EXPANDED PTFE SEALING TAPE

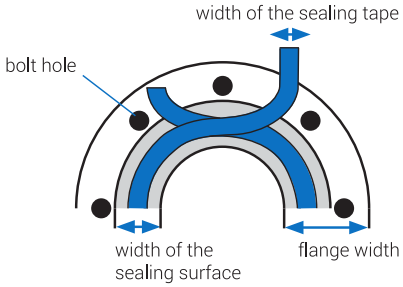
MADE IN ITALY

1 SELECTION OF SIZE

a. For flat face flanges

Please select the nominal width of the sealing tape from the table:

b. For tongue and groove flanges: The width of the sealing tape should be equal to or less than the groove width.



Effective sealing width (mm)	Tape width (mm)
3 - 7	3
7 - 10	5
10 - 17	7
17 - 25	10
25 - 32	12
32 - 40	14
40 - 50	17
50 - 65	20
65 - 80	25
80 - 95	30
95 - 120	40

2 INSTALLATION

2.1 Installation – sealing tape

a. Preparing the flange

- Open the flange connection.
- Sealing surface should be cleaned of old sealing materials.

b. Applying the sealing tape

- Remove the masking tape a little at a time to prevent the adhesive strip from picking up dirt. A dirty adhesive surface could cause a misplacement of the sealing tape during assembly.
- Position the start of the sealant tape close to a bolt hole (figure 1).

c. Closing the sealing tape

- Complete the installation by overlapping both ends at the starting bolt hole.
- Use a sharp knife or a pair of scissor to cut away the excess material, leaving approx. 1 cm protruding material (figure 2).

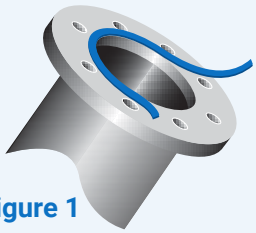


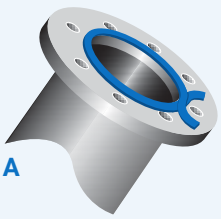
Figure 1



Figure 2

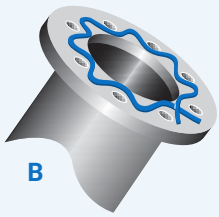
Note: When the sealing tape has a nominal width of ≥ 20mm the skive cut technique must be used since there is not enough force to compress the double thickness of the overlap joint. The skive cut technique can be always used as an alternative to the overlap technique if you are uncertain.

flat face flanges



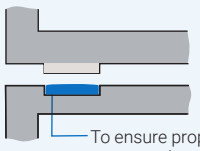
A

fragile flanges



B

Tongue and groove



C

To ensure proper gasket compression, the tongue must be equal to or taller than the groove depth.

2.2 Installation – sealing tape with nominal width ≥ 20mm:

Perform step 2.1 a and 2.1 b but with a skive cut on both ends.

a. Skive cut at the beginning

- Unwind around 0,5 m of the sealing tape and cut the end with a sharp knife by using the skive cut technique → length of the skive cut (l_s) = approx. 25 mm, angle α < 15° (figure 3).

b. Closing skive cut

- Complete the installation by placing the sealing tape over the skived end and overlap approx. 14 mm of the sealing tape.
- For the second skive cut mark the start and end points (figure 4).
- Cut away excess material with an angle of 15 degrees. The interface should be 20% thicker than the original sealing tape (figure 5).

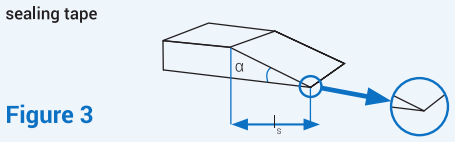


Figure 3

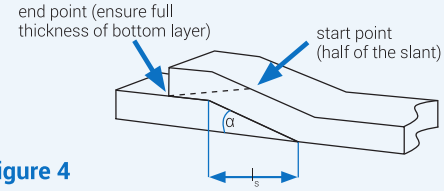


Figure 4

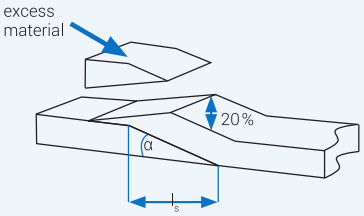
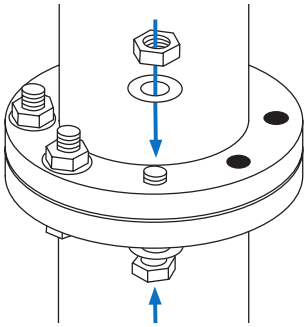
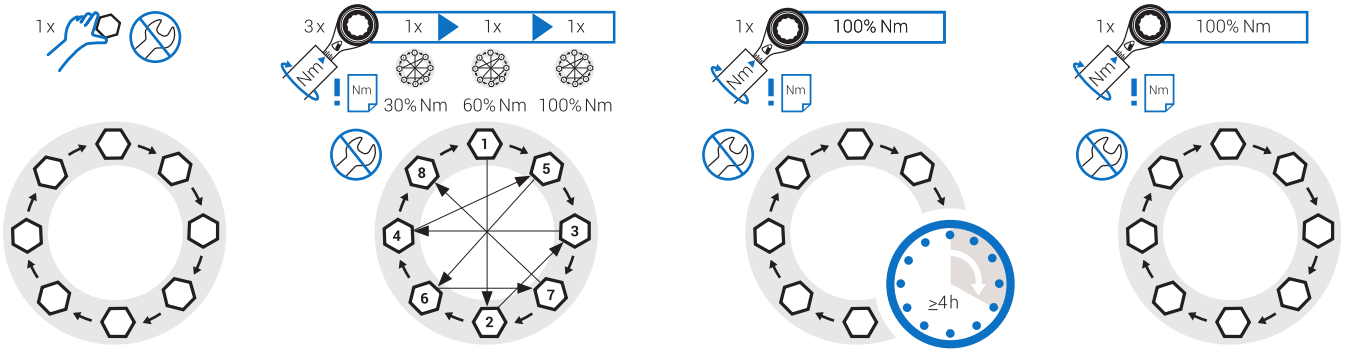


Figure 5

3 TORQUING



1. Install screws, nuts and washers, properly lubricated, on the flange.



2. The screws are initially hand tightened in a sequential circular pattern.

3. Tighten the screws crosswise in three phases by using a calibrated torque:

- 1st pass: 30% of target torque
- 2nd pass: 60% of target torque
- 3rd pass: 100% of target torque

4. Tighten the screws crosswise with 100% of the torque and wait for 4 hours.

5. For final installation retighten the screws crosswise until the required torque is reached.

For further details on gasket installation, please refer to the ESA / FSA Guidelines for safe seal usage — Flanges and Gaskets, available from the Fluid Sealing Association and the European Sealing Association.

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