



Uni-Flange Assembly Instructions Series 200, 400 and 420 Adapter Flanges

1. Pipe end should be cut square, removing any burrs and bevels. Clean the plain end of the pipe. Thoroughly lubricate the pipe and gasket with a soap based pipe lubricant. Slide the flange onto the pipe with the gasket cavity facing the end of the pipe. Slide the lubricated gasket over the pipe end, with the tapered end facing the gasket cavity in the flange. (No other gasket is necessary or should be used to seal the flange faces).
2. Slide the flange forward until the gasket is evenly seated in the flange cavity, and the Uni-Flange® face is flush with the end of the pipe. (The end of the pipe should butt against the facing flange, it cannot be more than 1/4" from the facing flange). Hand tighten the set screws against the pipe surface.
3. Using conventional flange bolts, mate the Uni-Flange to the standard flange. Be sure to evenly tighten the bolts alternately on opposite sides. (Use the star method like tightening the lug nuts on a car wheel). Do not over-tighten the flange bolts. It is not necessary to bring the Uni-Flange Adapter to a face to face contact with the standard flange. A gap of approximately 1/8" between the flanges is normal.
4. Snug down all the set screws evenly. Tighten in an alternating manner (star method) to the torque values shown in the chart to the right. Use of a torque wrench is highly recommended.

Note: In installations where rapid or excessive surges may occur, or extreme thrusts encountered (e.g. near pumps or 90° bends), Uni-Flange engineers recommend the use of tie rods for additional thrust restraint.

FLANGE SIZE	SET SCREW	RECOMMENDED SET SCREW TORQUE VALUES (FT. LBS.)						
		▲ DUCTILE IRON PIPE (THICKNESS CLASS)				STEEL PIPE (SCHEDULE)		
		50	51	52	53+	20	30	40+
2"	1/2" x 1"	-	-	70	70	-	-	35
2-1/2"	1/2" X 1"	-	-	-	-	-	-	35
3"	1/2" X 1"	-	50	70	70	-	-	70
3-1/2"	1/2" X 1"	-	-	-	-	-	-	70
4"	1/2" x 1"	-	50	70	70	-	-	70
5"	5/8" x 1-1/4"	-	-	-	-	-	-	70
*6"	1/2" x 1-1/4"	50	60	70	70	-	-	70
**6"	5/8" x 1-1/4"	50	60	90	90	-	-	90
8"	5/8" x 1-1/4"	50	60	90	90	50	90	90
10"	5/8" x 1-1/4"	50	60	90	90	50	90	90
12"	5/8" x 1-1/4"	50	60	90	90	50	90	90
14"	5/8" x 1-1/4"	60	70	90	90	60	90	90
16"	5/8" x 1-1/4"	60	70	90	90	60	90	90
18"	3/4" x 2"	70	80	115	115	60	100	115
20"	3/4" x 2"	70	80	115	115	70	100	115
24"	3/4" x 2"	70	80	115	115	70	100	125
30"	1" x 2-1/4"	90	110	125	125	-	-	125
36"	1" x 2-1/4"	90	110	125	125	-	-	125
42"	1" x 2-1/4"	90	110	125	125	-	-	125
48"	1" x 2-1/4"	90	110	125	125	-	-	-

▲ Consult factory for use on pressure class pipe.

Uni-Torque Set Screws have
preset torque values
1/2" x 1" = 70 Ft. Lbs. ± 5
5/8" x 1-1/4" = 85 Ft. Lbs. ± 5
Uni-Torque Set Screws are only recommended
on Class 52 thru 56 Ductile Iron Pipe and
Schedule 40 steel.

* refers to Series 200
** refers to Series 200/420
FLANGE ADAPTER



SERIES 200
2" THROUGH 12"
SERIES 400
2" THROUGH 8"

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