

Installation Manual for the Rubber Joint

ZRJ-MK300F · ZRJ-MK400F



Installation Procedure

1. Before installation

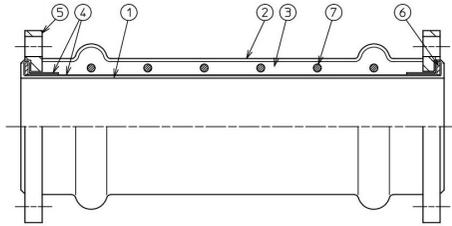


Table1 Parts List

No.	Name	Material
1	Inner Layer Rubber	Synthetic rubber
2	Outer Layer Rubber	Synthetic rubber
3	Plugging Rubber ※ 1	Synthetic rubber
4	Reinforcement Fiber	Nylon cord
5	Flange ※ 2	Carbon steel
6	Solid Ring	Carbon steel
7	Reinforcement Ring	Carbon steel

※1.All the inside surfaces are flat type.
 ※2.If the flange is SS400,
 hot dip galvanizing + epoxy coating (2 coats).

- Please confirm whether the diameter is correct.
- Please confirm whether there is any damage of sealing surface.
- Please confirm whether there is any damage of inside and outside of rubber.

2. Installation



Please insert the set bolt from this side.

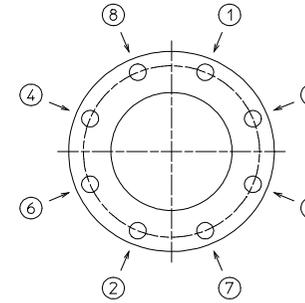
- ① Please Install between the piping flanges not to damage the sealing surface.
- ② Insert the set bolt toward the piping side from the product side.

Table 2 Length of bolt

Size	Bolt size×Length
20A	M12x50mm
25A~40 A	M16x55mm
50A~100 A	M16x65mm
125A~200 A	M20x75mm
250A~300 A	M22x90mm

3. Tightening of the bolts

The order of bolt tightening.



- ① Please tighten the bolts diagonally and equally.
- ② Please tighten the opposite side of flange with same way.
- ③ When you use the bolt and nut made of stainless steel, please apply lubrication.

Please refer to the tightening torque values in Table 3.

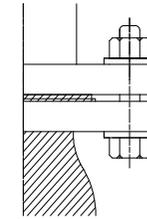
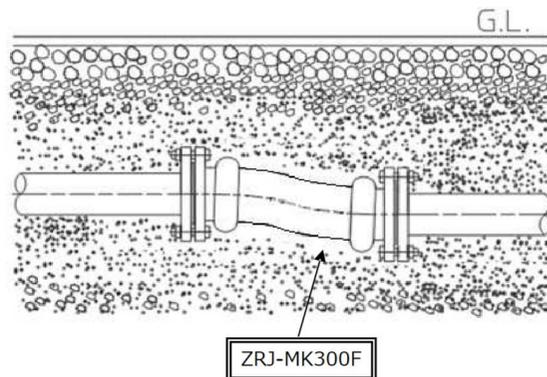


Table3 Tightening torque

Size	Torque
20A	25N · m
25A~100 A	30N · m
125A~150 A	40N · m
200A~300 A	45N · m

! Please confirm whether the flange face is parallel before tightening.

Completion



NOTES

- Insert set bolt from product side and tighten bolts evenly in diagonal line order.
- The service life of rubber fittings may be reduced depending on the conditions of use. For details, please refer to the precautions in the catalog.
- Please carry out the welding work of the piping before installing the flexible joint. If you have to carry out the welding work after installing the flexible joint, take ground the welding electricity, also put a protective cover around the flexible joint so that the welding current does not flow into the piping system.
- When burying, the depth should be within 3m and the weight should be within 25t.
- Compact the backfill sandy soil to the top of the pipe every 30 cm thickness and backfill the pipe securely. Do not backfill all the way up to the ground level in one go.
- When compacting sandy soil, be careful not to damage the flexible joint body.