Installation Instructions

**GORE® Joint Sealant** is ideally suited for large or complex steel flanges and equipment to achieve an incredibly tight seal. Available on a spool, the user can easily and quickly form a gasket in place on the flange, and achieve significant savings in material, labor, and lead-time over traditional large cut gaskets.

To install, please follow the instructions below:

1. **Size Selection**

   For flat face flanges, raised face flanges, and manways:
   Measure the width of the sealing surface and reference the table below to select the nominal width of GORE® Joint Sealant.

<table>
<thead>
<tr>
<th>Effective Sealing Width (mm)</th>
<th>Effective Sealing Width (inches)</th>
<th>GORE® Joint Sealant Nominal Width (mm)</th>
<th>GORE® Joint Sealant Nominal Width (inches)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3–7</td>
<td>1/8–1/4</td>
<td>3</td>
<td>1/8</td>
</tr>
<tr>
<td>7–10</td>
<td>1/4–3/8</td>
<td>5</td>
<td>3/16</td>
</tr>
<tr>
<td>10–17</td>
<td>3/8–5/8</td>
<td>7</td>
<td>1/4</td>
</tr>
<tr>
<td>17–25</td>
<td>5/8–1</td>
<td>10</td>
<td>3/8</td>
</tr>
<tr>
<td>25–40</td>
<td>1–1.5</td>
<td>14</td>
<td>1/2</td>
</tr>
<tr>
<td>40–50</td>
<td>1.5–2</td>
<td>17</td>
<td>5/8</td>
</tr>
<tr>
<td>50–65</td>
<td>2–2.5</td>
<td>20</td>
<td>3/4</td>
</tr>
<tr>
<td>65+</td>
<td>2.5+</td>
<td>25</td>
<td>1</td>
</tr>
</tbody>
</table>

   For tongue and groove flanges:
   Select the nominal width of GORE® Joint Sealant that is equal to or less than the width.

   **ATTENTION**

   Perform an engineering torque estimation to confirm a gasket stress higher than 17 MPa (2500 psi) can be achieved.

2. **Installation – Standard & Custom Flanges**

   **2.1 Prepare the Flange**

   Open the flanges a minimum of 15 cm (6”). Completely clean the surface to ensure optimal adhesion. Remove all oil, graphite, and other residue.

   **2.2 Apply Joint Sealant**

   Remove the adhesive backing a little at a time, to prevent the adhesive strip from picking up dirt. Position the end of the joint sealant around the starting bolt hole.

   **ATTENTION**

   No additional anti-adhesives spray or liquid should be applied to the flange surfaces. In cold conditions, gently warm the joint sealant before installation to make the adhesive more sticky.

2.3 **Complete the Joint Sealant**

   Complete the gasket by overlapping both ends at the starting bolt hole and cut away excess material. See above illustrations.

   **ATTENTION**

   The skive cut technique is recommended to complete the gasket when 17 mm (5/8”) or wider GORE® Joint Sealant is being used, except when installed on ASME or JIS metallic flanges.
3.3 Closing Skive Cut
Complete the gasket by laying the Joint Sealant over the skived end, extending beyond ≈ 14 mm (1/2”). To prepare for the second and final skive cut, identify and mark the starting and end points.

Cut away the gasket material at an angle. This will leave an area of ≈ 120% of the original gasket thickness.

4. Torquing
4.1 Select a Torque
As a general rule, it is advisable to make the best possible use of the available bolt force. However, the torque recommendations of the equipment manufacturer must be followed at all times.

4.2 Flange Tightening Procedure
Unless the equipment manufacturer specializes a certain pattern, utilize the star pattern, multiple pass, and incremental torque. Refer to the ESA/FSA “Gasket Installation Procedures” for more detailed information on the recommended installation practices.