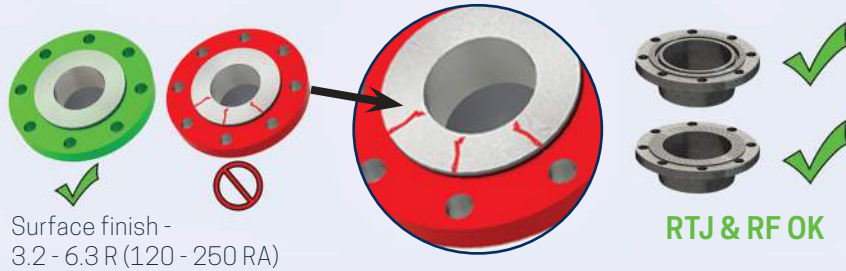


GPT VCXT[®] Installation Instructions

- 1.** CLEAN & INSPECT FLANGE FACE - Ensure flange face finish is in accordance with ASME PCC-1 guidelines



- 2.** Ensure wide enough flange gap and alignment is created BEFORE installing gasket 1/8" (3mm) larger than gasket thickness



DO NOT ATTEMPT TO INSTALL GASKET PRIOR TO ALIGNING FLANGES

- 3.**

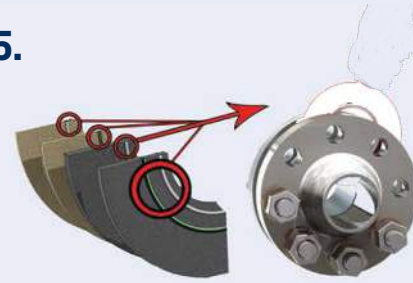


NOTE: ALWAYS USE NEW BOLTS, NEVER RE-USE WASHERS, SLEEVES OR GASKETS ONCE INSTALLED

- 4.**



- 5.**



SUGGESTION

For isolation gaskets - use the cardboard included in the packaging during installation to help protect the seals and isolating materials from damage. (Additional flange gap may be required)



- 6.**



Install remaining studs with washers and sleeves

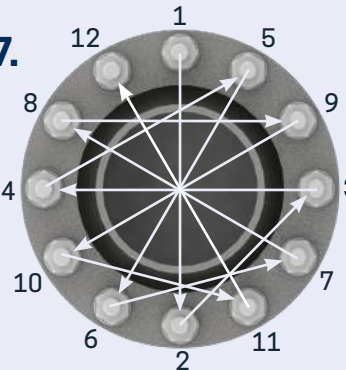


Always use a torque wrench or appropriate tensioning equipment



Never use impact drivers or hammer wrenches! This can cause damage to the isolation washers, sleeves, and gaskets.

- 7.**



TORQUE IN LEGACY STAR PATTERN

1. Snug each stud to 10-20 [ft-lb] (14-27 Nm)
2. Tighten to 30% of target torque
3. Tighten to 70% of target torque
4. Tighten to 100% of target torque
5. Final torque to 100% in circular pattern



Installation guidance video can be found at: www.gptindustries.com/installer

RECOMMENDED BOLT TORQUE VALUES

Torque Table for GPT Isolating Gaskets							
NPS	150#	300#	600#	900#	1500#	2500#	NPS
	REC	REC	REC	REC	REC	REC	
ASME B16.5 Recommended Values in [ft-lb]							
½	40	40	40	80	80	80	½
¾	45	70	70	105	105	105	¾
1	45	90	90	160	160	160	1
1¼	45	90	90	235	235	270	1¼
1½	45	160	160	350	350	395	1½
2	90	90	90	240	240	275	2
2½	90	160	160	340	340	380	2½
3	90	160	160	255	540	600	3
3½	90	160	255	N/A	N/A	N/A	3½
4	90	160	255	560	785	1020	4
5	160	160	380	785	1290	1500	5
6	160	160	380	560	1000	2175	6
8	160	255	560	1065	1640	2020	8
10	255	380	785	1065	2385	3180	10
12	255	560	785	1065	2490	4560	12
14	380	560	1065	1400	3055	N/A	14
16	380	785	1400	1805	4210	N/A	16
18	560	785	1805	2830	6055	N/A	18
20	560	785	1805	3465	7295	N/A	20
24	785	1400	2830	6200	10850	N/A	24
METRIC (Nm)							
½	54	54	54	109	109	109	½
¾	61	95	95	142	142	142	¾
1	61	122	122	217	217	217	1
1¼	61	122	122	319	319	366	1¼
1½	61	217	217	475	475	536	1½
2	122	122	122	326	326	373	2
2½	122	217	217	461	461	515	2½
3	122	217	217	346	732	814	3
3½	122	217	346	N/A	N/A	N/A	3½
4	122	217	346	760	1065	1383	4
5	217	217	516	1065	1750	2034	5
6	217	217	516	760	1356	2950	6
8	217	346	760	1444	2224	2738	8
10	346	516	1065	1444	3234	4312	10
12	346	760	1065	1444	3377	6184	12
14	516	760	1444	1899	4143	N/A	14
16	516	1065	1899	2448	5710	N/A	16
18	760	1065	2448	3836	8209	N/A	18
20	760	1065	2448	4699	9892	N/A	20

NOTES:

1. All values are calculated assuming a 0.11 coefficient of friction and new nuts and studs using non-metallic lubrication.
2. "M" maintenance factor = 4 "Y" minimum design seating stress = 3625 [psi]. For EVOLUTION™ isolating gasket "Y" = 0.
3. Recommended values are based on 30,000 psi bolt stress. Max values are based on 50,000 psi bolt stress**
4. If using both lubricated and coated studs or uncoated bolts with no lubricant, contact GPT for recommended torque values.

NOTE: On isolating testing - any isolation testing should be completed prior to hydro testing in order to prevent media in line from causing false readings. It's suggested that isolation be checked with the use of an RF meter as per NACE SP0288-2007 standard practice.

It should be noted that humidity and other environmental effects can cause false isolation readings.

For additional assistance please contact our engineering office at GPT.engineering@gptindustries.com

GPT Industries
303.988.1242
www.gptindustries.com

FOR METRIC TORQUE VALUES - $Nm = \frac{ft-lb}{0.73756}$
divide ft-lb value by 0.73756

**Please note that Recommended and Max torque values are based on bolt stresses of B7, or equivalent studs, Grade 2H hex nuts, and A105 or equivalent flange material. For lower strength flanges or bolts contact GPT Engineering for torque recommendations.

The GPT gasket torque calculator is available at www.gasketcalculator.gptindustries.com

