

Assemblyprotocol for IsoSeal flange-insulation-seals

GfD Paulmann GmbH (in-house)

taking into consideration the GfD assembly information for flange-insulation-seals or flange-insulation-seals with PTFE compact ring, the GfD table of tightening torques for flange fastening parts or respectively the flange-screw-calculation and the GfD information to the resistance of the used material in dependance of temperature and surrounding

1. Material control before assembly

Control of the flanges (sheets and sealing faces of the flanges have to be free of corrosion or respectively of damage)

Control of the IsoSeal flange-insulation-seals (gasket and carrier material, PTFE compact ring)

Control of the flange-screws (material class, galvanised / black, slightly lubricated)

2. Assembly

Dimensions: DN _____ PN _____

Material: _____

IsoSeal flange-insulation-seal is placed exactly parallel to the sealing faces of the flange / holes for the flange-screws and holes in the seal carrier have to **align** – NO offset!

IsoScrew insulation-screws are inserted with IsoUsch insulation-washer and steel washer into the flanges and the steel nuts have to be at least hand-tightend (crosswise).

Insulation of the flange-screws stands out into the washers on both sides.

Insulation-screws are tightend crosswise in at least three runs (30% / 70% / 100% of the table value – bigger screws with high tightening torques may be tightend in even more runs) with a suitable torque wrench considering the table or standard values. The screw tightening torques have to be written down.

1. run (30%)	2. run (70 %)	3. run (100%)

3. Control after assembly and putting into operation (warming up)

Isulation test with ohmmeter or isulation testing device.

Leak test with gas sniffing device or a lather leak test.

Assembly was done respecting point 1-3.

Date, place of assembly

installer

Date

approved by
