



GASKET SECUREMENT PROCEDURE
FOR NEC FLANGES:

- 1.) ROUND GASKET TO AN APPROXIMATE CIRCLE USING A TAPERED FLASK OR OTHER SUITABLE OBJECT.
- 2.) SECURE GASKET TO FLANGE WITH .0007" THICK ALUMINUM FOIL (HOUSEHOLD FOIL IS ADEQUATE) STRIPS LOOPED AROUND THE WIRE GASKETS AS SHOWN IN THE FIGURE.
- 3.) TO HOLD THE ALUMINUM GASKET SEVERAL ALUMINUM STRIPS APPROXIMATELY EQUALLY SPACED BETWEEN EVERY OTHER BOLT HOLE IS RECOMMENDED.
- 4.) THE .020" ALUMINUM WIRE GASKET READILY SEALS ON NEC STANDARD FLANGES WITH 20-25 FOOT-POUNDS TORQUE USING 3/8" DIAMETER STAINLESS BOLTS AND 10-15 FOOT-POUNDS USING 5/16" DIAMETER BOLTS. FLANGES SHOULD BE RETORQUED AFTER THE FIRST BAKEOUT. SUBSEQUENT BAKEOUTS RARELY REQUIRE RETORQUING.
- 5.) REMOVE MASKING TAPE STRIPS PRIOR TO BAKE-OUT.

						DRAWN	NLP	2/11/99		NATIONAL ELECTROSTATICS CORPORATION MIDDLETON, WISCONSIN		
NO.	REVISION		BY	DATE	CKD	DATE	CHECKED	MJS				
TOLERANCES AND FINISH UNLESS OTHERWISE SPECIFIED						DESIGNED	JBS	NEC ALUMINUM GASKET INSTALLATION - SCHEMATIC				
FRACTIONAL ±1/64"	.XXX ±.005	ANGLE ±.5°	MACH 125 ✓	THIRD ANGLE PROJECTION		SCALE	NTS					
MATERIAL						PART NO.		2GS062350	B	DWG NO.	7-6235	LOC CV