

Novus Bolting



We now supplement our product portfolio with a bolting range including stud bolts, threaded bar and fasteners responding to market demand in offering complete sealing solutions - the one stop sealing shop.

Our bolting range is manufactured to national and international standards together with specific customer designs.

Typically supplying the requirements of Oil, Gas, Offshore Power Generation, Shipping, Building, Instrumentation and General Industries.



Where used

Flange Assembly, Offshore, Valves, Heat Exchangers, Pressure Vessels, Compressors, Gas, Steam and Water Turbines, Marine and Stationary Diesel Engines, Civil and Defence Nuclear Industry, Hydraulic Power Plants, Power Generation and Transmission, Transport (Railways Shipping), Civil Engineering, Furnaces and Crushers for Cement Industries



Also in this publication



Stud-Bolts

A complete range of Stud-Bolts, threaded bar and nuts. Materials and size information.



Bolt-Lube

Assembly Lubrication and Anti-Seize Compound. Product Specification



Training

Training Courses and Training Information and Training Aids

Bolting

We have a full range of bolting products manufactured in an extensive range of materials with a wide choice of finishes and treatments. All products are machined to fine tolerances and to high performance specifications to meet the rigorous demands of world wide industries.



Materials and Finishes

Carbon & Alloys

Mild Steel
080M40 (EN8)
605M36 (EN16)
708M40 (EN19)
817M40 (EN24)
826M40 (EN26)
ASTM A193/A320 Grades
B5, B7, B7M, B16, B16A, L7, L7M, L43
DUREHETE* 900, 950, 1055
JETHETE*
ESSHETE*
Chrome Moly and Chrome Moly Vanadium

Nickel Alloys & Duplex

Monel* 400 & K500
Inconel* 600, 601, 625, 718
Incoloy* 800HT, 825, 925
Hastelloy B2, C22, C276
UNS31254 (2545MO*)
UNS532550 (Ferralium 255*)
UNS32750
UNS32760
ASTM A453 Grade 600
Zeron 100*
Carpenter Alloy 20*
Nimonic 75, 80A, 90
Titanium Alloys

Stainless Steel

A2 & A4 Class 50, 70 & 80
300 & 400 Series
C-80
ASTM A193 / A420 Grades
B8, B8M, B8TX Class 1 &
B8X, B8MX, B8TX
B8C
B6
17-4 PH
FV5208
Nitronic* 50 & 60
904L

Non-Ferrous

Hiduron*
Marinel*
Aluminium Bronze
Silicon Aluminium
Bronze
Phosphor Bronze
Naval Brass
Brass
Cupro Nickel 70/30, 90/10
Aluminium
Nylon
PTFE

Surface Coatings

Bright Zinc
Zinc & Passivated
Zinc Nickel
Hot Dip Galvanised
Phosphate
Molykote
PTFE
Sheradised
Electroless Nickel
Cadmium
Zinga

Heat Treatments

Hardening & Tempering
Normalising
Nitriding
Case Hardening
Age Hardening
Through Hardening

* Registered Trademark

Novus Stud-Bolts

Stud-Bolts with 2 Heavy Hexagonal Nuts ASTM A193 B7 Stud-Bolts / A194 2H Nuts

Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box	Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box	Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box						
1/2" UNC	2	200	19.2	3/4" UNC	3	60	19.2	1" UNC	4.1/4	30	22.4						
	2.1/4	180	10.2									3.1/4	60	19.9	4.1/2	25	19.2
	2.1/2	160	17.8									3.1/2	60	20.6	4.3/4	25	19.6
	2.3/4	150	17.5									3.3/4	50	17.6	5	25	20.3
	3	140	17		4	50	18.4		5.1/4	25	20.8						
		3.1/4	140			4.1/4	50			18.9	5.1/2	25	21.3				
		3.1/2	140			4.1/2	50			19.5	5.3/4	25	21.9				
		3.3/4	130			17.8	4.3/4			50	20.1	6	25	22.4			
	4	100	14.2		5	50	20.7		6.1/4	20	18.3						
		4.1/4	100			5.1/4	50			21.3	6.1/2	20	18.8				
		4.1/2	100			5.1/2	40			17.5	6.3/4	20	19.2				
		4.3/4	100			15.7	5.3/4			40	17.9	7	20	19.6			
	5	80	12.9		6	40	18.5		7.1/4	40	20.7						
		5.1/4	80			6.1/4	40			18.9	7.1/2	20	20.4				
		5.1/2	80			6.1/2	40			19.3	7.3/4	20	20.9				
		5.3/4	80			14.2	6.3/4			40	19.6	8	20	16			
6	80	14.6	7	40	20.3	8.1/4	35	19.4									
				7.1/4	40		20.7	8.1/2	35	19.8							
				7.1/2	35		18.6	8.3/4	30	20.2							
				7.3/4	35		19	8.3/4	30	20.6							
8	35	19.4	8	35	19.8	9	30	21									
				8.1/4	35		19.8	9.1/4	15	17.6							
				8.1/2	35		20.2		9.1/2	15	17.6						
				8.3/4	30		20.6			15	11.9						
9	30	21	9	30	21	9.1/4	15			17.6							
				9.1/4	15		17.6	9.1/2		15	11.9						
				9.1/2	15		11.9		9.1/2	15	11.9						
				9.1/2	15		11.9										

5/8" UNC	2.1/2	100	19	7/8" UNC	3.1/2	40	19.7	1.1/8" UNC	6	15	17.9						
	2.1/4	100	19.8									3.3/4	40	20.3	6.1/4	15	18.3
	3	100	20.6									4	40	20.9	6.1/2	15	18.7
		3.1/4	100										21.4	4.1/4	40	21.6	6.3/4
		3.1/2	100		22.2	4.1/2	40		22.2	7	15		19.5				
		3.3/4	90		20.7	4.3/4	40		22.9		7.1/4		15	19.9			
	4	80	19		5	35	20.6		7.1/2		15	20.3					
		4.1/4	70			17.2	5.1/4		35		21.2	7.3/4	15	20.7			
		4.1/2	70			17.8	5.1/2		35	21.7	8	15	21.1				
		4.3/4	70			18.4	5.3/4		30	19.1		8.1/4	15	21.5			
	5	70	18.9		6	30	19.6		8.1/2	15		21.9					
		5.1/4	60			16.7	6.1/4			30		20	8.3/4	15	22.4		
		5.1/2	60			17.2	6.1/2			30	20.5	9	15	22.8			
		5.3/4	60			17.7	6.3/4			30	21		9.1/4	15	23.2		
	6	60	18.2		7	25	17.9		9.1/2	10	15.7						
		6.1/4	60			18.6	7.1/4			25	16.4		9.1/2	10	15.7		
6.1/2		60	19.1	7.1/2		25	18.7	9.1/2		10	15.7						
6.3/4		60	19.6	7.3/4		25	19.1			9.1/2	10	15.7					
8	25	19.6	8	25	19.6	9.1/2	10		15.7								
				8.1/4	25		19.6		9.1/2		10	15.7					
				8.1/2	25		19.6	9.1/2			10	15.7					
				8.3/4	25		19.6			9.1/2	10	15.7					

Novus Stud-Bolts

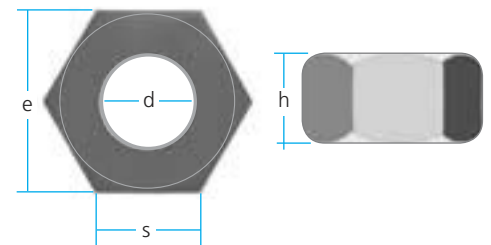
Stud-Bolts with 2 Heavy Hexagonal Nuts ASTM A193 B7 Stud-Bolts / A194 2H Nuts

Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box	Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box	Diameter Inches	Length Inches	Quantity per Box	Weight Kg per Box
1.1/4" UNC	6	15	22.9	1.3/8" UNC	6.3/4	10	20.6	1.1/2" UNC	7.3/4	10	27.3
	6.1/4	15	23.4								
	6.1/2	15	23.9		7	10	21.1				
	6.3/4	15	24.5								
	7	7.1/4	15		25.5	8	10			22.7	
		7.1/2	10		17.3						
		7.3/4	10		17.7						
		8.1/4	10		18.3						
	8	8.1/2	10		18.7	8.1/4	10			23.2	
		8.3/4	10		19						
		9	10		19.4						
		9.1/4	10		19.7						
9.1/2	9.1/2	5	12.2	9.1/4	5	12.4					
	9.1/2	5	12.6								

Heavy Hexagonal Nuts

Nominal Size Diameter (d)	Number of threads per inch	Width across flats (s)		Thickness (h)		Width across corners (e)		Weight of 100 Nuts (kg)
		inch	mm	inch	mm	inch	mm	
3/8	16	11/16	17.5	3/8	9.1	3/4	19.7	1.4
7/16	14	3/4	19.0	7/16	10.7	7/8	22.0	1.9
1/2	13	7/8	22.2	1/2	12.3	1	25.4	3.0
9/16	12	15/16	23.8	9/16	13.9	1.1/16	27.0	3.7
5/8	11	1.1/16	27.0	5/8	15.5	1.1/4	31.2	5.4
3/4	10	1.1/4	31.7	3/4	18.7	1.3/8	35.7	8.8
7/8	9	1.7/16	36.5	7/8	21.8	1.5/8	41.6	13.5
1	8	1.5/8	41.3	1	25.0	1.7/8	47.2	19.3
1.1/8	8	1.13/16	46.0	1.1/8	28.2	2.1/16	52.0	26.9
1.1/4	8	2	50.8	1.1/4	31.0	2.1/4	57.8	35.7
1.3/8	8	2.3/16	55.6	1.3/8	34.1	2.1/2	63.5	46.3
1.1/2	8	2.3/8	60.3	1.1/2	37.3	2.3/4	69.3	59.5
1.5/8	8	2.9/16	65.1	1.5/8	40.5	2.15/16	75.0	73.6
1.3/4	8	2.3/4	69.8	1.3/4	43.6	3.1/6	78.6	92.7
1.7/8	8	2.15/16	74.6	1.7/8	46.8	3.3/8	85.5	109.5
2	8	3.1/8	79.4	2	50.0	3.9/16	90.0	135.8
2.1/4	8	3.1/2	88.9	2.1/4	56.0	3.15/16	100.0	190.3
2.1/2	8	3.7/8	98.4	2.1/2	62.3	4.3/8	111.6	256.0
2.3/4	8	4.1/4	108.0	1.3/4	70.0	4.7/8	124.3	335.0
3	8	4.5/8	117.5	3	76.2	5.3/8	135.3	432.0
3.1/4	8	5	127.0	3.1/4	80.9	5.3/4	146.5	543.0
3.1/2	8	5.3/8	136.5	3.1/2	87.3	6.3/16	157.2	694.0
3.3/4	8	5.3/4	146.0	3.3/4	93.7	6.5/8	168.6	824.0
4	8	6.1/8	155.6	4	100.0	7.1/16	179.5	991.0

Heavy Hexagonal Nuts



How to order Stud-Bolts and Nuts

A correct purchase order should contain the following information for Stud-Bolts and Nuts:-

- 1 Diameter and Length
- 1 Material
- 1 Quantity

Novus Bolt-Lube

Assembly Lubrication and Anti-Seize Compound.

Description

Novus Bolt-Lube is a high quality assembly and anti-seize compound and is designed for use on fasteners operating on process plant where arduous conditions may be encountered.

Service

Novus Bolt-Lube has been formulated to provide easier assembly and disassembly of fasteners therefore reducing the torque required to load and unload the joint. Due to the inclusion of an extreme pressure additive it provides additional protection against galling or seizure. The compound is water resistant and assures long-term protection against rust and corrosion.

Material Properties

Novus Bolt-Lube contains molybdenum disulphide (MoS₂), graphite and other low-friction ingredients in a non-setting form. The formulated blend is carefully controlled to ensure consistency of lubricating and anti-seize properties along with low-friction characteristics.

Applications

Ensure the bolt and nut threads are clean before application. Apply Bolt-Lube lubricant liberally using a brush to the bolt and nut threads and to the face of the nut to be tightened. Do not apply grease or bolt lubricant to the joint face.

Availability

Tins of 500 grammes come complete with integral brush applicator for ease of use. Available in 1kg Tin, 5kg Pail, 12.5 Pail and 20kg Pail.

Other sizes available on request.

PHYSICAL PROPERTIES	
Coefficient of Friction*	0.12
Temperature Range	-54°C to 650°C
Physical State	Semi-Solid Paste
Colour	Steel Blue
Odour	Petroleum
pH	Neutral
Boiling Range/Point	316°C
Melting Point	232°C
Flash Point (PMCC)	221°C
Auto Ignition Temperature	260°C

* The coefficient of Friction (CoF) is used in the calculations that determine the torque that should be applied to the bolts during assembly. In order to establish the CoF, Novus have developed a unique 'in house' test procedure, utilising specially adapted fasteners to measure bolt load. This test procedure accurately determines the CoF and provides a method for verifying consistency of product from batch to batch.

Bolting Instructions

Bolting

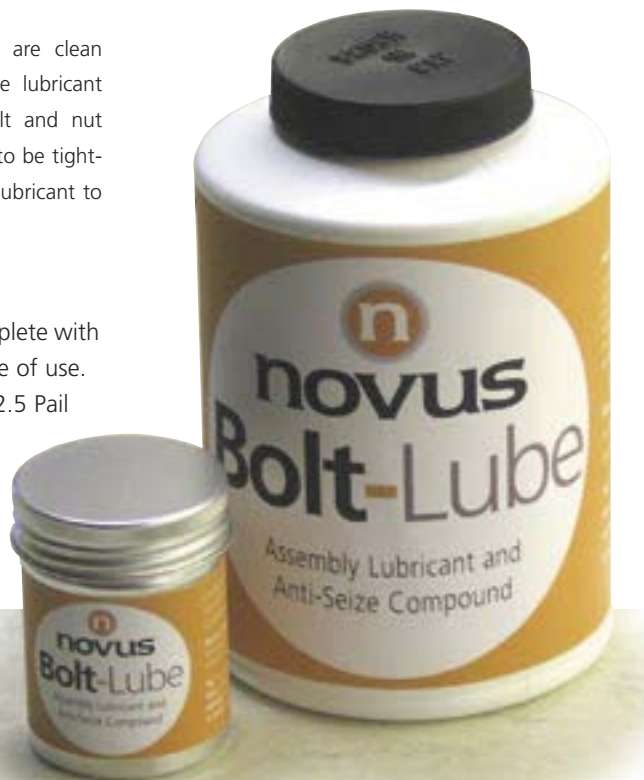
- Ensure the bolt and nut threads are clean. Apply bolt lubrication to the bolt and nut threads and to the face of the nut to be tightened. Do not apply grease or bolt lubricant to the joint face. After cleaning and lubrication it should be possible to run the nut along the full length of the bolt by hand. If this is not possible the bolts and nuts should be refurbished or replaced.
- Scrape, wire brush or file as necessary the back face of each flange where the bolt heads and nuts are to sit, ensuring that the surfaces are clean and flat.
- If possible use hardened flat washers to ensure even transfer of the load.

Installation

- Ensure that the gasket is installed centrally.
- It is recommended that the bolts are tightened using a controlled method such as torque or tension. If using a torque wrench, ensure that it is accurately calibrated.
- Tighten bolts in a star-like crossing pattern in the following sequence:
 - Finger tighten nuts
 - Tighten to 30% of the final load
 - Tighten to 60% of the final load
 - Tighten to full load
- Make a final tightening sequence, working around the flange, tightening each bolt in turn until the specified torque is achieved.

After Installation

- Check that the flange faces are parallel using a suitable tool e.g. Novus Flange Gap Tool.



Training

Training Programme 'Control of Flanged Joints'

The reliability of the flanged joint depends critically on competent control of the joint making process. It is common to put considerable effort into the design process only for improper assembly to lead to joint failure. Therefore it is important that joint making is undertaken by trained and validated technicians who have an understanding of the procedure and the underlying principles and practice.

The Control of Flanged Joints is an industry recognised training program designed to ensure that all individuals with responsibilities in connection with ensuring the safe control of flange joints are trained and validated as competent to undertake these responsibilities. The program, produced in conjunction with a major global petrochemical company and leading bolt service company, is based around a video presentation of best practices and utilises an intelligent bolting system to explain and demonstrate these principles. This unique training method allows key areas of joint making e.g. the need to use bolt lubricant, to be clearly understood.

The training covers a broad spectrum of topics which can be tailored to suit requirements including:

- * Introduction
- * Leaks and Emissions
- * Flange Design Issues
- * Flange Joint Preparation and Assembly
- * Systems and Procedures
- * Records and Traceability
- * Tightening Joints On-Line
- * Emission Monitoring
- * Control of Fugitive Emissions



A DVD presentation explains the principles of best practice.



On-Site Bolting Service

As part of our Bolting Programme we can test and recommend action and solutions to all your bolting problems, quality or safety control requirements in both our laboratory and on-site. We can also help with the training, information and technology of all flange and bolting problems - correct flange assembly, leakage issues, bolting stresses etc., and recommend the appropriate remedies and solutions. Please ask our technical department for details.

Contact our Technical Team for full details



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