NOTICE

In an effort to continually improve our product performance, and provide our customers with the best materials and products available, we are providing this performance gasket material. This new material is preferred as it can be used with all service applications (e.g. steam, water and hot oil).

Care should be exercised in handling before and during installation. IT IS FRAGILE, and should not be bent, folded, cut or damaged in any way, in order to optimize its performance in service.

The new material has been tested and approved under our ISO 9001 procedures and meets or exceeds Kadant Johnson's gasket specifications. If you have any questions, please contact your local sales representative or Kadant Johnson's customer service team at 269.278.1715.

Recommended Torque For Joint Heads, Bodies, and/or Wear Plates

<table>
<thead>
<tr>
<th>Nominal Diameter of Bolt</th>
<th>Recommended Torque Ft-Lb</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/4˝</td>
<td>5</td>
</tr>
<tr>
<td>3/8˝</td>
<td>18</td>
</tr>
<tr>
<td>7/16˝</td>
<td>31</td>
</tr>
<tr>
<td>1/2˝</td>
<td>35</td>
</tr>
<tr>
<td>9/16˝</td>
<td>60</td>
</tr>
<tr>
<td>5/8˝</td>
<td>60</td>
</tr>
<tr>
<td>3/4˝</td>
<td>100</td>
</tr>
<tr>
<td>1˝</td>
<td>200</td>
</tr>
<tr>
<td>“5/8˝</td>
<td>120</td>
</tr>
</tbody>
</table>

*Use for 1150 joint only and 9700, 9800 and 9950 joint body to bracket

All torques are with light oil lubricated bolts.
GASKET INSTALLATION
AND
BOLT TORQUING PROCEDURE

1. MAKE SURE THE PARTS THAT ARE TO BE GASKETED ARE CLEAN AND FREE FROM ALL DEBRIS, IN THE AREA WHERE THE GASKET WILL BE LOCATED.

2. WITH GASKET IN PLACE INSTALL THE REQUIRED CAP SCREWS FINGER TIGHT.

3. PARTIALLY TIGHTEN THE CAP SCREWS USING THE PROPER PATTERN SHOWN IN FIGURE 1.

4. REPEAT STEP 3 UNTIL THE CAP SCREWS ARE TIGHT TO THE REQUIRED TORQUE.

5. SEE A-97-16-4-4 FOR MINIMUM TORQUE VALUE.

FIGURE 1

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PATTERN NO: 
REFERENCE DRAWING: 
TREATMENT: 

ANGULAR TOLERANCE: ±0°30' 
LOCATION: 111 
REQ. NO: US021991-17 

MATERIAL: 

DEBURR: 

DRAWN BY: SAB 
CHECKED BY: 
DATE: FEB-4-1991 

PROJECTION: 

TITLE: GASKET INSTALLATION AND BOLT TORQUING PROCEDURE 

SYMBOL NO: A-97-1608-4-1 
SCALE: NONE OF: 1 
PAGE: 1 
DRAWING NO: A32050 
REV: C 

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