

Air Handling Systems

by Manufacturers Service Co., Inc.

INSTALLING ANGLE RINGS (FLANGES) ON ELBOWS WITH SMALL-ENDS

#1 Van Stoned Method

Slip ring over end of elbow collar and push tight to bead. Trim elbow collar so that only ½” is sticking out past face of ring. Use finger grip vice grips and clamp ring to collar. Take a rawhide mallet and peen ½” over to face of flange just shy of bolt holes. Ring will be secured between bead and peened collar.

#2 Weld/Tack Weld Method

Slip ring over end of elbow collar and push tight to bead. Take a magic marker and scribe the portion of the collar protruding past face of ring. Take ring off and cut back collar at scribe mark. Then slip ring over elbow and push to bead. Tack weld where ring meets bead. Then take a mallet and dress collar tight to inside of ring. This will eliminate the gap.