



## Installation Instructions For SELF LOCATOR and RING Gaskets

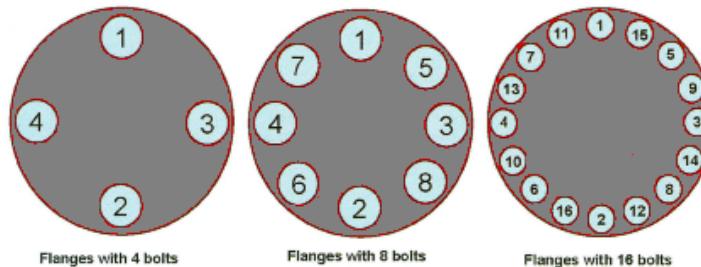
### Precaution

Observe all depressurizing, cooling and safety procedures before installation. Read all instructions before proceeding. To successfully install the Selco Seal® Flange Gasket, the following procedure is recommended and is independent of tightening method used.

- I. Inspect the gasket sealing surfaces. Look for tool marks, cracks, scratches or pitting. Radial tool marks on a gasket sealing surface are virtually impossible to seal regardless of the type of gasket being used. If reworking flanges is not feasible, consider relocating the position of the sealing element on the gasket surface or specify a double sealing path.
- II. Inspect the gasket. Verify that the gasket specification matches the requirements of the flange.
- III. Inspect and clean each stud or bolt, nut, washer and the flange face. Replace or repair any item out of specification. New stud or bolts should be used if flange has witnessed thermal cycling where the temperature limits for the studs and / or springs might have been exceeded.
- IV. Lubricate with recommended lubricant, all thread contacts areas and nut facings. The better the lubricant, the more consistent will be the actual applied bolt stress. Improperly lubricated bolting materials can decrease bolting stress by as much as 50%. A Premium Anti-Seize Lubricant is recommended.
- V. Insert the gasket between the flange facing to allow a bolt to center the gasket. Install the balance of the bolts and nuts and bring to a finger tight condition. Take care not to damage the sealing elements.



Gaskets must be installed by authorized, experienced personnel. Any non-compliance with our instructions can lead to equipment damage and/or personnel harm.



- VI. Bolts should now be torqued 45% to 65% of the bolts yield value in a four (4) step tightening sequence. Torque figures are determined by the bolt diameter, the material from which the bolts are made and in service temperature should be considered at times. Sealing Corporation recommends the use of B-7 Bolts or equivalent whenever feasible.

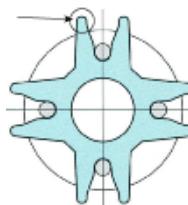
**Pass 1:** Bring all nuts up hand tight; then snug tight evenly.

**Pass 2:** Torque to a maximum of 30% of the final torque.

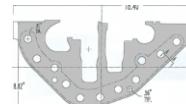
**Pass 3:** Torque to a maximum of 60% of the final torque.

**Pass 4:** Torque to the final 100% torque.

After the four (4) basic torquing passes are complete, continue torquing the nuts using the final 100% torque in a clockwise manner around the flange until no further rotation of the nut is observed. This process may require an additional five (5) to seven (7) passes.  
*Note: Good bolting practice requires a minimum of two (2) threads above the nut after torquing.*



- VII. For SELF LOCATOR Gaskets, after assembly, protruding portions of locating tines should be turned over if applicable.



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