



Certificate

no 16021250265-1197 EN Rev.1

Inspecta

Certificate of Assessment

This Certificate confirms that the collars with the nominal size range from DN 15 to DN 400 and the pressure class range from PN 2.5 to PN 16 manufactured by using the flanging machines produced by the company

T-Drill Oy
PO BOX 20
66401 LAIHIA

meet the strength requirements set out in EN 1092-1, and may be used in pressure equipment.

The verifying pressure tests have been performed by T-DRILL Oy comprehensively, in accordance with Method A set forth in Annex T to the standard EN 13445-3. The materials used for testing were carbon steel and stainless steel. The tests were applied to the most critical pipe sizes DN 65 and DN 125, selected on the basis of preceding theoretical calculations. Therefore the test results obtained with these sizes can be considered to represent the entire range of nominal sizes under inspection.

Our assessment is based on the results of the above described tests, and the long-standing practical experience of T-DRILL Oy with the produced collars. In the flanging process the flange thickness is reduced. However, provided that the flanging machines used to manufacture the collars are operated in accordance with their operating instructions, the produced flanges contain no defects jeopardising safety of pressure equipment.

The manufacturer of pressure equipment should take into account possible work hardening of the lapped pipe end when designing and manufacturing flange joints of carbon steel pipes or tubes. The hot forming option that is available with the T-Drill flanging machine prevents possible work hardening and there is no need for additional heat treatment of the steel.

Seinäjoki 27.09.2016

INSPECTA TARKASTUS OY
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