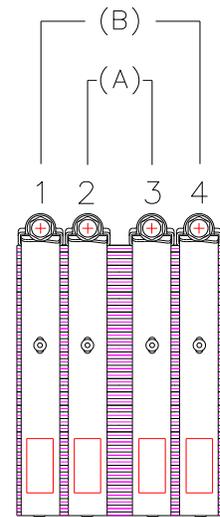
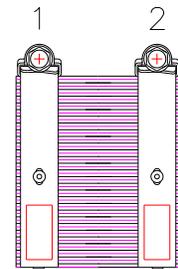


## Recommended Practice for Installation of Classic Hubless Cast Iron Pipe Couplings

### A. Clamp and Gasket Installation

- 1) Pipe ends are to be cut as squarely and smoothly as possible.
- 2) Check coupling and gasket for foreign material, clean if necessary.
- 3) Insert gasket over pipe or fitting until end of the pipe or fitting butts against the gasket's integrally molded shoulder.
- 4) Slide the coupling assembly over the gasket in a fashion as indicated in one of the picture showing general schematic for installation of couplings of all sizes. Insert the second pipe or fitting into the gasket until both ends of pipe or fittings butt against the integrally molded shoulder in the center of gasket.
- 5) Slide the coupling assembly into position centered over the gasket. At this point, it is recommended to hand tighten all the clamps in the coupling assembly with a nut runner or wrench. Final tightening is described below.
- 6) Use a preset, or preferably, a dial indicating type torque wrench and tighten clamps to 60 inch-pounds of torque using the procedure below.
- 7) Coupling sizes 1 1/2", 2", 3", and 4" have two clamps.  
 \*\*Tighten clamp 1 and then clamp 2 alternately in 20 lbf-in increments until the recommended 60 lbf-in is reached.
- 8) Coupling sizes 5", 6", 8" and 10" have four clamps.  
 \*\* First the inner clamps "A" are to be tightened alternately in 20 lbf-in increments until the recommended 60 lbf-in load is reached. Next, the outside clamps "B" are to be tightened alternately in 20 lbf-in increments until the recommended 60 lbf-in is reached.

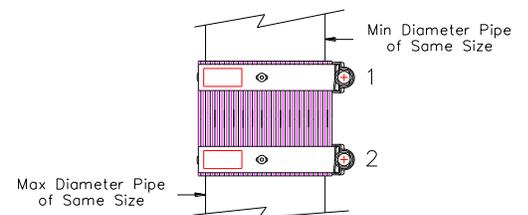
\*\* When O.D. difference between pipe and fitting is visibly different the following torque pattern is recommended 1-3, 2-4. (This Assumes min.  $\varnothing$  pipe is under 1 & 2 as shown, if not reverse sequence).



Sizes 5", 6", 8" & 10"

### B. NOTES:

- 1) For installation details inside and outside building, see CISPI 310.



General Schematic for Installation of Couplings of All Sizes

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