



FLANGE ASSEMBLY RECORD
 XXXXXXXXXX Station Unit 2 Fall 2007 Outage

Mechanic's Name	Date	VSP Location ID	Flange/Functional Location
		VSP #28, #29, #30, #31	LP Outer Cylinder Cover

Flange Preparation

Flange Faces Cleaned? (remove all residue from sealing surfaces)	YES	NO
Flange Sealing Surface In Good Condition?(no deep radial scratches, flange serrations intact)	YES	NO

Gasket

New Gasket Used	YES	NO
Gasket Material	Inertex SQ-S Expanded PTFE	
Gasket Thickness		1/8"
Gasket Fits Properly In Flange?	YES	NO

Flange Alignment After Assembly (refer to sketch below)

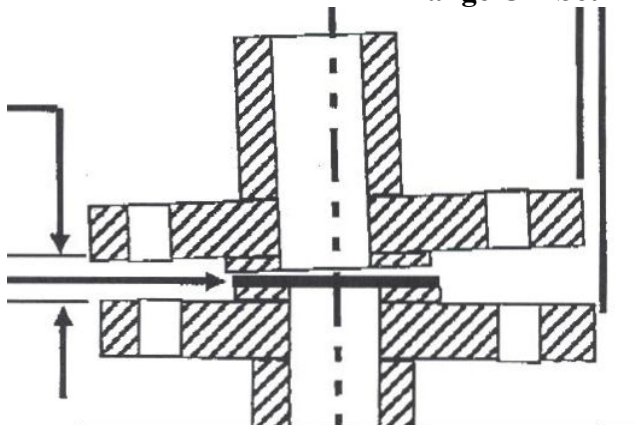
Flange Gap- Measurements Made At 90° Increments (should vary <1/32" per 12" dia.)	12:00 Position	3:00 Position	6:00 Position	9:00 Position
Flange Off-Set- Measurements Made At 90° Increments (should be <1/8")				

Flange Assembly, Bolting, Torque

Bolt Grade/ Head Marking (circle the type)	B7	F593	Grade 5	Grade 8	None
Thread lubricant applied to threads AND underside of nut?	YES		NO		
Assembly Torque Applied (confirm bolt/stud diameter)	5/8" Dia. @ 140 Ft-Lb				
Torque Applied At Each Increment (Ft-Lb)	1 st	2 nd	3 rd	4 th	5 th
	Snug	25	50	100	140
Bolts Tightened In Correct Sequence, In A Minimum Of 3 Increments, With Final Rotational Pass @ 5 th Pass Torque	YES		NO		

Flange Off-Set

VSP #28, #29, #30, #31



Flange Gap

Flange Connection Installed Correctly and Ready For Service

Mechanic Approval: _____