

# 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 501 & RC501 Couplings

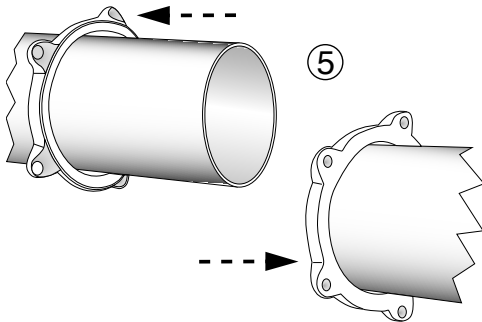
**Step 1** • Check the coupling parts to insure that no damage has occurred during transit and that no parts are missing.

**Step 2** • Clean pipe ends for a distance of 2" greater than length of the coupling when centered over the joint.

**Step 3** • 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.

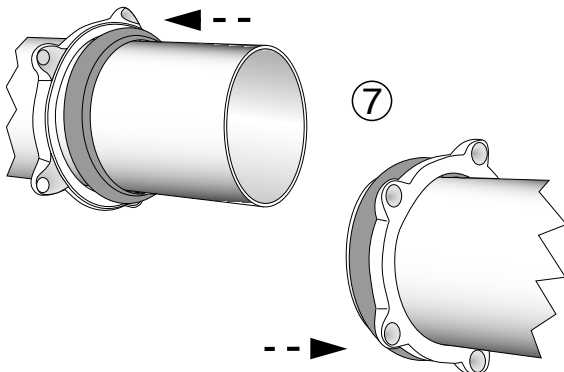
**Step 4** • Place a reference mark on the pipe an equal distance from each pipe end for centering coupling over the pipe ends. There should be a minimum of 2" inches of pipe insertion per coupling end. If the coupling has anchor pins, see Anchor Pin installation guide for pipe insertion.

**Step 5** • Place one end ring on each pipe end.

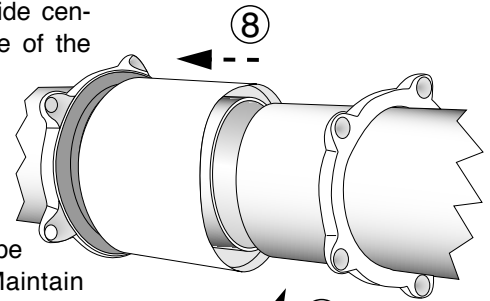


**Step 6** • Lubricate the gaskets and pipe surface with a suitable gasket lubricant.

**Step 7** • Place one gasket next to each end ring with beveled edge toward the pipe end.



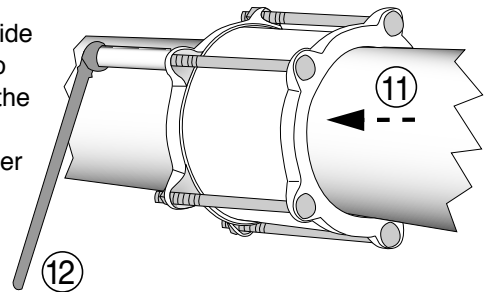
**Step 8** • Slide center ring onto one of the pipes.



**Step 9** • Bring the other pipe into position. Maintain recommended gap between pipe ends ( $\frac{1}{4}$ " -  $\frac{1}{2}$ " for five inch long center ring).

**Step 10** • The center ring should be centered such that the space between the OD of the pipe and the ID of the center ring is even all around the pipe. Slide gaskets into position with the beveled edge engaging the flared end of the center ring.

**Step 11** • Slide the end rings into position against the gaskets. Check coupling for proper positioning over pipe ends using reference marks. (See Step 4)



**Step 12** • Insert bolts into end rings and tighten. Bolt tightening should be done evenly, alternating to diametrically opposite positions at approximately 20 ft-lbs increments.

Nom. Pipe Diameter	Torque
2" - 12"	40-50 ft-lbs.
14" and above	60-70 ft-lbs.

**Note:**

50 ft-lbs. torque = 12" wrench w/50 lbs. force  
70 ft-lbs. torque = 12" wrench w/70 lbs. force

**Step 13** • After pipe is pressurized, check for leakage and tighten as necessary.

**Note: Flexible Couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.**

## Style 501 & RC501 Couplings

### PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correct size coupling; also check gasket to make sure it is the size you think it is.
2. Clean pipe to remove dirt and corrosion from pipe surface. Lubrication and additional cleaning should be provided by brushing both the gasket and plain pipe end with soapy water or approved pipe lubricant per ANSI/AWWA C111/A21.11.
3. Make sure no foreign materials lodge between gasket and pipe.
4. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque.
5. Keep threads free of foreign material to allow proper tightening.
6. Take extra care to follow proper bolt tightening procedures and torque recommendations. Bolts are often not tightened enough when a torque wrench is not used.
7. Pressure test for leaks before backfilling.
8. Backfill and compact carefully around pipe and fittings.
9. Couplings with a step in the center ring have the potential for migrating along the pipe; therefore some form of restraint should be used.
10. 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.

### COMMON INSTALLATION PROBLEMS

1. Bolts are not tightened to the proper torque.
2. Rocks or debris between pipe and gasket.
3. Dirt on threads of bolts or nuts.
4. Pipe not inserted into the coupling far enough.
5. Center ring not centered evenly around pipe.
6. Too much pipe deflection.