

Rotec Maximum Torque Settings for Hot Pressing SMC Composite 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]						
15	20	20	20	30	30	30
20	20	20	20	30	30	30
25	20	20	20	30	30	30
32	35	35	35	45	45	45
40	35	35	35	45	45	45
50	45	45	45	60	60	60
65	45	45	45	60	60	60
80	45	45	45	60	60	60
100	55	55	60	75	75	75
125	65	65	80	80	100	100
150	80	80	100	100	110	110
200	80	100	100	110	130	130
250	80	100	130	130	160	160
300	100	130	160	160	190	190

Torque Guidelines

1. Application Method

- To achieve the maximum torque settings, refer to the "Bolted Connections/Tightening Sequences" file on our website.
- Use increments of 15Nm for dimensions up to DN150 mm and for all raised face situations. For all other situations, use increments of 20Nm for dimensions up to DN300 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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