

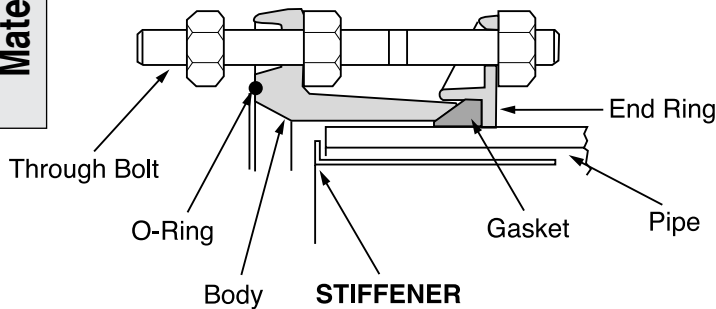
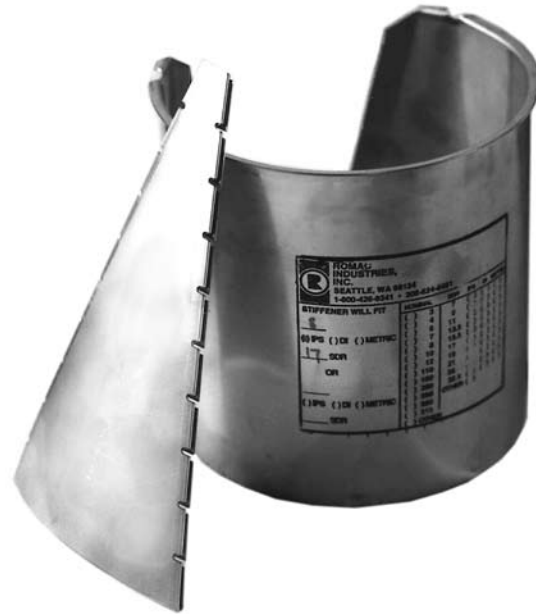
HDPE FOR HIGH DENSITY POLYETHYLENE PIPE



Stiffening Inserts

Material Specifications

Romac's specially designed Stiffening Inserts provide circumferential inside support of HDPE pipe ends. The Stiffening Inserts are constructed of stainless steel per ASTM 240, type 304; their thin yet strong wall reinforces the pipe without disturbing the flow characteristic of the medium.



Flexible couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.

A Stiffener must be used in a coupling for SDR greater than 7.

Romac Only warrants the use of Romac stiffeners with Romac 501 Couplings and Romac Flanged Coupling Adapters.

Romac Couplings are not to be used on HDPE pipe with an SDR greater than 32.5.

For above-ground HDPE applications, contact Romac's Engineering Department at 1-800-426-9341.

Products and prices listed on pages 8-9 and 8-10 are standard Romac sizes. For information on other sizes, contact Romac's Engineering Department.

For important technical information on HDPE pipe, see Page 8-1 & Page 8-2.

Easy Installation...

1 Both pipe ends being joined require stiffeners. Insert stiffener into each pipe so that stiffener lip touches pipe end.

2 Insert wedge into stiffener.

Wedge

Stiffener

Make sure wedges are not directly opposed

Wedge Extension

3 Fix wedge firmly in stiffener by striking with a rubber hammer.

4 Assemble coupling onto pipe.

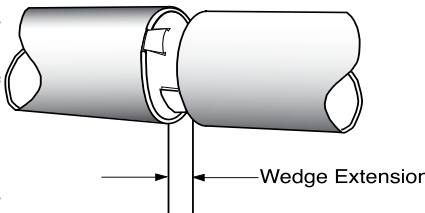
! A stiffener **MUST** be used in each HDPE pipe end.
Exact SDR of HDPE used is required when ordering.

HDPE FOR HIGH DENSITY POLYETHYLENE PIPE  MADE IN U.S.A. **Stiffening Inserts**

| For IPS Pipe Size | | | | | | | | | |
|-------------------|-----------------------|------|------------------------------|-----------------|-------------------|--------------------------|----------------|------------|--------------|
| NOM. PIPE SIZE | PIPE OUTSIDE DIAMETER | SDR | SUGGESTED CENTER RING LENGTH | AVERAGE PIPE ID | AVERAGE PIPE WALL | MAXIMUM WEDGE EXTENSION* | CATALOG NUMBER | LIST PRICE | WEIGHT (LBS) |
| 4" | 4.5 | 9 | 7 | 3.44 | 0.530 | 2.2 | 206-04020907 | \$82.68 | 1.6# |
| | | 11 | | 3.63 | 0.434 | 1.9 | 206-04021107 | | |
| | | 13.5 | | 3.79 | 0.353 | 1.7 | 206-04021307 | | |
| | | 15.5 | | 3.88 | 0.308 | 1.6 | 206-04021507 | | |
| | | 17 | | 3.94 | 0.281 | 1.5 | 206-04021707 | | |
| | | 19 | | 4.00 | 0.251 | 1.5 | 206-04021907 | | |
| | | 21 | | 4.05 | 0.227 | 1.4 | 206-04022107 | | |
| | | 26 | | 4.13 | 0.183 | 1.3 | 206-04022607 | | |
| | | 32.5 | | 4.22 | 0.138 | 1.2 | 206-04023207 | | |
| | | 6" | | 6.625 | 9 | 7 | 5.06 | | |
| 11 | 5.35 | | 0.638 | | 2.0 | | 206-06021107 | | |
| 13.5 | 5.58 | | 0.520 | | 1.8 | | 206-06021307 | | |
| 15.5 | 5.72 | | 0.453 | | 1.7 | | 206-06021507 | | |
| 17 | 5.80 | | 0.413 | | 1.6 | | 206-06021707 | | |
| 19 | 5.89 | | 0.370 | | 1.5 | | 206-06021907 | | |
| 21 | 5.96 | | 0.334 | | 1.5 | | 206-06022107 | | |
| 26 | 6.08 | | 0.270 | | 1.4 | | 206-06022607 | | |
| 32.5 | 6.22 | | 0.204 | | 1.3 | | 206-06023207 | | |
| 8" | 8.625 | | 9 | | 7 | | 6.59 | 1.016 | 2.2 |
| | | 11 | 6.96 | 0.831 | | 1.9 | 206-08021107 | | |
| | | 13.5 | 7.27 | 0.677 | | 1.7 | 206-08021307 | | |
| | | 15.5 | 7.45 | 0.590 | | 1.6 | 206-08021507 | | |
| | | 17 | 7.55 | 0.538 | | 1.5 | 206-08021707 | | |
| | | 19 | 7.66 | 0.481 | | 1.5 | 206-08021907 | | |
| | | 21 | 7.75 | 0.435 | | 1.4 | 206-08022107 | | |
| | | 26 | 7.92 | 0.352 | | 1.3 | 206-08022607 | | |
| | | 32.5 | 8.10 | 0.265 | | 1.2 | 206-08023207 | | |
| | | 10" | 10.75 | 9 | | 7 | 8.22 | 1.266 | 2.7 |
| 11 | 8.68 | | | 1.036 | 2.4 | | 206-10021107 | | |
| 13.5 | 9.06 | | | 0.844 | 2.1 | | 206-10021307 | | |
| 15.5 | 9.28 | | | 0.735 | 2.0 | | 206-10021507 | | |
| 17 | 9.41 | | | 0.670 | 1.9 | | 206-10021707 | | |
| 19 | 9.55 | | | 0.600 | 1.8 | | 206-10021907 | | |
| 21 | 9.66 | | | 0.543 | 1.7 | | 206-10022107 | | |
| 26 | 9.87 | | | 0.438 | 1.6 | | 206-10022607 | | |
| 32.5 | 10.09 | | | 0.331 | 1.5 | | 206-10023207 | | |
| 12" | 12.75 | | | 9 | 7 | | 9.75 | 1.502 | 3.2 |
| | | 11 | 10.29 | 1.229 | | 2.8 | 206-12021107 | | |
| | | 13.5 | 10.75 | 1.001 | | 2.5 | 206-12021307 | | |
| | | 15.5 | 11.01 | 0.872 | | 2.4 | 206-12021507 | | |
| | | 17 | 11.16 | 0.795 | | 2.3 | 206-12021707 | | |
| | | 19 | 11.33 | 0.711 | | 2.2 | 206-12021907 | | |
| | | 21 | 11.46 | 0.644 | | 2.1 | 206-12022107 | | |
| | | 26 | 11.71 | 0.520 | | 1.9 | 206-12022607 | | |
| | | 32.5 | 11.97 | 0.392 | | 1.8 | 206-12023207 | | |

To Order:
Determine Nominal Pipe Size and SDR Size.

*** Maximum Wedge Extension:** This would be the extension if the pipe was made to the smallest permissible inside diameter and the stiffener was installed at zero Fahrenheit. This extension also takes into account the slight collapsing of the pipe on the cut end "toe in" (1% of the outside diameter). The typical wedge extension, at room temperature and for the average pipe ID would be half the values listed above. For best results, install wedges so that they're not directly opposed



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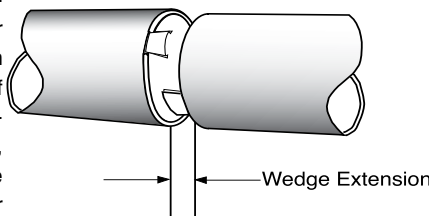


Stiffening Inserts

| For Ductile Iron Pipe Sizes | | | | | | | | | |
|-----------------------------|-----------------------|------|------------------------------|-----------------|-------------------|--------------------------|----------------|------------|--------------|
| NOM. PIPE SIZE | PIPE OUTSIDE DIAMETER | SDR | SUGGESTED CENTER RING LENGTH | AVERAGE PIPE ID | AVERAGE PIPE WALL | MAXIMUM WEDGE EXTENSION* | CATALOG NUMBER | LIST PRICE | WEIGHT (LBS) |
| 4" | 4.80 | 9 | 7 | 3.67 | 0.565 | 2.3 | 206-04010907 | \$91.07 | 1.7# |
| | | 11 | | 3.87 | 0.463 | 2.0 | 206-04011107 | | |
| | | 13.5 | | 4.05 | 0.377 | 1.8 | 206-04011307 | | |
| | | 15.5 | | 4.14 | 0.328 | 1.7 | 206-04011507 | | |
| | | 17 | | 4.20 | 0.299 | 1.6 | 206-04011707 | | |
| | | 19 | | 4.26 | 0.268 | 1.6 | 206-04011907 | | |
| | | 21 | | 4.32 | 0.242 | 1.5 | 206-04012107 | | |
| | | 26 | | 4.41 | 0.196 | 1.4 | 206-04012607 | | |
| | | 32.5 | | 4.50 | 0.148 | 1.3 | 206-04013207 | | |
| | | 6" | | 6.90 | 9 | 7 | 5.27 | | |
| 11 | 5.57 | | 0.665 | | 2.1 | | 206-06011107 | | |
| 13.5 | 5.82 | | 0.542 | | 1.9 | | 206-06011307 | | |
| 15.5 | 5.96 | | 0.472 | | 1.8 | | 206-06011507 | | |
| 17 | 6.04 | | 0.430 | | 1.7 | | 206-06011707 | | |
| 19 | 6.13 | | 0.385 | | 1.6 | | 206-06011907 | | |
| 21 | 6.20 | | 0.348 | | 1.5 | | 206-06012107 | | |
| 26 | 6.34 | | 0.281 | | 1.4 | | 206-06012607 | | |
| 32.5 | 6.48 | | 0.212 | | 1.3 | | 206-06013207 | | |
| 8" | 9.05 | | 9 | | 7 | | 6.92 | 1.066 | 2.3 |
| | | 11 | 7.31 | 0.872 | | 2.0 | 206-08011107 | | |
| | | 13.5 | 7.63 | 0.711 | | 1.8 | 206-08011307 | | |
| | | 15.5 | 7.81 | 0.619 | | 1.7 | 206-08011507 | | |
| | | 17 | 7.92 | 0.564 | | 1.6 | 206-08011707 | | |
| | | 19 | 8.04 | 0.505 | | 1.5 | 206-08011907 | | |
| | | 21 | 8.14 | 0.457 | | 1.5 | 206-08012107 | | |
| | | 26 | 8.31 | 0.369 | | 1.4 | 206-08012607 | | |
| | | 32.5 | 8.49 | 0.278 | | 1.3 | 206-07013207 | | |
| | | 10" | 11.10 | 9 | | 7 | 8.49 | 1.307 | 2.8 |
| 11 | 8.96 | | | 1.070 | 2.5 | | 206-10011107 | | |
| 13.5 | 9.36 | | | 0.872 | 2.2 | | 206-10011307 | | |
| 15.5 | 9.58 | | | 0.759 | 2.1 | | 206-10011507 | | |
| 17 | 9.72 | | | 0.692 | 2.0 | | 206-10011707 | | |
| 19 | 9.86 | | | 0.619 | 1.9 | | 206-10011907 | | |
| 21 | 9.98 | | | 0.560 | 1.8 | | 206-10012107 | | |
| 26 | 10.20 | | | 0.453 | 1.7 | | 206-10012607 | | |
| 32.5 | 10.42 | | | 0.342 | 1.6 | | 206-10013207 | | |
| 12" | 13.20 | | | 9 | 7 | | 10.09 | 1.555 | 3.3 |
| | | 11 | 10.66 | 1.272 | | 2.9 | 206-12011107 | | |
| | | 13.5 | 11.13 | 1.036 | | 2.6 | 206-12011307 | | |
| | | 15.5 | 11.39 | 0.903 | | 2.5 | 206-12011507 | | |
| | | 17 | 11.55 | 0.823 | | 2.4 | 206-12011707 | | |
| | | 19 | 11.73 | 0.736 | | 2.2 | 206-12011907 | | |
| | | 21 | 11.87 | 0.666 | | 2.1 | 206-12012107 | | |
| | | 26 | 12.12 | 0.538 | | 2.0 | 206-12012607 | | |
| | | 32.5 | 12.39 | 0.406 | | 1.9 | 206-12013207 | | |

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