

Assembly Instructions for Nor-Cal Conflat and Wire Seal Type Flanges

1. Apply a small amount of high temperature anti-seize compound to the bolt threads.
2. Check that both flange surfaces are clean and sealing edges are free from nicks and scratches.
3. Using clean, lint free gloves, unpack gasket.
4. Place gasket in the knife edge counterbore of non-rotatable flange.
5. Align the mating hole pattern and leak test grooves.
6. Install the proper bolts and tighten hand tight. Check to see that the flange faces are parallel.
7. Tighten the bolts $\frac{1}{4}$ to $\frac{1}{2}$ turns using a circular clockwise pattern until the flange faces are metal to metal. Torque the fasteners to the listed value using the same pattern.

Torque Specifications for Conflat Flange Assembly

Nominal OD	Bolt Size	Torque in Inch Pounds
1 $\frac{1}{3}$	8-32	28
2 $\frac{1}{8}$	$\frac{1}{4}$ - 28	110
2 $\frac{3}{4}$	$\frac{1}{4}$ - 28	110
3 $\frac{3}{8}$	$\frac{5}{16}$ - 24	190
4 $\frac{1}{2}$	$\frac{5}{16}$ - 24	190
4 $\frac{5}{8}$	$\frac{5}{16}$ - 24	190
6	$\frac{5}{16}$ - 24	190
6 $\frac{3}{4}$	$\frac{5}{16}$ - 24	190
8	$\frac{5}{16}$ - 24	190
10	$\frac{5}{16}$ - 24	190
12	$\frac{5}{16}$ - 24	190
13 $\frac{1}{4}$	$\frac{3}{8}$ - 24	345
14	$\frac{3}{8}$ - 24	345
14 $\frac{1}{2}$	$\frac{3}{8}$ - 24	345
16 $\frac{1}{2}$	$\frac{3}{8}$ - 24	345

These torque specs are for Nor-Cal supplied fasteners only.

Dimensions in inches

Torque Specifications for Wire Seal Flange Assembly

Nominal OD	Bolt Size	Torque in Inch Pounds
12	$\frac{3}{8}$ - 24	345
14	$\frac{3}{8}$ - 24	345
17	$\frac{1}{2}$ - 20	850
19	$\frac{1}{2}$ - 20	850
22	$\frac{5}{8}$ - 18	1,450
27	$\frac{5}{8}$ - 18	1,450

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Dimensions in inches