



Technical Information

Tolerances for connection flanges and installation dimensions for Fabric Expansion Joints

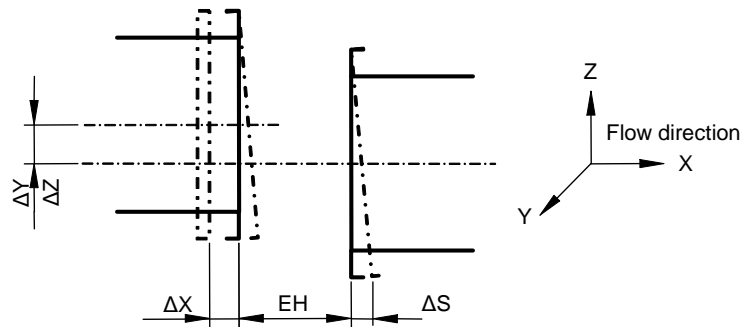
RAL-GZ 719

TI-013

Rev. 4 – 03/14

page 1 of 2

1. Max. allowable tolerances for the connection flanges of fabric expansion joints



Installation length [EH]

$$\Delta X = -10\text{mm}, +5\text{mm}$$

Lateral offset both directions

$$\Delta Z, \Delta Y = \pm 10\text{mm}$$

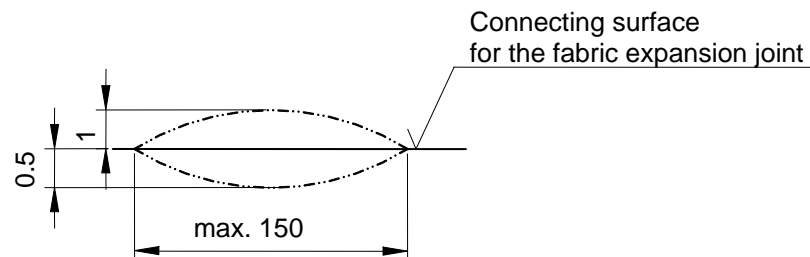
Misalignment of flanges

$$\Delta S = \pm 7\text{mm}$$

Accumulated tolerances

$$\Sigma = \sqrt{\max. (\Delta Z^2; \Delta Y^2) + \Delta S^2} + \Delta X \leq 10\text{mm}$$

2. Max. allowable tolerances for the connecting surface of fabric expansion joints



Between measured distance of max. 150mm may be either a smooth deepening of 0.5mm or a smooth superelevation of 1mm compared with the theoretical shape.

Waviness of the duct flange max. $\pm 1\text{mm}$ over a distance of 1000mm.

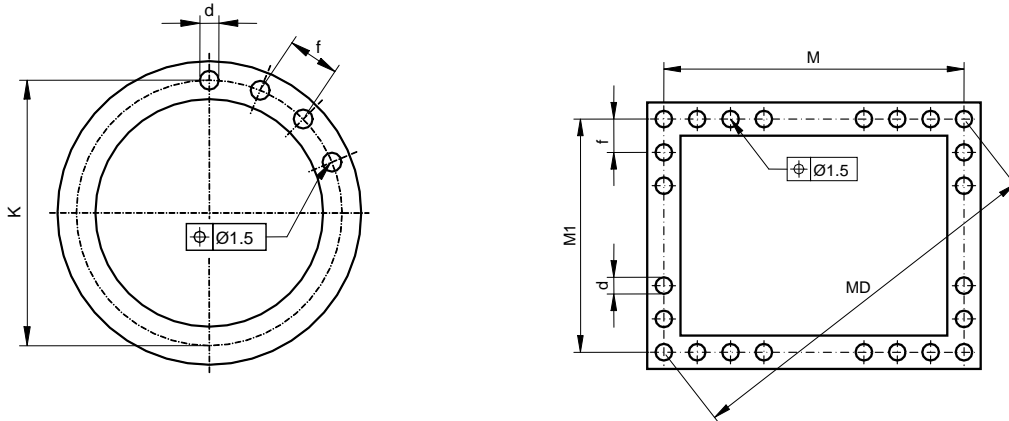
Max. Roughness of flanges $R_t = 150\mu\text{m}$.

Offset is not allowed at the splicing part of the flange area.

The connecting surface must be free of ridge, groove, notch, weld spatter.

Edited by the Quality Committee of the Quality Association for Fabric Expansion Joints

3. Max. allowable tolerances for the hole pattern of fabric expansion joints



Pitch circle diameter <4000mm

Pitch circle diameter >4000mm

Centre distance <4000mm

Centre distance >4000mm

Diagonal distance <4000mm

Diagonal distance >4000mm

Pitch

Hole diameter

All holes in the connecting flanges must be deburred on both sides.

K = ISO 2768-1 tolerance class m

K = ISO 2768-1 tolerance class c

M, M1 = ISO 2768-1 tolerance class m

M, M1 = ISO 2768-1 tolerance class c

MD = ISO 2768-1 tolerance class m

MD = ISO 2768-1 tolerance class c

f = ISO 2768-1 tolerance class c

d = EN 20273-1 tolerance class g

4. General tolerances

Tolerances for length dimensions (compare ISO 2768-1)

Tolerance class	>6 <30	>30 <120	>120 <400	>400 <1000	>1000 <2000	>2000 <4000	>4000 <8000	>8000 <12000	>12000 <16000	>16000 <20000
m	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6
c	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8

Edited by the Quality Committee of the Quality Association for Fabric Expansion Joints