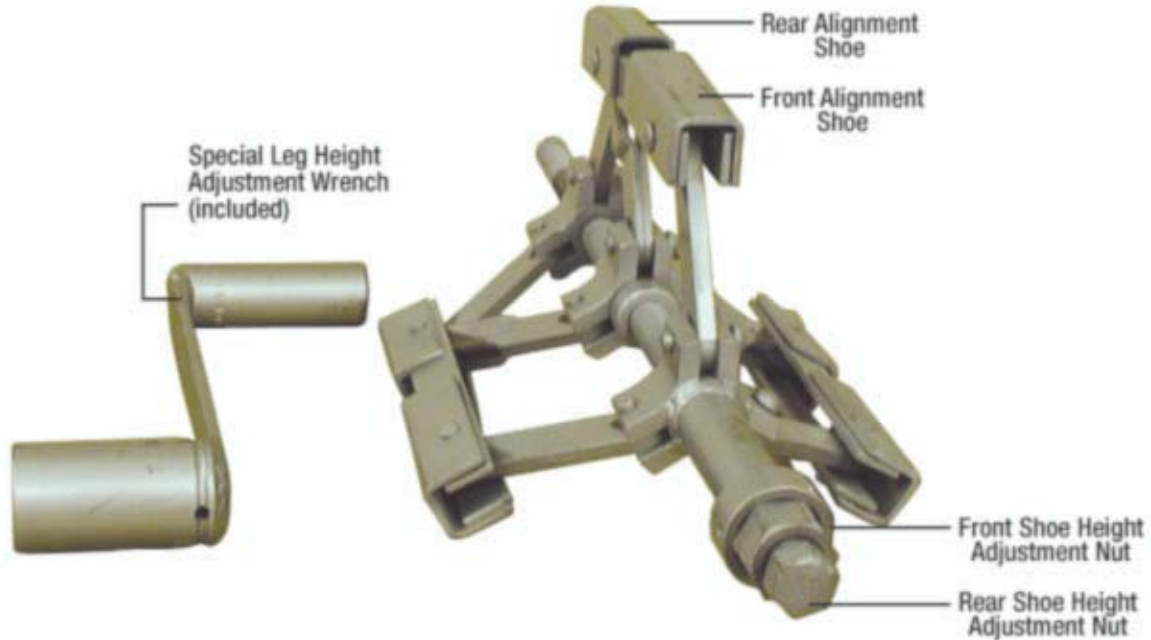


Internal Flange Alignment Tools



The Internal Flange Alignment Tool quickly and accurately aligns the ID of the flange to the ID of the pipe. Reduces fit-up time by 60%. The ID of the Flange can vary $\pm 1/8"$ / 3mm to the ID of the pipe and still obtain perfect alignment. The Internal Flange Alignment Tool is designed to align 150 and 300 pound flanges. The tool is used for the alignment of the flange and should never be used as the sole support of the flange.

- **ACCURATE** – Eliminates guess work when internally aligning flange.
- **RAPID ALIGNMENT** – Flanges can be aligned and squared in two (2) minutes.
- **SAVES TIME AND MONEY** – Alignment can be done by one (1) person regardless of flange size.

Part Number	Pipe Size (In./mm)	Shipping Weight (lbs./kg)
Carbon Steel		
D325	4 - 6 / 102 - 152	10 / 5
D326	6 - 8 / 152 - 203	11 / 5
D327	8 - 14 / 203 - 356	16 / 7
D328	16 - 24 / 406 - 610	24 / 11
Stainless Steel		
D325SS	4 - 6 / 102 - 152	10 / 5
D326SS	6 - 8 / 152 - 203	11 / 5
D327SS	8 - 14 / 203 - 356	16 / 7
D328SS	16 - 24 / 406 - 610	24 / 11

Internal Flange Alignment Tools



1 Insert the Front and Rear Alignment Shoes into the pipe. Tighten the Rear Alignment Shoes against the pipe wall using the Rear Shoe Height Adjustment Nut. Back-off the Rear Height Adjustment Nut one (1) full turn.



2 Center the rivet in the Front Alignment Shoe on the end of the pipe and rotate the Rear Shoe Height Adjustment Nut until the Rear Alignment Shoes are tight against the pipe wall.



3 Tighten the Front Alignment Shoes against the pipe wall using the Front Shoe Height Adjustment Nut. Back-off the Front Height Adjustment Nut one (1) full turn.



4 Place the Flange over the Front Alignment Shoes, until it touches the end of the pipe.



5 Tighten the Front Alignment Shoes against the flange wall using the Front Shoe Height Adjustment Nut.



6 The Flange Bore is now centered to the pipe face regardless of whether the inside diameters vary.



7 Release Front Alignment Shoes from flange wall using the Front Shoe Height Adjustment Nut just enough for flange to rotate. Level the Flange Bolt Holes with a Leveler. Tighten Front Alignment Shoes against the flange wall using Front Shoe Height Adjustment Nut.

Tack the Flange to the pipe and point between the Front Alignment Shoes. Remove the clamp after tacking is complete.