



DISMANTLING JOINT

7906DJ INSTALLATION GUIDE

Before beginning assembly of your Robar Dismantling Joint be sure to confirm that you have received the correct size required and all parts have not been damaged during transport.

1. Inspect all mating flange surfaces for any damage or irregularities that may interfere with the flanges ability to form a long-term seal.
2. Confirm that the drill pattern on the Robar Dismantling Joint matches the mating flanges.
3. Measure the gap between flanges and confirm the dismantling joint's capability based on the shop drawing.
4. Loosen the coupling bolts on the end ring to "relax" the gasket seal and to allow for easy movement of the flanges. Total disassembly is not required for installation, but tie rods must be removed for installation.
5. Move the Dismantling Joint into position between the mating flanges.
6. Install flange gaskets and fasten the dismantling joint to each mating flange. Start with the flanged coupling end of the dismantling joint.
7. Install the flange bolts on the flanged spool portion. ensure both halves have the same centerline. If not, check to ensure both flanges on the dismantling joint are flush with the mating flange ends. At the same time ensure that the coupling gasket is seated properly to the flange coupling body. If needed, adjust the gasket so it is seated correctly.

Note: When installing flange bolts, ensure that the supplied tie rods are properly spaced per the shop drawing.

8. The Robar 7906 series DJ uses through rods which also act as flange bolts.
9. If necessary, adjust the end ring into position and hand tighten the fasteners.
10. Insert the supplied tie rods (for restrained application). Each tie rod should have a total of 4 nuts when fully assembled. When inserting the tie rod, thread the nuts into position. The tie rod must pass through the flanges on each end of the dismantling joint. Make sure the tie rod lengths are equal for all rods supplied. Tighten the nuts that secure the flanges. **DO NOT TIGHTEN THE FOLLOWER RING BOLT AND NUTS BEFORE PROPER TORQUE HAS BEEN APPLIED TO THE FLANGE BOLTING)**
11. Tighten the follower ring nuts to 30-35 ft-lbs two or three times. Increase the wrench setting to 40-50 ft-lbs and continue this procedure to 75 ft-lbs. Continue torquing the nuts to 75 ft-lbs several times to ensure uniform gasket pressure.

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