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Rotec Maximum Toque Settings for RTM Composite Backing Rings

Before applying the torque settings listed below, please ensure you thoroughly read the guidelines provided on the following page of this document.

Maximum Torque Settings [Nm]						
Pressure Rating [Pmax]	**3 bars / 6 bars**	**10 bars**	**16 bars**	**20 bars**	**25 bars**	**32 bars**
DN [mm]						
350	50	80	100	100	120	120
400	65	100	130	130	160	160
450	65	100	130	130	160	160
500	65	100	130	130	160	160
600	100	130	160	160	190	190
630	100	130	160	160	190	190
650	100	130	160	160	190	190
700	100	130	160	160	190	190
800	120	150	190	190	220	220
900	120	150	190	190	220	220
1000	140	180	220	220	250	260
1100	140	180	220	220	250	260
1200	160	200	250	260	280	300
1350	160	200	250	260	280	300
1400	180	220	260	280	320	-
1500	180	220	260	280	320	-
1600	200	250	290	300	-	-
1800	200	250	290	300	-	-
2000	230	280	320	-	-	-
2100	230	280	320	-	-	-
2200	230	280	320	-	-	-
2400	260	320	-	-	-	-
2600	260	320	-	-	-	-

Toque Guidelines

1. Application Method

- To achieve the maximum torque settings, refer to the "Bolted Connections/Tightening Sequences" file on our website.
- Use increments of 20Nm for dimensions from DN350 mm up to DN600 mm and for all raised face situations. For all other situations, use increments of 30Nm for dimensions above DN600 mm.

2. Be Aware

- The torque ratings for composite flanges are typically determined by the gasket used. Please consult your gasket supplier for the recommended torque rating. If the gasket requires a higher torque than the maximum allowable torque of the flange, you should change the type of gasket.
- The indicated torque ratings for composite flanges are maximum ratings designed to prevent flange damage. These torque ratings are based on new, un-greased bolts.

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