

INSTALLATION GUIDELINES GYLON® 3545 & 3504 TUFF-RAIL®

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Manway Covers

Gasket Material: GYLON® 3545 (100% PTFE) / GYLON® 3504 PTFE w/ mircospheres

Gasket Dimensions: 19.5" I.D. x 21.5" O.D.

Manway Styles: AAR-1, UTC-1, TRN-1

SWING BOLT TORQUES 6 OR 8 BOLT ASSEMBLIES

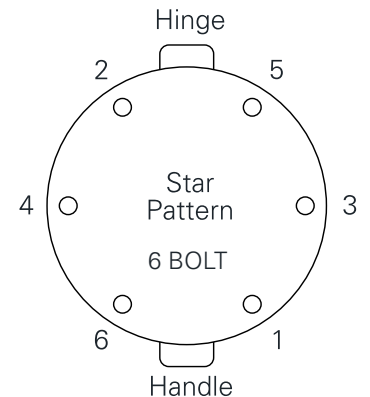
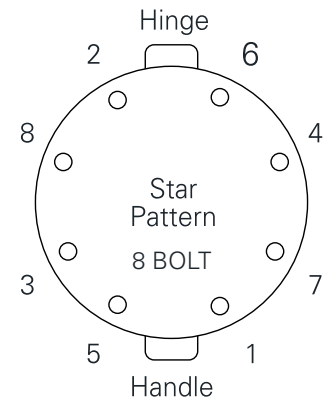
	7/8"	1"
Hand tight	20 ft. lbs.	20 ft. lbs.
1 st pass	50 ft. lbs.	50 ft. lbs.
2 nd pass	100 ft. lbs.	150 ft. lbs.
3 rd pass	133 ft. lbs.	200 ft. lbs.
Final pass	133 ft. lbs.	200 ft. lbs.

NOTE:

The values shown apply for manway bolts with a minimum yield strength of 30,000 psi (such as ASTM A307 grade A/B bolts) and are based on Garlock estimates of allowable bolt loads on swing bolt assemblies. For manways with bolt sizes not shown, please contact Garlock applications engineering at 800.448.6688.

KEYS TO SUCCESS

- » Inspect manway nozzle and cover seating groove for flatness and repair imperfections.
- » Inspect fasteners and associated hardware; lubricate accordingly (JET-LUBE 550® or similar)
- » Apply star pattern bolting sequence as noted
- » Do not exceed maximum torque values listed
- » Client requirements supersede installation guidelines



INSTALLATION & DIMENSIONAL INFORMATION

TUFF-RAIL® 3545 & 3504 Recommended Bolt Load				
A307 Lubricated				
	7/8" 6 bolt	7/8" 8 bolt	1" 6 bolt	1" 8 bolt
Torque	133 ft. lbs.	133 ft. lbs.	200 ft. lbs.	200 ft. lbs.
Stress	3000 psi	4000 psi	4000 psi	5225 psi

Garlock Part Number	Inside Diameter	Outside Diameter	Thickness Rib to Rib
36045TR-0001 Style 3545	19.50"	21.50"	.220"
36120TR-0001 Style 3504	19.50"	21.50"	.220"

NOTES:

- » Recommendations based on AAR-1, UTC-1, TRN-1 Manways
- » Torque values are based on 60-85% of bolt yield strengths and a maximum gasket stress of 15,000psi
- » Lubricating bolts is always recommended
- » Other manway gasket materials and configurations are available upon request

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Tel: 1.877.GARLOCK | 315.597.4811
Fax: 800.543.0598 | 315.597.3216
www.garlock.com

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