



Operational Procedure - Rev 0

NWP 01 - Rev 1

BMS 83 - Taylor Forge Class 125 to 350 Flat Ring & Full Face Gaskets

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Class 125

Nominal Pipe Size	Gasket ID		IBC Gasket OD		Full Face						Nominal Pipe Size	
	Inches	mm	Inches	mm	Full Face Gasket OD		Diameter of Bolt Holes		Bolt P.C.D.			Number of Bolt Holes
					Inches	mm	Inches	mm	Inches	mm		
26	26 1/4	666.8	30 3/8	771.5	34 1/4	870.0	1 3/8	34.9	31 3/4	806.5	24	26
28	28 1/4	717.6	32 5/8	828.7	36 1/2	927.1	1 3/8	34.9	34	863.6	28	28
30	30 1/4	768.4	34 5/8	879.5	38 3/4	984.3	1 3/8	34.9	36	914.4	28	30
32	32 1/4	819.2	36 7/8	936.6	41 3/4	1060.5	1 5/8	41.3	38 1/2	977.9	28	32
34	34 1/4	870.0	38 7/8	987.4	43 3/4	1111.3	1 5/8	41.3	40 1/2	1028.7	32	34
36	36 1/4	920.8	41 1/8	1044.6	46	1168.4	1 5/8	41.3	42 3/4	1085.9	32	36
38	38 1/4	971.6	43 5/8	1108.1	48 3/4	1238.3	1 5/8	41.3	45 1/4	1149.4	32	38
40	40 1/4	1022.4	45 5/8	1158.9	50 3/4	1289.1	1 5/8	41.3	47 1/4	1200.2	36	40
42	42 1/4	1073.2	47 7/8	1216.0	53	1346.2	1 5/8	41.3	49 1/2	1257.3	36	42
44	44 1/4	1124.0	50 1/8	1273.2	55 1/4	1403.4	1 5/8	41.3	51 3/4	1314.5	40	44
46	46 1/4	1174.8	52 1/8	1324.0	57 1/4	1454.2	1 5/8	41.3	53 3/4	1365.3	40	46
48	48 1/4	1225.6	54 3/8	1381.1	59 1/2	1511.3	1 5/8	41.3	56	1422.4	44	48
50	50 1/4	1276.4	56 3/8	1431.9	61 3/4	1568.5	1 7/8	47.6	58 1/4	1479.6	44	50
52	52 1/4	1327.2	58 5/8	1489.1	64	1625.6	1 7/8	47.6	60 1/2	1536.7	44	52
54	54 1/4	1378.0	60 7/8	1546.2	66 3/4	1695.5	1 7/8	47.6	62 3/4	1593.9	44	54
60	60 1/4	1530.4	67 3/8	1711.3	73	1854.2	1 7/8	47.6	69 1/4	1759.0	52	60
66	66 1/4	1682.8	74 1/8	1882.8	80	2032.0	1 7/8	47.6	76	1930.4	52	66
72	72 1/4	1835.2	80 5/8	2047.9	86 1/2	2197.1	1 7/8	47.6	82 1/2	2095.5	60	72
84	84 1/4	2140.0	93 3/8	2371.7	99 3/4	2533.7	2 1/8	54.0	95 1/2	2425.7	64	84
96	96 1/4	2444.8	106 1/8	2695.6	113 1/4	2876.6	2 3/8	60.3	108 1/2	2755.9	68	96

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Class 175

Nominal Pipe Size	Gasket ID		IBC Gasket OD		Full Face						Nominal Pipe Size	
	Inches	mm	Inches	mm	Full Face Gasket OD		Diameter of Bolt Holes		Bolt P.C.D.			Number of Bolt Holes
					Inches	mm	Inches	mm	Inches	mm		
26	26	660.4	29	736.6	31 1/2	800.1	7/8	22.2	29 7/8	758.8	28	26
28	28	711.2	31	787.4	33 1/2	850.9	7/8	22.2	31 7/8	809.6	28	28
30	30	762.0	33 1/4	844.6	35 3/4	908.1	7/8	22.2	34 1/8	866.8	36	30
32	32	812.8	35 1/4	895.4	37 3/4	958.9	7/8	22.2	36 1/8	917.6	36	32
34	34	863.6	37 3/8	949.3	40 1/4	1022.4	1	25.4	38 3/8	974.7	36	34
36	36	914.4	39 3/8	1000.1	42 1/4	1073.2	1	25.4	40 3/8	1025.5	36	36
38	38	965.2	41 3/8	1050.9	44 1/4	1124.0	1	25.4	42 3/8	1076.3	36	38
40	40	1016.0	43 3/8	1101.7	46 1/4	1174.8	1	25.4	44 3/8	1127.1	40	40
42	42	1066.8	45 3/4	1162.1	49	1244.6	1 1/8	28.6	46 7/8	1190.6	40	42
44	44	1117.6	47 3/4	1212.9	51	1295.4	1 1/8	28.6	48 7/8	1241.4	40	44
46	46	1168.4	49 3/4	1263.7	53	1346.2	1 1/8	28.6	50 7/8	1292.2	40	46
48	48	1219.2	51 3/4	1314.5	55	1397.0	1 1/8	28.6	52 7/8	1343.0	44	48
50	50	1270.0	53 3/4	1365.3	57	1447.8	1 1/8	28.6	54 7/8	1393.8	44	50
52	52	1320.8	56	1422.4	59 1/2	1511.3	1 1/4	31.8	57 1/4	1454.2	44	52
54	54	1371.6	58	1473.2	61 1/2	1562.1	1 1/4	31.8	59 1/4	1505.0	44	54
60	60	1524.0	64	1625.6	67 1/2	1714.5	1 1/4	31.8	65 1/4	1657.4	48	60
66	66	1676.4	70	1778.0	73 1/2	1866.9	1 1/4	31.8	71 1/4	1809.8	56	66
72	72	1828.8	76 1/2	1943.1	80	2032.0	1 1/4	31.8	77 3/4	1974.9	64	72
84	84	2133.6	90 1/8	2289.2	94	2387.6	1 3/8	34.9	91 1/2	2324.1	72	84
96	96	2438.4	102 1/8	2594.0	106	2692.4	1 3/8	34.9	103 1/2	2628.9	88	96

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Class 250

Nominal Pipe Size	Gasket ID		IBC Gasket OD		Full Face						Nominal Pipe Size	
					Full Face Gasket OD		Diameter of Bolt Holes		Bolt P.C.D.			Number of Bolt Holes
	Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm		
26	26 1/4	666.8	32 5/8	828.7	38 1/4	971.6	1 7/8	47.6	34 1/2	876.3	28	26
28	28 1/4	717.6	35 1/8	892.2	40 3/4	1035.1	1 7/8	47.6	37	939.8	28	28
30	30 1/4	768.4	37 3/8	949.3	43	1092.2	1 7/8	47.6	39 1/4	997.0	28	30
32	32 1/4	819.2	39 5/8	1006.5	45 1/4	1149.4	1 7/8	47.6	41 1/2	1054.1	28	32
34	34 1/4	870.0	41 5/8	1057.3	47 1/2	1206.5	1 7/8	47.6	43 1/2	1104.9	28	34
36	36 1/4	920.8	43 7/8	1114.4	50	1270.0	2 1/8	54.0	46	1168.4	32	36
38	38 1/4	971.6	45 7/8	1165.2	52 1/4	1327.2	2 1/8	54.0	48	1219.2	32	38
40	40 1/4	1022.4	48 1/8	1222.4	54 1/2	1384.3	2 1/8	54.0	50 1/4	1276.4	36	40
42	42 1/4	1073.2	50 5/8	1285.9	57	1447.8	2 1/8	54.0	52 3/4	1339.9	36	42
44	44 1/4	1124.0	52 7/8	1343.0	59 1/4	1505.0	2 1/8	54.0	55	1397.0	36	44
46	46 1/4	1174.8	55 1/8	1400.2	61 1/2	1562.1	2 1/8	54.0	57 1/4	1454.2	40	46
48	48 1/4	1225.6	58 5/8	1489.1	65	1651.0	2 1/8	54.0	60 3/4	1543.1	40	48

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Class 350

Nominal Pipe Size	Gasket ID		IBC Gasket OD		Full Face						Nominal Pipe Size	
	Inches	mm	Inches	mm	Full Face Gasket OD		Diameter of Bolt Holes		Bolt P.C.D.			Number of Bolt Holes
					Inches	mm	Inches	mm	Inches	mm		
26	26	660.4	29 1/2	749.3	32 3/4	831.9	1 1/8	28.6	30 5/8	777.9	28	26
28	28	711.2	31 1/2	800.1	34 3/4	882.7	1 1/8	28.6	32 5/8	828.7	28	28
30	30	762.0	33 3/4	857.3	37	939.8	1 1/8	28.6	34 7/8	885.8	32	30
32	32	812.8	35 3/4	908.1	39	990.6	1 1/8	28.6	36 7/8	936.6	36	32
34	34	863.6	37 3/4	958.9	41	1041.4	1 1/8	28.6	38 7/8	987.4	40	34
36	36	914.4	40 1/4	1022.4	43 3/4	1111.3	1 1/4	31.8	41 1/2	1054.1	40	36
38	38	965.2	42 1/4	1073.2	45 3/4	1162.1	1 1/4	31.8	43 1/2	1104.9	40	38
40	40	1016.0	44 1/4	1124.0	47 3/4	1212.9	1 1/4	31.8	45 1/2	1155.7	44	40
42	42	1066.8	46 1/2	1181.1	50	1270.0	1 1/4	31.8	47 3/4	1212.9	48	42
44	44	1117.6	48 7/8	1241.4	52 3/4	1339.9	1 3/8	34.9	50 1/4	1276.4	44	44
46	46	1168.4	50 7/8	1292.2	54 3/4	1390.7	1 3/8	34.9	52 1/4	1327.2	48	46
48	48	1219.2	52 7/8	1343.0	56 3/4	1441.5	1 3/8	34.9	54 1/4	1378.0	48	48
52	52	1320.8	57 1/4	1454.2	61 1/2	1562.1	1 1/2	38.1	58 3/4	1492.3	52	52
54	54	1371.6	59 1/4	1505.0	63 1/2	1612.9	1 1/2	38.1	60 3/4	1543.1	52	54
60	60	1524.0	65 1/4	1657.4	69 1/2	1765.3	1 1/2	38.1	66 3/4	1695.5	60	60
66	66	1676.4	72 3/8	1838.3	77	1955.8	1 5/8	41.3	74	1879.6	60	66
72	72	1828.8	78 3/8	1990.7	83	2108.2	1 5/8	41.3	80	2032.0	72	72
84	84	2133.6	91 7/8	2333.6	96 1/2	2451.1	1 3/8	34.9	93 1/4	2368.6	80	84
96	96	2438.4	103 7/8	2638.4	109 1/4	2775.0	1 7/8	47.6	105 3/4	2686.1	84	96

Unless otherwise specified on the works order, tolerances shall be in accordance as follows:

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- i.e.**
- | | |
|---|-----------------|
| Outside Diameter | + 0 / - 3.00 mm |
| Inside Diameter | + 3.00mm / - 0 |
| Bolt circle diameter | + / - 1.50 mm |
| Centre to centre of adjacent bolt holes | + / - 0.76 mm |