

SPIRAL-WOUND GASKETS

Suggested Torque Values (ft.-lbs.)*

Based on ASTM A193 B7 bolting or equal yield strength bolt material.

Class 150																			
Size	1/2	3/4	1	1-1/4	1-1/2	2	2-1/2	3	4	5	6	8	10	12	14	16	18	20	24
Torque	50	60	60	60	60	120	120	160	120	200	200	260	320	320	500	500	710	710	1000

Class 300																			
Size	1/2	3/4	1	1-1/4	1-1/2	2	2-1/2	3	4	5	6	8	10	12	14	16	18	20	24
Torque	50	90	105	120	200	105	140	175	200	200	200	320	500	710	620	875	1000	1000	1400

* Note: Use new, correct size, bolts/studs, nuts, and washers (torques NOT for PTFE coated bolting). Not suitable for flange materials with elongation at failure less than 20%. Use antiseize or graphite oil on bolt threads and nut faces. Listed torques are for the final pass. After hand tightening, torquing must follow the cross bolting sequence (star pattern) and there shall be 3 complete passes at 30%, 60% and 100% of final torque. Once final torque is achieved, there should be a minimum of 2 clockwise passes until there is no further nut rotation. **As recognized by ASME, spiral wound gaskets without an inner ring may buckle under ANY load due to the nature of the materials used.**