

ALKY-ONE® Torque Values

Recommended Torque Values (ft-lb)		
Pipe Size	150#	300#
1/2"	30	30
3/4"	40	50
1"	50	70
1-1/2"	60	130
2"	130	70
2-1/2"	130	100
3"	130	140
4"	120	220
5"	200	220
6"	220	200
8"	220	330
10"	350	420
12"	350	630
14"	530	500
16"	480	710
18"	750	880
20"	750	880
24"	1130	1310

Torque values are for carbon steel ASME B16.5 raised face flanges and B7 or B7M studs.

Advanced Sealing

Installation Instructions and Notes for the ALKY-ONE Gasket

1. Confirm that flanges are undamaged, clean and properly aligned before installing gasket.
2. Spread flanges to insert the ALKY-ONE gasket without damage to the barrier pillow.
3. Use new studs when installing the ALKY-ONE gasket.
4. Use a high-quality molybdenum anti-seize such as JetLube 550 Extreme.
5. Use a clicker torque wrench.
6. Use a flange gap tool to ensure even compression.
7. Finger-tighten all studs for alignment, then torque in even increments using a star-cross pattern.
8. Tighten to the value listed on this chart.

Questions? Call (562) 802-7782