

# GASKET INSTALLATION INSTRUCTIONS

## READ ALL INSTRUCTIONS THRU BEFORE BEGINNING INSTALLATION.

1. **CLEAN ALL** FLANGE GASKET SURFACES OF OLD GASKETS, OIL, DIRT, OR FOREIGN SUBSTANCES.
2. **INSPECT** THE FLANGE GASKET SEATING SURFACES. LOOK FOR TOOLMARKS, CRACKS, SCRATCHES OR PITTING. RADIAL TOOL MARKS ON THE GASKET-SEATING SURFACE ARE DIFFICULT IF NOT IMPOSSIBLE TO SEAL REGARDLESS OF THE TYPE GASKET BEING USED.
3. NOTIFY THE PROPER PERSONNEL OF EXCESSIVE PITTING, RADIAL TOOL MARKS, OR DAMAGE TO THE GASKET SURFACE SO THAT THEY CAN BE REPAIRED BEFORE PROCEEDING.
4. **INSPECT** THE GASKET TO BE INSTALLED FOR DAMAGE, AND MAKE SURE IT FITS THE GASKET SURFACE AREA PROPERLY.
5. BE **EXTREMELY CAREFULL** HANDLING THE NEW GASKET DURING INSTALLATION. TO PREVENT DAMAGE LEAVE PROTECTIVE WRAP, IF ANY, ON THE GASKET UNTIL READY FOR INSTALLATION.
6. **INSPECT** FOR DAMAGE, AND (CLEAN IF NOT NEW), EACH STUD, BOLT, NUT, WASHER, AND OR FLANGE SPRINGS. REPLACE ANY ITEMS OUT OF SPECIFICATION.
7. LUBRICATE WITH **APPROVED** LUBRICANT **ALL THREAD CONTACT AREAS AND NUT FACINGS, FLANGE DISK SPRINGS OR HARDENED FLAT WASHERS**. THE BETTER THE LUBRICANT; THE MORE CONSISTENT WILL BE THE ACTUAL APPLIED BOLT STRESS.
8. INSERT THE GASKET ONTO THE GASKET SURFACE BEING **CAREFUL** TO NOT DAMAGE THE GASKET DURING INSTALLATION. **DO NOT** USE TAPE TO HOLD GASKET IN PLACE UNLESS IT IS GRAPHITE TAPE. **DO NOT** USE LUBRICANTS ON THE GASKET SURFACE.
9. INSTALL THE BOLTS, (FLANGE SPRINGS OR HARDENED FLAT WASHERS, If Required), AND NUTS. BRING ALL NUTS UP HAND TIGHT AND SNUG EVENLY.
10. **NUMBER** ALL BOLTS PER BOLTING SEQUENCE SUPPLIED.
11. **PASS 1:** TORQUE TO A MAXIMUM OF 30% OF THE FINAL TORQUE VALUE SUPPLIED USING A CROSS TORQUE PATTERN PER THE BOLT SEQUENCE SUPPLIED.
12. **PASS 2:** TORQUE TO A MAXIMUM OF 60% OF THE FINAL TORQUE VALUE USING THE BOLT SEQUENCE AGAIN.
13. **PASS 3:** TORQUE TO THE FINAL 100% TORQUE USING THE BOLT SEQUENCE AGAIN.
14. **PASS 4:** THE FINAL STEP IN THE BOLTING PROCEDURE IS TO PERFORM A FINAL COUNTER TORQUE SEQUENCE. STARTING AT THE NEXT TO THE LAST BOLT THAT WAS TIGHTENED; APPLY THE FINAL TORQUE AROUND THE BOLTS IN A **CLOCKWISE** DIRECTION AROUND THE FLANGE UNTIL THE BOLTING PATTERN IS COMPLETED. ADDITIONAL CLOCKWISE PASSES MAY BE REQUIRED UNTIL NO FURTHER ROTATION OF THE NUT IS REQUIRED TO BRING ALL NUTS TO THE FINAL TORQUE VALUE.
15. **CRITICAL:** RETIGHTEN BOLTS TO FINAL TORQUE AGAIN WHEN OUTSIDE EDGE OF FLANGE REACHES 300 DEGS F. IF EXCHANGER RUNS COOLER THAN 300 DEGS F, RE-TIGHTEN ONCE MAX TEMP IS REACHED.
16. IF YOU HAVE PROBLEMS, OR DO NOT UNDERSTAND ANY PART OF THE INSTRUCTIONS CONTACT:

**DON BYBEE**

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