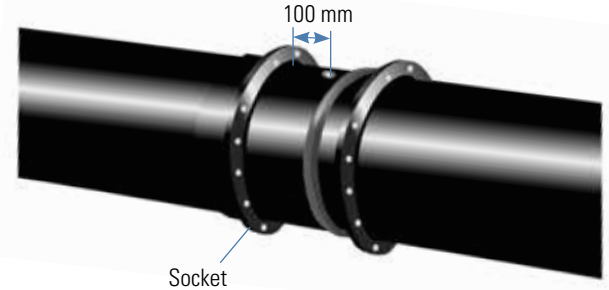
Bolted gland ring:	1
EPDM Gasket:	1
Hexagon screws + nuts:	DN 1200: 28, DN 1400: 32, DN 1600: 36
Washers:	DN 1200: 56, DN 1400: 64, DN 1600: 72
Lubricant for gasket/seat:	Neutrex
Lubricant for bolt thread:	Multis EP 2

Installation

- Clean the socket (particularly the sealing seat), the spigot to be inserted, the sealing ring and the bolted-gland ring
- Mark the distance measure $L = \text{DN 1200: 215 mm, DN 1400/1600: 275 mm}$
- Push the bolted-gland ring and sealing ring behind the marking.
- Lubricate the spigot end on a length of 200 mm. Lubricate the sealing ring seat inside the socket.
- Insert the spigot into the socket so a distance of 100 mm is kept between the mark and the flange.



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- Push the sealing into the sealing seat of the socket. Check that the spigot is correctly centred.
- Push the bolted-gland ring onto the sealing and align it using hardwood wedges.
- Insert hexagonal head bolts with washers into the bolted-gland flange and the bolted-gland ring.
- Lubricate bolt threads. Assemble the nuts with washers. Tighten the nuts lightly in order to align the sealing ring, generally beginning at the bottom.
- Then tighten the nuts one by one (always two nuts facing each other). While tightening, the width of the gap all around between the socket flange and the gland should never differ by more than 15 mm. The required torque is locally $150 \pm 20 \text{ Nm}$ per bolt. If deflection is required, the torque must be $60 \pm 10 \text{ Nm}$ per bolt before deflection. Tighten to $150 \pm 20 \text{ Nm}$ per bolt after deflection.
- Due to the characteristics of EPDM gaskets, we recommend to control the correct tightening torque before applying the test pressure.

Deflection

After tightening the joint in a centred and aligned position, the pipes can be deflected up to an angle of 2° .

Observe the above requirements on the torque for deflection.

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