

## ANCHOR PIN INSTALLATION

1. Remove anchor pins from flanged coupling adapter body or coupling ring.
2. Assemble the flanged coupling adapter or coupling per the installation instructions.
3. Thread a short NPT pipe nipple into the threaded anchor pin hole. Using the largest drill bit that will fit through the pipe nipple, drill a center mark on the pipe. Do not drill through the pipe. Remove pipe nipple.
4. Use a 5/16 inch diameter drill to complete the hole through the pipe at the center mark made in step 3.
5. Use the appropriate size drill per the chart below to complete the hole through the pipe. Be careful not to damage the half coupling threads.
6. Install anchor pins. Apply a suitable thread sealant and tighten to prevent leakage. See table below for recommended torque.

### BASIC INFORMATION AND DRILL SIZE

<u>NOM SIZE</u>	<u>PIN SIZE</u>	<u>THREAD SIZE</u>	<u>DRILL SIZE for PIN</u>	<u>FT-LBS</u>
4"	1/2	3/8 NPT	17/32	40
6"	5/8	1/2 NPT	21/32	50
8" & larger*	7/8	3/4 NPT	29/32	80
12" & larger*	1	1 NPT	1-1/32	100

\*Pin size dependant upon pressure requirements.

### TORQUE REQUIREMENTS

Anchor pins use NPT tapered pipe threads to provide a seal between the pin and the fitting body. To transfer the restraining forces transmitted and real the pins, these torque values are required.