



JUDBERD MACHINERY

**HEAVY DUTY RIGID DUCTILE IRON EN545
DISMANTLING JOINT Series No. DJ001**

RIGID TYPE FROM DN40 TO DN3000 PN10/PN16/PN25

FOR BIGGER PRESSURE, PLEASE REFER TO
JUDBERD STEEL MATERIAL DISMANTLING
JOINT Series No. DJ006

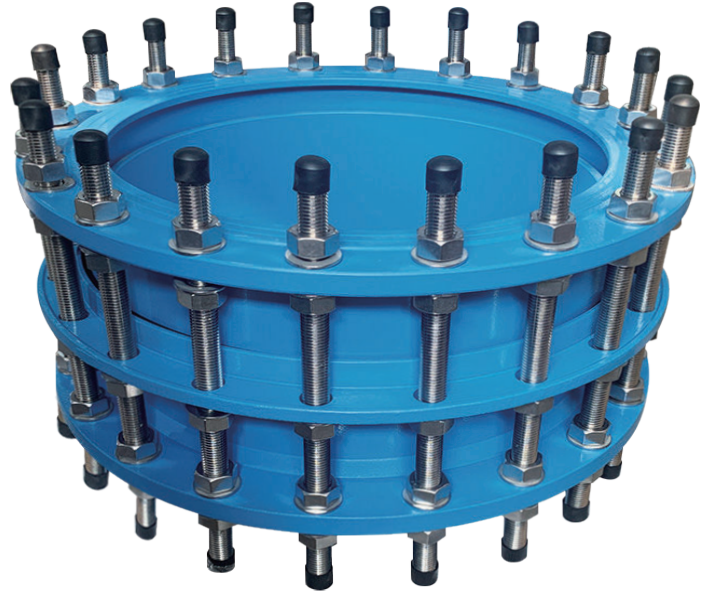


**2 YEARS/5 YEARS
10 YEARS WARRANTY
ACCORDING TO DIFFERENT
MATERIAL CHOICE**



**30 YEARS
EXPERIENCE**

CERTIFIED TO WRAS AND ACS

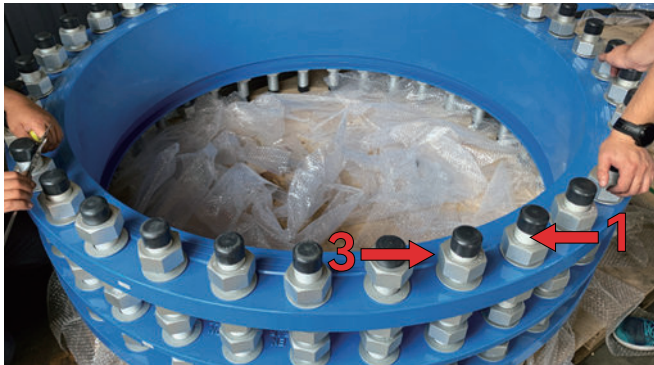


FEATURE

BOLTS LENGTH

The length of the dismantling joint bolts (Fig No.1 as below) is not routine. because the dismantling joint bolts need to go through the mate flange (Fig No.2 as below) to connect the dismantling joint with neighbour mate flange, so the length of the dismantling joint bolts will be related with the thickness of the mate flange.

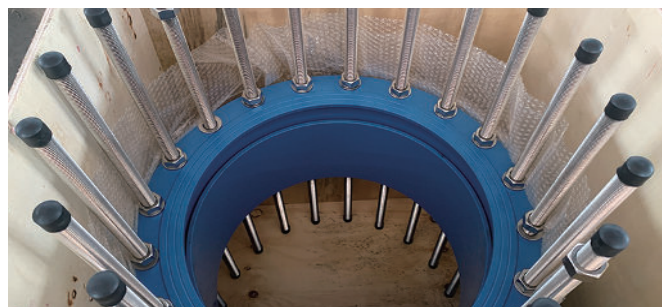
Precaution: some client complain the nuts and washers interferent with the flange raised face (fig No.3 as below), in fact, this is no need to worry about, because when connected to the pipeline, the nuts and washers need to be assembled to the back of the flange (fig No.4 as below).



Judberd's standard dismantling joint bolts length is based on EN1092 (EN1092-1 for steel flange and EN1092-2 for ductile iron material flange)/ISO7005 or ANSI B 16.5 /ANSI B16.47 normal flange. If you need to use dismantling joint to connect GPR flange, PE pipe with back ring flange etc, We can offer dismantling joint with longer length bolts as below photo, please consult judberd for suitable bolts length.



NORMAL BOLTS LENGTH



EXTENSION BOLTS ACCORDING TO THE
ACTUAL CONNECTION REQUIREMENTS OF THE PROJECT



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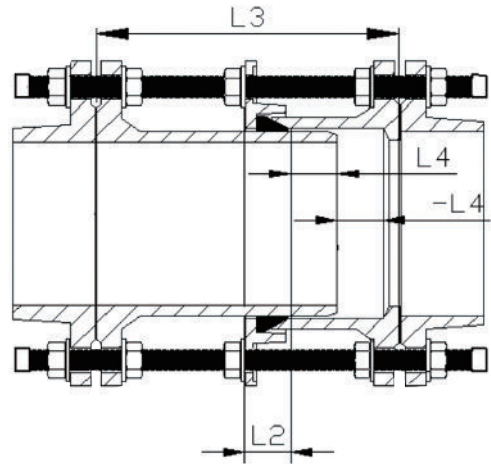
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FACE TO FACE LENGTH

For new lay pipeline, the dismantling joint installation length (L3 as right diagram) and extendable/shortenable length (L4 as right diagram) can be according to our design dimensions (see our GAD drawing), but if it is for replacing the former pipeline, you need to tell us the nominal length and extendable/shortenable length to meet the normal operation of the pipeline through customisation.

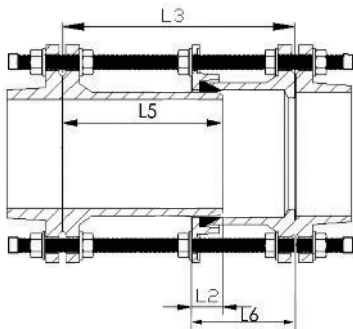
Maximum length=nominal length(L3 as right diagram) + extendable length(L4 as right diagram)

Minimum length=nominal length(L3 as right diagram)-shortenable length(L4 as right diagram)



HOW TO GET THE MAXIMUM LENGTH AND MINIMUM LENGTH OF A DISMANTLING JOINT ?

HERE IS HOW TO CALCULATE



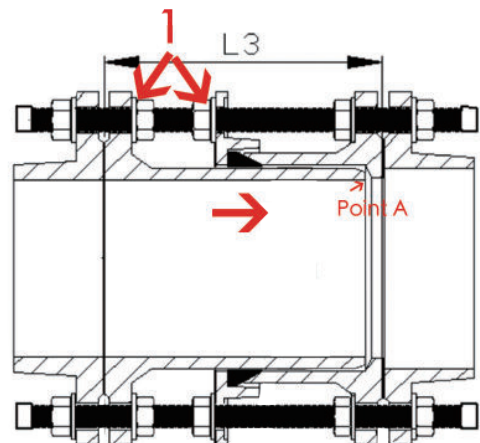
The Maximum Length = Flange Spigot Length (L5 as above diagram) + Length of flange adaptor(L6 as above diagram) -Minimum safe length for flange spigot insertion (L2 as above diagram)

The L2 value is different for each size as Left diagram shown

L2 VALUE

NOMINAL DIAMETER	PRESSURE	MINIMUM SAFE LENGTH FOR LONG BODY INSERTION
DN	PN	L2
DN40-65	PN10/16/25	40
DN80-DN250	PN10/16/25	45
DN300-DN400	PN10/16/25	50
DN450-DN800	PN10/16/25	55
DN900-DN1000	PN10/16/25	60
DN1100-DN1200	PN10/16/25	65
DN1300-DN16000	PN10/16/25	75
DN1800-DN2600	PN10/16/25	80

The Minimum Length = the length between the flange faces when the long body is inserted into the deepest part of the flange adaptor (to point A as right), but note that sometimes the flange spigot cannot be inserted to point A because of the two nuts and two washers as right Fig No. 1 will stop flange spigot to go inside flange adaptor if there have no enough space for 2 nuts and 2 washers thickness.



IF YOU HAVE QUESTIONS ABOUT DISMANTLING JOINT LENGTHS, FEEL FREE TO CONSULT JUDBERD.



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R&D

Judberd has a proficient design team for dismantling joints, we can design dismantling joints with different flange sizes/standard and different adjustable lengths according to the requirements of customer's projects, meanwhile, we can recommend suitable materials according to the requirements of customer's usage environment, conveyed medium and warranty period.

Our sizes can be from DN40 to DN3000, for different sizes, different requirements, we have carried out careful analysis and used different production processes to produce each dismantling joint in the best way.

PRODUCTION PROCESS

1 CASTING



VERTICAL MOULDING LINE PRODUCTION

For small size $DN \leq 300$, we use vertical moulding line production, with DISA as the representative of the vertical moulding line process is undoubtedly a revolution in the foundry industry, so that our casting moulding speed is fast, because of the sand compacted tighter, so the surface of the product is very smooth, at the same time, because of the mass production, our control of the material more strictly, and all the casting process is mechanised control.

So it is more reliable. At the same time, because of automated production, the efficiency is greatly improved, the production cost is greatly reduced. The superior performance of Vertical moulding line can be seen in the following link of disa group

<https://www.disagroup.com/disamatic>

However, due to the size limitation of the vertical moulding line, the maximum size of dismantling joint parts that can be accommodated is DN300 PN25.

Thank to the vertical moulding line significantly optimises our dismantling joint production.



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- FOR SIZES DN350-DN500,
WE USE HORIZONTAL MOULDING TECHNOLOGY.
HORIZONTAL MOULDING IS ALSO AUTOMATED AND IS SUITABLE FOR LARGER SIZES OF DISMANTLING JOINT.



You can find out more about horizontal moulding technology by clicking on the link below.
<https://www.disagroup.com/horizontal-explained#:~:text=In%20horizontal%20moulding%2C%20the%20two,and%20FLEXIPAD%20hydraulic%20squeeze%20technique.>

- FOR SIZES DN600-DN1800,
WE USE CLAY SAND OR RESIN SAND CASTING.
- FOR SIZES DN2000-DN3000,
WE USE LOST FOAM PROCESS TO PRODUCE CASTINGS.





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2 MACHINING

For the machining of dismantling joint, we use many different types of machining equipment to fulfil the requirements for precision and efficiency.

3 SHOT BLASTING

Before machining the dismantling joint castings, we will do the first shot blasting on the surface of the dismantling joint casting.

Shot blasting before machining is to get the casting surface sand thrown off, sand is easy to wear for machining tools, so have to throw off the sand and then machining. After machining, before surface coating, we will carry out the second shot blasting according to the specific requirements of different coating, for example, if it is a common FBE coating, after machining, the second shot blasting to SA2.5, which can increase the roughness of the surface of the casting, so as to ensure that the adhesion of the later FBE coating, and at the same time the surface should be thrown off the dust and oil and other factors which affect the coating adhesion.



BEFORE SECOND SHOT BLASTING



AFTER SECOND SHOT BLASTING

4 SURFACE COATING

According to the conveyed medium, working environment, client required warranty period, we can choose different surface coating/paint.

● FBE COATING

FBE coating is used for drinking water, neutral water and other non-corrosive medium. Even for the common FBE coating, you need to choose different material powder, For underground, you should choose epoxy powder because it has better anti-wet performance, and friendly to potable water.

For above ground you should put one layer polyester powder on the outside surface because it has better UV-proof function.

● NYLON 11 COATING

Nylon 11 coated dismantling joints have good abrasion resistance, chemical resistance and high temperature resistance, and can be used for the transport of corrosive medium or harsh working environments.

● PVC COATING

PVC coated dismantling joints are non-flammable, high-strength, waterproof and sunproof, abrasion-resistant, high-temperature resistant and UV protected.

Judberd can recommend the appropriate dismantling joint according to the customer's actual use requirements.