



Proper gasket installations help maximize performance and prevent NARs.

Inspection

- Remove old gasket and all residue from surface of flange carefully
- Inspect flange surface and new gasket for any defects prior to install
- Verify gasket material is as required for compatibility
- Repair all nicks/gouges (> 1/32" in depth) and replace where needed
 - Radial scratches MUST be repaired or replaced due to seal difficulty

Gasket Install

- Align flanges surfaces and bolt holes
- Ensure flanges are parallel to each other
- Insert gasket between the flanges on required sealing surface
 - If gasket contains bolt holes, ensure proper alignment
- ID of gasket should never be smaller than ID of flange
- Carefully compress mating flange down onto gasket
- Adhesive is only recommended when absolutely necessary
 - Coat minimum amount of gasket required to fix in place

Lubrication and Fasteners

- Confirm lubricant compatible with application parameters
- Recommended lubricant friction coefficient $K < 0.17$
- Liberally lubricate all bolt threads, washers, and nuts
 - Be careful not to contaminate gasket with lubricant
 - Hardened washers are recommended

Bolt Tightening

- Prior to tightening, consult torque tables based on application parameters to find target torque
- Never torque bolts under pressure
- If deviating from table parameters, further calculation required (consult Trelleborg engineering team)
- Utilize calibrated torque wrench during install
- Follow torque sequence and torque in star pattern as indicated below
- Final pass should be in clockwise fashion
- Depending on material, retorque bolts 24 hours after install

Torque Sequence

1st Pass	Finger Tight
2nd Pass	30%
3rd Pass	60%
4th Pass	100%
5 Pass	100%

