

# INSTALLATION INSTRUCTIONS

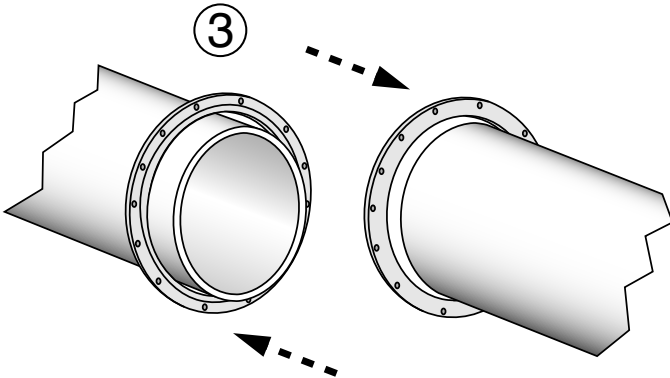
Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the coupling to ensure you have the proper size.

## Style 400 Fabricated Steel Coupling (Smaller than 60")

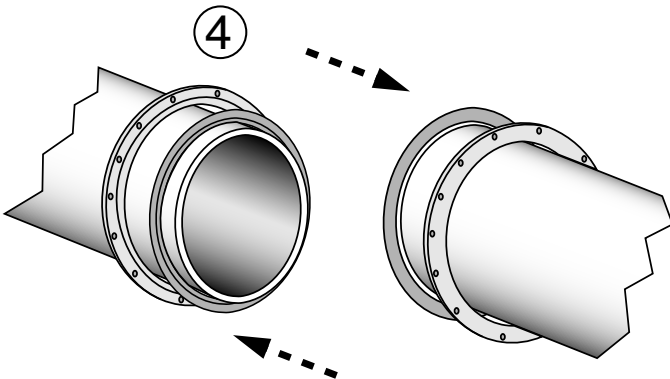
**Step 1** Clean pipe ends for a distance of 2" greater than length of the coupling. Check area where gaskets will seat to make sure there are no dents, projections, gouges, etc. that will interfere with the gasket seal. Welds must be ground flush.

**Step 2** Place a reference mark on pipe an equal distance from each pipe end for centering coupling over the pipe ends.

**Step 3** Place one end ring on each pipe end.

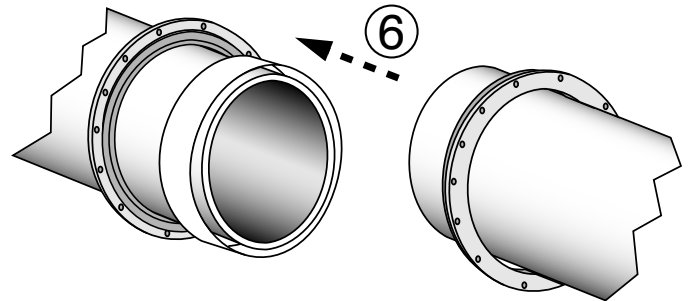


**Step 4** Clean gaskets and place one gasket next to each end ring with beveled edge toward the pipe end.

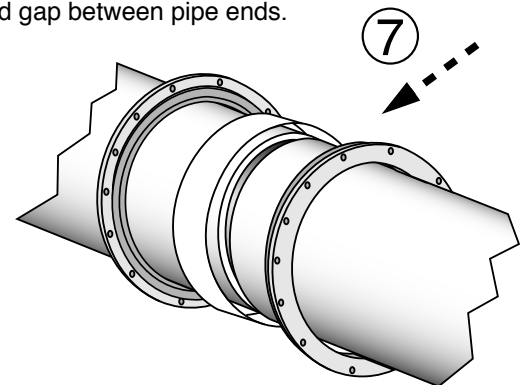


**Step 5** Lubricate the gaskets and pipe surface with a suitable gasket lubricant.

**Step 6** Slide center ring onto pipe end.



**Step 7** Bring the other pipe end into position. Maintain recommended gap between pipe ends.



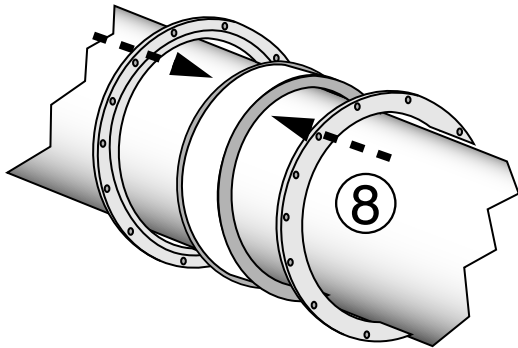
### Recommended Gap between Pipe Ends

Center Ring Length	Optimum Gap	Max. Gap with Pipe Stops and No Pipe Movement
5"	1/4" - 1/2"	1"
7"	1/2" - 3/4"	2"
10"	1/2" - 1 1/4"	3 1/2"

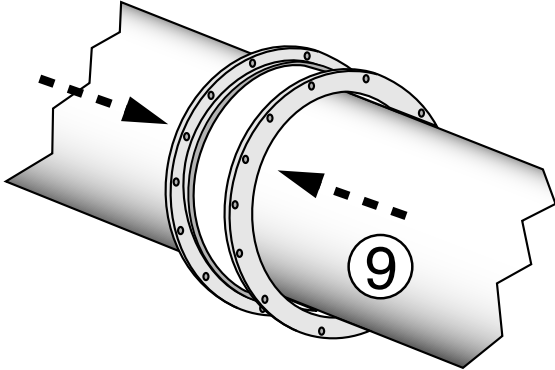
Installation Instructions continued on back

## Style 400 (continued from front)

**Step 8** Center ring should be positioned such that pipe entrance is equal. Slide gaskets into position with the beveled edge engaging the flared end of center ring.

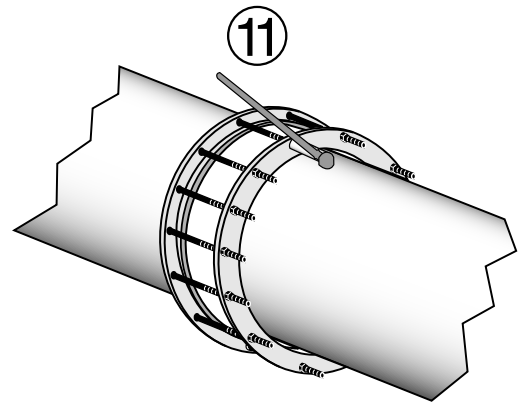


**Step 9** Slide the end rings into position against the gaskets.



**Step 10** Check coupling for proper positioning over pipe ends using reference marks. (See Step 2).

**Step 11** Insert bolts into end rings and tighten. Bolt tightening should be done evenly, alternating to diametrically opposite positions to bring bolts to recommended tightness. (60-70 ft-lbs. for  $\frac{5}{8}$ " bolts and 85-95 ft-lbs. for  $\frac{3}{4}$ " bolts).



**Step 12** After pipe is pressurized check for leakage and retorquing as necessary.



**CAUTION:** A pipe section should not be allowed to hang in the coupling either before or after making up the joint. Couplings are designed to "float" on the pipe ends. They are not designed to support the pipe.

**CAUTION:** Couplings with a step in the center ring have the potential for migrating along the pipe; therefore some form of restraint should be used.

**CAUTION:** When reinstalling parts with stainless steel hardware there may be a loss in pressure holding ability due to worn or damaged threads during the original installation.

**CAUTION:** Flexible couplings do not provide protection against axial force. Suitable anchorage should be provided.