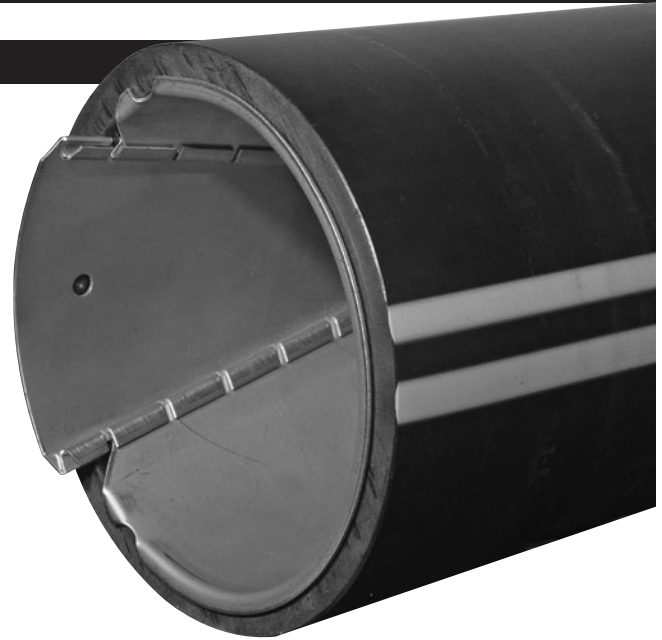
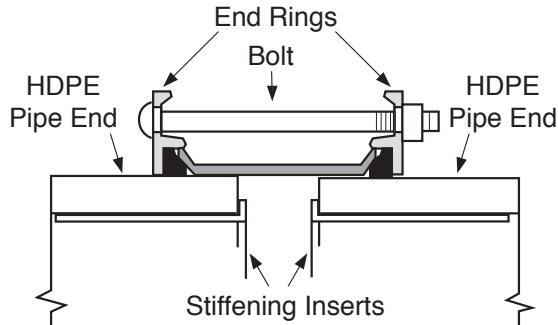




STIFFENING INSERTS

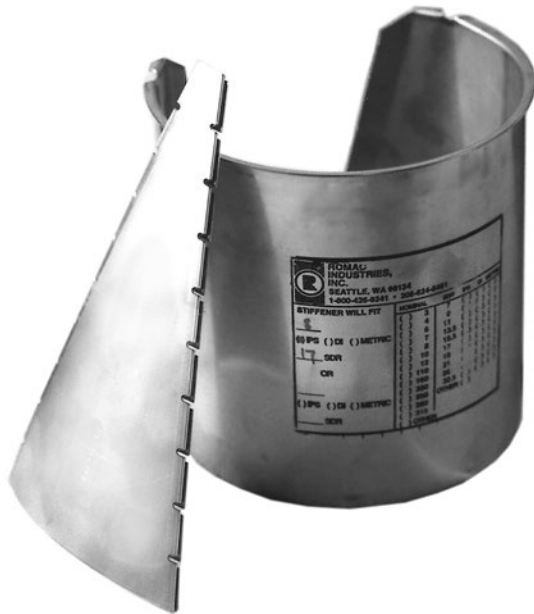
MATERIAL SPECIFICATIONS

Romac's specially designed Stiffening Inserts provide circumferential inside support of pipe ends to allow use of couplings on HDPE Pipe. The stiffening inserts are constructed of stainless steel per ASTM A240, type 304 (optional 316). The thin, yet strong wall reinforces the pipe without disturbing the flow characteristic of the medium.



SIZES 4"– 12" (PGS. 9-6 & 9-7)
FEATURE A WEDGE INSERT FOR INSTALLATION
 (SEE PHOTO ABOVE).

SIZES 14"– 36" (PG. 9-8)
ARE CUSTOM MOLDED TO THE ACTUAL PIPE I.D. AND HAVE A TAPERED EDGE FOR EASE OF INSTALLATION.



- Flexible couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.
- Romac couplings are not to be used on HDPE pipe with an SDR greater than 32.5.
- Romac only warrants the use of Romac stiffeners with Romac couplings.
- A stiffener must be used in a coupling for SDR greater than 7.
- For above-ground HDPE applications, contact Romac's Engineering Department at 1-800-426-9341.
- For important technical information on HDPE pipe, see Page 9-1 & Page 9-2.

STIFFENING INSERTS

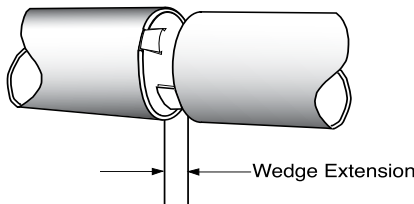


HDPE FOR HIGH DENSITY POLYETHYLENE PIPE

FOR IPS PIPE SIZE

NOM. PIPE SIZE	OUTSIDE DIAMETER	SDR	SUGGESTED CENTER RING LENGTH	AVERAGE PIPE ID	AVERAGE PIPE WALL	MAX. WEDGE EXTENSION*	CATALOG NUMBER	LIST PRICE	WEIGHT (lbs.)
4"	4.5	9	7	3.44	0.530	2.2	206-04020907	\$158.31	1.6#
				3.63	0.434	1.9	206-04021107		
				3.79	0.353	1.7	206-04021307		
				3.88	0.308	1.6	206-04021507		
				3.94	0.281	1.5	206-04021707		
				4.00	0.251	1.5	206-04021907		
				4.05	0.227	1.4	206-04022107		
				4.13	0.183	1.3	206-04022607		
				4.22	0.138	1.2	206-04023207		
				6"	6.625	9	7		
5.35	0.638	2.0	206-06021107						
5.58	0.520	1.8	206-06021307						
5.72	0.453	1.7	206-06021507						
5.80	0.413	1.6	206-06021707						
5.89	0.370	1.5	206-06021907						
5.96	0.334	1.5	206-06022107						
6.08	0.270	1.4	206-06022607						
6.22	0.204	1.3	206-06023207						
8"	8.625	9	7					6.59	1.016
				6.96	0.831	1.9	206-08021107		
				7.27	0.677	1.7	206-08021307		
				7.45	0.590	1.6	206-08021507		
				7.55	0.538	1.5	206-08021707		
				7.66	0.481	1.5	206-08021907		
				7.75	0.435	1.4	206-08022107		
				7.92	0.352	1.3	206-08022607		
				8.10	0.265	1.2	206-08023207		
				10"	10.75	9	7	8.22	1.266
8.68	1.036	2.4	206-10021107						
9.06	0.844	2.1	206-10021307						
9.28	0.735	2.0	206-10021507						
9.41	0.670	1.9	206-10021707						
9.55	0.600	1.8	206-10021907						
9.66	0.543	1.7	206-10022107						
9.87	0.438	1.6	206-10022607						
10.09	0.331	1.5	206-10023207						
12"	12.75	9	7					9.75	1.502
				10.29	1.229	2.8	206-12021107		
				10.75	1.001	2.5	206-12021307		
				11.01	0.872	2.4	206-12021507		
				11.16	0.795	2.3	206-12021707		
				11.33	0.711	2.2	206-12021907		
				11.46	0.644	2.1	206-12022107		
				11.71	0.520	1.9	206-12022607		
				11.97	0.392	1.8	206-12023207		
				14" & up	see page 9-8				

* **MAXIMUM WEDGE EXTENSION:** This would be the extension if the pipe was made to the smallest permissible inside diameter and the stiffener was installed at zero Fahrenheit. This extension also takes into account the slight collapsing of the pipe on the cut end "toe in" (1% of the outside diameter). The typical wedge extension, at room temperature and for the average pipe ID would be half the values listed above. For best results, install wedges so that they're not directly opposed.



- Provide pipe SDR when ordering.
- HDPE Products are No Cancel, No Return Items.

TO ORDER: Determine Nominal Pipe Size and SDR Size.

HDPE



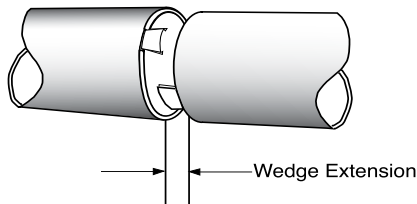
STIFFENING INSERTS

FOR DUCTILE IRON PIPE SIZE

NOM. PIPE SIZE	OUTSIDE DIAMETER	SDR	SUGGESTED CENTER RING LENGTH	AVERAGE PIPE ID	AVERAGE PIPE WALL	MAX. WEDGE EXTENTION*	CATALOG NUMBER	LIST PRICE	WEIGHT (lbs.)
4"	4.80	9 11 13.5 15.5 17 19 21 26 32.5	7	3.67	0.565	2.3	206-04010907	\$174.38	1.7#
				3.87	0.463	2.0	206-04011107		
				4.05	0.377	1.8	206-04011307		
				4.14	0.328	1.7	206-04011507		
				4.20	0.299	1.6	206-04011707		
				4.26	0.268	1.6	206-04011907		
				4.32	0.242	1.5	206-04012107		
				4.41	0.196	1.4	206-04012607		
				4.50	0.148	1.3	206-04013207		
				6"	6.90	9 11 13.5 15.5 17 19 21 26 32.5	7		
5.57	0.665	2.1	206-06011107						
5.82	0.542	1.9	206-06011307						
5.96	0.472	1.8	206-06011507						
6.04	0.430	1.7	206-06011707						
6.13	0.385	1.6	206-06011907						
6.20	0.348	1.5	206-06012107						
6.34	0.281	1.4	206-06012607						
6.48	0.212	1.3	206-06013207						
8"	9.05	9 11 13.5 15.5 17 19 21 26 32.5	7					6.92	1.066
				7.31	0.872	2.0	206-08011107		
				7.63	0.711	1.8	206-08011307		
				7.81	0.619	1.7	206-08011507		
				7.92	0.564	1.6	206-08011707		
				8.04	0.505	1.5	206-08011907		
				8.14	0.457	1.5	206-08012107		
				8.31	0.369	1.4	206-08012607		
				8.49	0.278	1.3	206-08013207		
				10"	11.10	9 11 13.5 15.5 17 19 21 26 32.5	7	8.49	1.307
8.96	1.070	2.5	206-10011107						
9.36	0.872	2.2	206-10011307						
9.58	0.759	2.1	206-10011507						
9.72	0.692	2.0	206-10011707						
9.86	0.619	1.9	206-10011907						
9.98	0.560	1.8	206-10012107						
10.20	0.453	1.7	206-10012607						
10.42	0.342	1.6	206-10013207						
12"	13.20	9 11 13.5 15.5 17 19 21 26 32.5	7					10.09	1.555
				10.66	1.272	2.9	206-12011107		
				11.13	1.036	2.6	206-12011307		
				11.39	0.903	2.5	206-12011507		
				11.55	0.823	2.4	206-12011707		
				11.73	0.736	2.2	206-12011907		
				11.87	0.666	2.1	206-12012107		
				12.12	0.538	2.0	206-12012607		
				12.39	0.406	1.9	206-12013207		
				14" & up	see page 9-8				

HDPE

* **MAXIMUM WEDGE EXTENSION:** This would be the extension if the pipe was made to the smallest permissible inside diameter and the stiffener was installed at zero Fahrenheit. This extension also takes into account the slight collapsing of the pipe on the cut end "toe in" (1% of the outside diameter). The typical wedge extension, at room temperature and for the average pipe ID would be half the values listed above. For best results, install wedges so that they're not directly opposed.



- Provide pipe SDR when ordering.
- HDPE Products are No Cancel, No Return Items.

TO ORDER: Determine Nominal Pipe Size and SDR Size.

STIFFENING INSERTS

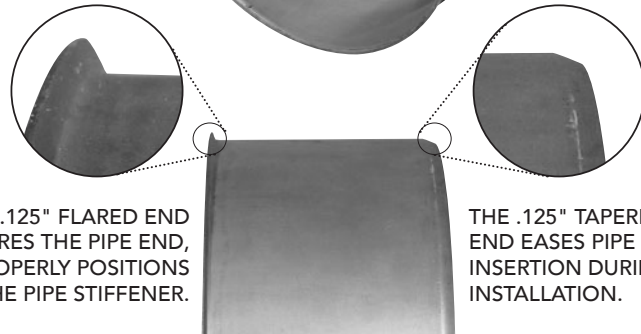
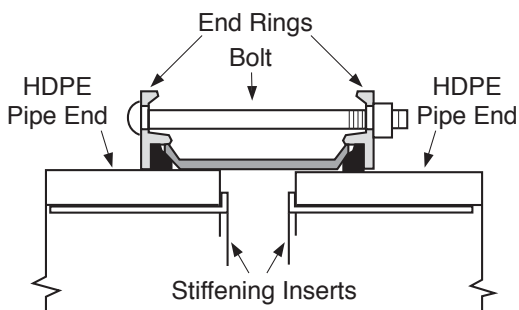


HDPE FOR HIGH DENSITY POLYETHYLENE PIPE

MATERIAL SPECIFICATIONS

Romac's specially designed Stiffening Inserts provide circumferential inside support of HDPE pipe ends. The Stiffening Inserts are constructed of stainless steel per ASTM A240, type 304 (optional 316). The thin, yet strong wall reinforces the pipe without disturbing the flow characteristic of the medium.

To ensure that pipe stiffeners are properly sized, we require the actual pipe I.D. at the time of order.



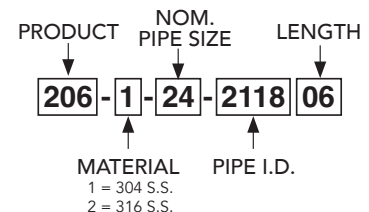
14"- 36" HDPE PIPE END STIFFENERS

NOM. PIPE SIZE	STIFFENER LENGTH		THICKNESS (GAUGE)	CATALOG NUMBER	LIST PRICE
	6"	12"			
14"	6"	12"	17	206-1-14- [PIPE ID] 06	POA
	12"	12"		206-1-14- [PIPE ID] 12	
16"	6"	12"	17	206-1-16- [PIPE ID] 06	POA
	12"	12"		206-1-16- [PIPE ID] 12	
18"	6"	12"	17	206-1-18- [PIPE ID] 06	POA
	12"	12"		206-1-18- [PIPE ID] 12	
20"	6"	12"	17	206-1-20- [PIPE ID] 06	POA
	12"	12"		206-1-20- [PIPE ID] 12	
22"	6"	12"	17	206-1-22- [PIPE ID] 06	POA
	12"	12"		206-1-22- [PIPE ID] 12	
24"	6"	12"	17	206-1-24- [PIPE ID] 06	POA
	12"	12"		206-1-24- [PIPE ID] 12	
30"	6"	12"	17	206-1-30- [PIPE ID] 06	POA
	12"	12"		206-1-30- [PIPE ID] 12	
36"	6"	12"	17	206-1-36- [PIPE ID] 06	POA
	12"	12"		206-1-36- [PIPE ID] 12	

For larger sizes, contact Romac Quotations Department.

- Provide pipe SDR when ordering.
- HDPE Products are No Cancel, No Return Items.

TO REQUEST PRICING: Indicate nominal pipe size. Select stiffener length and actual pipe ID.
EXAMPLE: For a 6" long stiffener for IPS size 24" nominal SDR 17 HDPE pipe, with an inside diameter of 21.18, the catalog number is: **206-01-2118 06**



HDPE