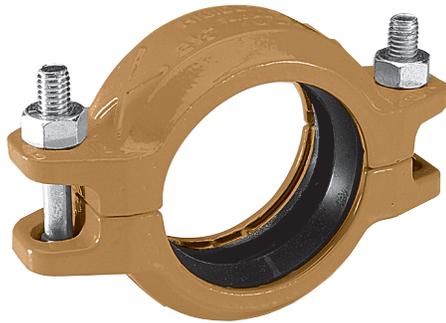


FIG. 7400 Rigidlite® Coupling



The Fig. 7400 Rigidlite Coupling from Gruvlok is specially designed to provide a rigid, locked-in pipe connection to meet the specific demands of rigid design steel pipe systems. Fast and easy swing-over installation of the rugged lightweight housing produces a secure, rigid pipe joint.

The galvanized Fig. 7400 is ideal for stainless steel piping application where the external corrosion properties of stainless steel is not required. For Gruvlok coupling pressure ratings on stainless steel pipe, please refer to the technical data section of the Gruvlok catalog.

MATERIAL SPECIFICATIONS

BOLTS:

SAE J429, Grade 5, Zinc Electroplated (standard)

HEAVY HEX NUTS:

SAE A563, Grade A, Zinc Electroplated (standard)

HARDWARE KITS:

- 304 Stainless Steel (available in sizes up to 3/4")
Kit includes: (2) Bolts per ASTM A193, Grade B8 and
(2) Heavy Hex Nuts per ASTM A194, Grade 8.
- EcoGuard® (available in sizes up to 3/4")
Kit includes: (2) Bolts per SAE J429, Grade 5, with EcoGuard®
corrosion-resistant zinc flake coating and
(2) Heavy Hex Nuts per ASTM A563, Grade A,
EcoGuard® corrosion-resistant zinc flake coating

HOUSING:

Ductile Iron conforming to ASTM A 536, Grade 65-45-12.

COATINGS:

- Rust inhibiting paint – Color: ORANGE (standard)
- Hot Dipped Zinc Galvanized (optional)

GASKETS:

Properties as designated in accordance with ASTM D 2000

- Grade "EP" EPDM (Green and Red color code)
-40°F to 250°F (Service Temperature Range)(-40°C to 121°C)
Recommended for water service, diluted acids, alkalies solutions,
oil-free air and many other chemical services.
NOT FOR USE IN PETROLEUM APPLICATIONS.

For hot water applications the use of Gruvlok Xtreme™ Temperature lubricant is recommended. NSF-61 Certified.

- Grade "T" Nitrile (Orange color code)
NOT FOR USE IN DRINKING WATER
-20°F to 180°F (Service Temperature Range)(-29°C to 82°C)
Recommended for petroleum applications. air with oil vapors and
vegetable and mineral oils.
NOT FOR USE IN HOT WATER OR HOT AIR
- Grade "O" Fluoro-Elastomer (Blue color code)
NOT FOR USE IN DRINKING WATER
Size Range: 1" - 8" (C style only)
20°F to 300°F (Service Temperature Range)(-29°C to 149°C)
Recommended for high temperature resistance to oxidizing acids,
petroleum oils, hydraulic fluids, halogenated hydrocarbons and
lubricants.
- Grade "L" Silicone (Red color code)
NOT FOR USE IN DRINKING WATER
Size Range: 1" - 8" (C style only)
-40°F to 350°F (Service Temperature Range)(-40°C to 177°C)
Recommended for dry, hot air and some high temperature chemical
services.

GASKET TYPE:

- Standard C Style (1" - 8")
- Flush Gap (1" - 8")

LUBRICATION:

- Standard Gruvlok
- Gruvlok Xtreme™ (Do Not use with Grade "L")

PROJECT INFORMATION		APPROVAL STAMP	
Project:		<input type="checkbox"/> Approved	
Address:		<input type="checkbox"/> Approved as noted	
Contractor:		<input type="checkbox"/> Not approved	
Engineer:		Remarks:	
Submittal Date:			
Notes 1:			
Notes 2:			

FIG. 7400 Rigidlite® Coupling

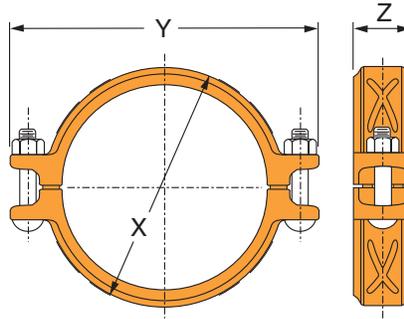


FIGURE 7400 RIGIDLITE COUPLING

Nominal Size	O.D.	Max. Working Pressure [†]	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts		Approx. Wt. Ea.
					X	Y	Z	Qty.	Size	
<i>In./DN(mm)</i>	<i>In./mm</i>	<i>PSI/bar</i>	<i>Lbs./kN</i>	<i>In./mm</i>	<i>In./mm</i>	<i>In./mm</i>	<i>In./mm</i>		<i>In./mm</i>	<i>Lbs./Kg</i>
1	1.315	300	407	0- ¹ / ₃₂	2 ¹ / ₄	4 ¹ / ₂	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.2
25	33.4	20.7	1.81	0-0.79	57	114	44		M10 x 57	0.5
1 ¹ / ₄	1.660	300	649	0- ¹ / ₃₂	2 ⁵ / ₈	4 ³ / ₄	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.3
32	42.2	20.7	2.89	0-0.79	67	121	44		M10 x 57	0.6
1 ¹ / ₂	1.900	300	851	0- ¹ / ₃₂	2 ⁷ / ₈	4 ⁷ / ₈	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.4
40	48.3	20.7	3.78	0-0.79	73	124	44		M10 x 57	0.6
2	2.375	300	1,329	0- ¹ / ₃₂	3 ¹ / ₄	5 ¹ / ₂	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.6
50*	60.3	20.7	5.91	0-0.79	83	140	44		M10 x 57	0.7
2 ¹ / ₂	2.875	300	1,948	0- ¹ / ₃₂	3 ⁷ / ₈	6	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.9
65	73.0	20.7	8.66	0-0.79	98	152	44		M10 x 57	0.9
3 O.D.	2.996	300	2,115	0- ¹ / ₃₂	4	5 ⁷ / ₈	1 ³ / ₄	2	³ / ₈ x 2 ¹ / ₄	1.9
76.1	76.1	20.7	9.41	0-0.79	102	149	44		M10 x 57	0.9
3	3.500	300	2,886	0- ¹ / ₃₂	4 ¹ / ₂	6 ¹ / ₄	1 ³ / ₄	2	³ / ₈ x 3	2.4
80	88.9	20.7	12.84	0-0.79	114	159	44		M10 x 70	1.1
4	4.500	300	4,771	0- ³ / ₃₂	5 ³ / ₄	7 ⁷ / ₁₆	1 ⁷ / ₈	2	³ / ₈ x 3	3.5
100	114.3	20.7	21.22	0-2.38	146	189	48		M10 x 70	1.6
5 ¹ / ₂ O.D.	5.500	300	7,127	0- ³ / ₃₂	6 ³ / ₄	9 ¹ / ₄	2	2	¹ / ₂ x 3	4.5
139.7	139.7	20.7	31.70	0-2.38	171	235	51		M12 x 76	2.0
5	5.563	300	7,292	0- ³ / ₃₂	6 ¹³ / ₁₆	8 ¹⁵ / ₁₆	1 ⁷ / ₈	2	¹ / ₂ x 3	4.5
125	141.3	20.7	32.44	0-2.38	173	227	48		M12 x 70	2.0
6 ¹ / ₂ O.D.	6.500	300	9,955	0- ³ / ₃₂	7 ³ / ₄	10 ³ / ₈	2	2	¹ / ₂ x 3	5.5
165.1	165.1	20.7	44.28	0-2.38	200	264	51		M12 x 76	2.5
6	6.625	300	10,341	0- ³ / ₃₂	7 ⁷ / ₈	10 ¹ / ₁₆	1 ¹⁵ / ₁₆	2	¹ / ₂ x 3	5.4
150	168.3	20.7	46.00	0-2.38	200	256	49		M12 x 70	2.4
8	8.625	300	17,528	0- ³ / ₃₂	10 ¹ / ₈	12 ⁷ / ₁₆	2 ³ / ₈	2	¹ / ₂ x 3	9.5
200*	219.1	20.7	77.97	0-2.38	257	316	60		M12 x 70	4.3

NOTES:

Range of Pipe End Separation values are for roll grooved pipe and may be doubled for cut groove pipe.
[†] Maximum Working Pressure Rating is for schedule 40 steel pipe. For light wall, stainless steel, aluminum and ISO pipe pressure ratings, please refer to the technical data section.

For additional details see "Coupling Data Chart Notes" in the Introduction Section of the Gruvlok Catalog. See Installation & Assembly directions on next page.

FIG. 7400

Rigidlite® Coupling

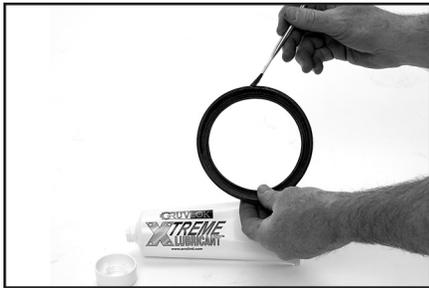
WARNING



- Read and understand all instructions before use.
- Ensure system is drained and depressurized before installation or service.
- Use appropriate personal protective equipment.

Failure to follow these instructions could result in serious personal injury and/or property damage.

Check pipe ends for proper grooved dimensions and to ensure that the pipe is free of indentations, projections, or other imperfections that would prevent proper sealing of the gasket.



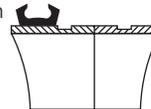
1 CHECK & LUBRICATE GASKET— Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok lubricant to the exterior surface and sealing lips of the gasket. Some applications require lubrication of the entire gasket surface. Be careful that foreign particles do not adhere to lubricated surfaces.

NOTICE: Gruvlok Xtreme™ Lubricant must be applied when used in dry pipe systems or freezer applications. separation. Pipe joint separation may result in significant property damage and serious injury.



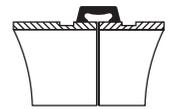
2 GASKET INSTALLATION— Slip the gasket over the pipe end making sure the gasket lip does not overhang the pipe end.

On couplings 10" and larger it may be easier to turn the gasket inside out then lubricate and slide the gasket over the pipe end as shown.



3 ALIGNMENT— After aligning the two pipe ends, pull the gasket into position centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

On couplings 10" and larger, flip or roll the gasket into centered position.



4 HOUSINGS— Remove one nut and bolt and loosen the other nut. Place one housing over the gasket, making sure the housing keys fit into the pipe grooves. Swing the other housing over the gasket and into the grooves on both pipes, making sure the tongue and recess of each housing is properly mated. Reinsert the bolt and run-up both nuts finger tight.



5 TIGHTEN NUTS— Securely tighten nuts alternately and equally, keeping the gaps at the bolt pads evenly spaced.

NOTICE: Uneven tightening may cause the gasket to pinch. Gasket should not be visible between segments after bolts are tightened.

6 ASSEMBLY IS COMPLETE— Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves. The bolt pads are to have equal gaps on each side of the coupling.

NOTICE: Visually inspect both sides of the coupling to ensure gaps between bolt pads are evenly spaced and are parallel. Any deviations must be corrected before placing coupling into service.

NOTICE: Sizes 16" and larger are cast in multiple segments. To install the larger sizes align the tongue and pocket of the couplings appropriately and tighten the nuts alternately to the specified bolt torque. When properly assembled there will be a small equal gap between the adjacent bolt pads.

ANSI SPECIFIED BOLT TORQUE		
Bolt Size	Wrench Size	Specified Bolt Torque *
<i>In.</i>	<i>In.</i>	<i>Ft.-Lbs</i>
3/8	1 1/16	30-45
1/2	7/8	80-100

* Non-lubricated bolt torques.