

Torque Value Guide

Series 450 (BLUE-MAX®) Gaskets

1) Remove old gasket and thoroughly clean cover plate flange, ring, or shell gasket surfaces

Note: Extra care should be taken when installing gaskets on the bottom of a boiler shell. Small particles of scale or sand tend to run down onto the mating surface between the time when the surface is cleaned and when the cover plate is put in place ready to be torqued.

2) Position Series 450 (BLUE-MAX) gasket on cover plate. Please make sure the gasket is pushed down tight and flat around the shoulder.

3) Install cover plate into opening, set crabs, tighten nut(s) finger tight while making sure inside diameter of the gasket is centered evenly around the inside edge of the ring or shell.

4) Tighten nut(s) with torque wrench about ½ turn. When all gaskets are in place previously described, torque Style #810-T hand hole gaskets to 60 ft lbs. Torque style #800-T manhole gaskets to 120 ft lbs.

Note: All plates with double crabs should be alternately tightened. IE: 40-80-120 ft lbs.

5) Fill and fire burner.

Note: Should gaskets leak while filling boiler, DO NOT TIGHTEN NUT(S). The soft rubber compound under the PTFE coating cures up with heat, allowing the rubber to fill into pits and irregular sealing surfaces. During curing process, it is NOT uncommon for leakage to occur.

6) Once the boiler has come up to operating temperature and pressure, allow the boiler to operate for a minimum of 4 hours. After this period, re-tighten any leaking gaskets only enough to stop leakage.

Series 450 (BLUE-MAX) Boiler gaskets are sold and intended for use in steam boilers. Recommendations for use of Series 450 (BLUE-MAX) boiler gaskets are based on tests believed to be reliable. Since their installation and use is beyond our control, we cannot guarantee the results, whether or not such use is in accordance with these directions. We hereby disclaim any responsibility for improper installation or gasket failure.