ROMAC INDUSTRIES, INC.

INSTALLATION INSTRUCTIONS

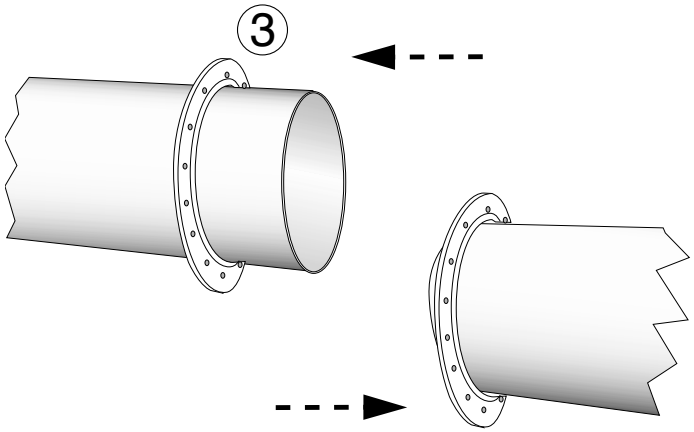
Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the coupling to ensure you have the proper size.

Style IC400 Fabricated Steel Coupling with insulating boot (12"- 72")

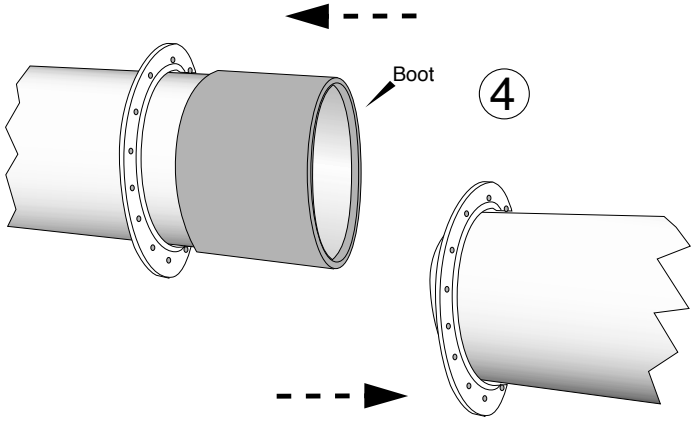
Step 1 Clean each pipe end for a distance of 2" greater than length of the insulating boot. Check area where gaskets will seat to make sure there are no dents, projections, gouges, etc. that will interfere with the gasket seal. Welds must be ground flush.

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

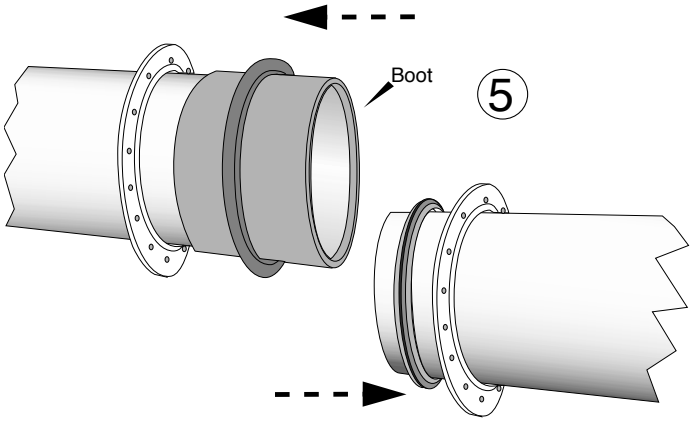
Step 3 Place one end ring on each pipe end.



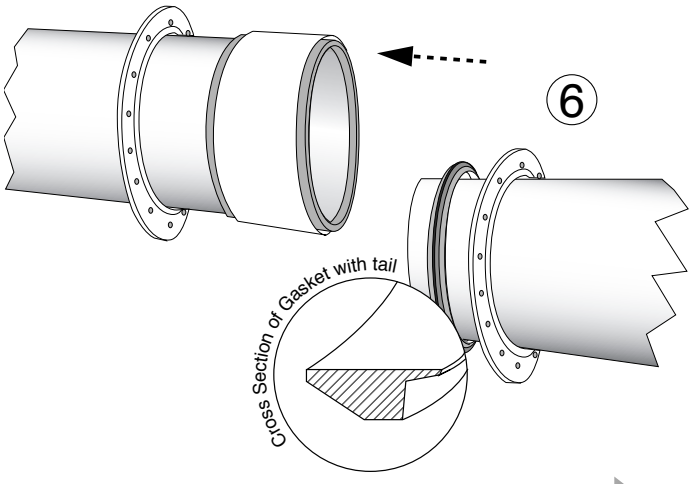
Step 4 Place insulating boot on pipe.



Step 5 Clean and lubricate gaskets. Place the gasket without the tail on the insulating boot. Place the other gasket on the opposite pipe, with beveled edge toward the pipe ends. If the coupling has two boots, then each gasket should be marked "IC".



Step 6 Slide center ring onto pipe end.



Installation Instructions continued on back

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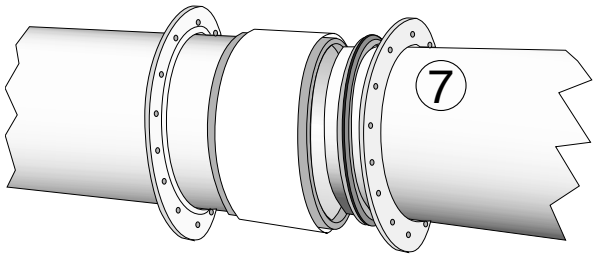
ROMAC INDUSTRIES, INC.

INSTALLATION INSTRUCTIONS

Style IC400 (continued from front)

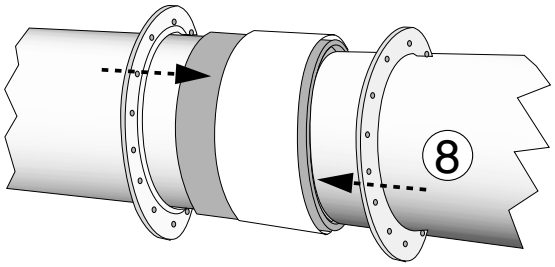
Step 7 Bring the other pipe end into position. Maintain recommended gap between pipe ends.



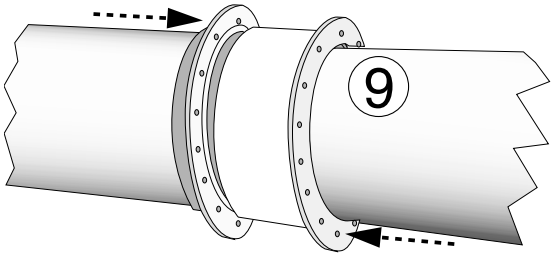
Recommended Gap between Pipe Ends

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"

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.

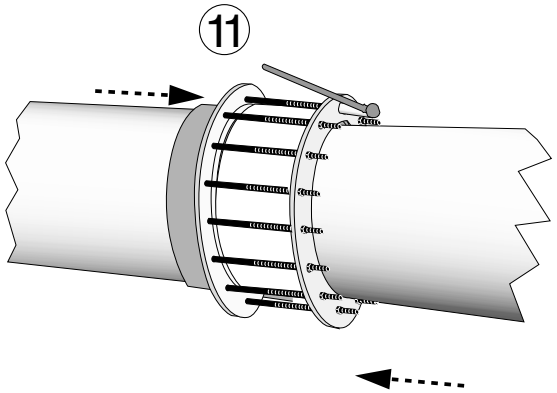


Step 9 Slide the end rings into position against the gaskets.



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 5/8" bolts and 85-95 ft-lbs. for 3/4" bolts).



PRESSURE RATING

Nom. Pipe Size	Working Pressure	Test Pressure
12"-36"	300psi	450psi
42"-72"	250psi	375psi

NOTE: Do not test to pressures higher than the psi rating of the pipe.

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

Note: Flexible Couplings do not provide protection against axial force. Suitable anchorage should be provided.
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.

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