



an EnPro Industries company

**TORQUE TABLE SPECIFIC TO VCXT ONLY**

Notes-

1. The max recommended value is not an absolute max value for the products relevant to this table. The absolute max value for these products could exceed the maximum allowable limits of the other components in a bolted flange assembly.

2. All values have been calculated assuming a 0.16 Coefficient of Friction and new nuts and studs. If using non-lubricated bolts, increase torque by 15%. For PTFE or Xylan™ coated studs use the recommended values shown here.

3. "M" Maintenance Factor = 0  
"Y" Minimum Design Seating Stress = 7500 [psi]

4. The Max torque value is based on the use of bolts with a yield strength of 100,000 [psi]

**NOTE ON ISOLATION TESTING.**  
ANY ISOLATION TESTING SHOULD BE COMPLETED PRIOR TO HYDRO TESTING IN ORDER TO PREVENT MEDIA IN LINE FROM CAUSING FALSE READINGS. IT IS SUGGESTED THAT ISOLATION BE CHECKED WITH THE USE OF AN RF METER AS PER NACE SPO286-2007 STANDARD PRACTICE.

IT SHOULD BE NOTED THAT HUMIDITY AND OTHER ENVIRONMENTAL EFFECTS CAN CAUSE FALSE ISOLATION READINGS

For additional assistance please contact our engineering office-

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**INCH [ft-lb]**

NPS	150#	300#	600#	900#	1500#	2500#
	Recommended [ft-lb]					
1/2	50	50	50	105	105	105
3/4	60	90	90	135	135	135
1	60	120	120	210	210	210
1 1/4	60	120	120	315	315	360
1 1/2	60	210	210	470	470	525
2	120	120	120	320	320	365
2 1/2	120	210	210	450	450	505
3	120	210	210	340	720	800
3 1/2	120	210	340	NA	NA	NA
4	120	210	340	745	1045	1355
5	210	210	505	1045	1715	2000
6	210	210	505	745	1330	2900
8	210	340	745	1415	2190	2690
10	340	505	1045	1415	3180	4240
12	340	745	1045	1415	3315	6075
14	505	745	1415	1865	4075	NA
16	505	1045	1865	2405	5610	NA
18	745	1045	2405	3775	8070	NA
20	745	1045	2405	4620	9725	NA
24	1045	1865	3775	8265	14465	NA

**METRIC (Nm)**

NPS	150#	300#	600#	900#	1500#	2500#
	Recommended Nm					
1/2	68	68	68	142	142	142
3/4	81	122	122	183	183	183
1	81	163	163	285	285	285
1 1/4	81	163	163	427	427	488
1 1/2	81	285	285	637	637	712
2	163	163	163	434	434	495
2 1/2	163	285	285	610	610	685
3	163	285	285	461	976	1085
3 1/2	163	285	461	N/A	N/A	N/A
4	163	285	461	1010	1417	1837
5	285	285	685	1417	2326	2712
6	285	285	685	1010	1803	3932
8	285	461	1010	1919	2970	3648
10	461	685	1417	1919	4312	5749
12	461	1010	1417	1919	4495	8238
14	685	1010	1919	2529	5526	N/A
16	685	1417	2529	3261	7607	N/A
18	1010	1417	3261	5119	10943	N/A
20	1010	1417	3261	6265	13187	N/A
24	1417	2529	5119	11207	19615	N/A

Torque table specific to VCXT only

# GPT VCXT ISOLATION GASKET INSTALLATION INSTRUCTIONS

**1. SURFACE FINISH- 120-250 RA**

**RTJ AND RF OK**

**2. 10-12mm**

**3. APPLY Piko-Lube® DO NOT USE METALLIC BASED LUBRICANTS**

**STEEL WASHER FIRST**

**G10 WASHER AGAINST FLANGE FACE**

**INSTALL SLEEVE ON BOLT**

**NOTE- FOR HCS COATED WASHERS USE 2 WASHERS PER SIDE**

**NOTE- ALWAYS USE NEW BOLTS**

**4. INSTALL SLEEVES AND WASHERS ON BOTTOM HALF OF FLANGE ASSEMBLY FOR EASY ALIGNMENT OF TYPE-GASKETS**

**5.**

**CAUTION**  
**DO NOT DAMAGE SEAL**

**SUGGESTION!**

**FOR VCFS GASKETS- USE THE CARDBOARD INCLUDED IN THE PACKAGING DURING INSTALLATION TO HELP PROTECT THE SEALS AND COATINGS FROM DAMAGE. (ADDITIONAL FLANGE SEPARATION MAY BE REQUIRED)**

**6.**

**INSTALL REMAINING BOLTS WITH WASHERS AND SLEEVES**

**ALWAYS USE A TORQUE WRENCH OR APPROPRIATE TENSIONING EQUIPMENT**

**NEVER USE IMPACT DRIVERS OR HAMMER WRENCHES! THIS CAN CAUSE DAMAGE TO THE WASHERS**

**7.**

**TORQUE IN LEGACY STAR PATTERN**

1. SNUG EACH BOLT TO 10-20 [ft-lb]
2. TIGHTEN TO 30% OF TARGET TORQUE
3. TIGHTEN TO 70% OF TARGET TORQUE
4. TIGHTEN TO 100% OF TARGET TORQUE
5. FINAL TORQUE TO 100% IN CIRCULAR PATTERN