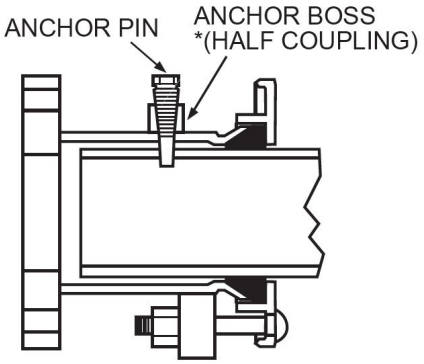
ANCHOR PIN INSTALLATION GUIDE

Anchor Pins provide pipe restraint. The quantity of anchor pins required is based on system pressure rating, pin size, and pin material (alloy steel or stainless steel). Anchor pins require the end user to field drill holes through their pipe wall. The anchor pins then thread into the coupling body, not the pipe. The portion of the anchor pin that protrudes through the pipe wall is a straight shank. The anchor pins are equally spaced around the perimeter of the coupling body, so the customer should be aware they will need access and the tools to do the field drilling. Contact Romac Quotations or Engineering Dept. for proper configuration and quoting.



*501 Series pins thread directly into body

- For use on Steel, Ductile, and Cast Iron only.
- Pipe Requirements: 1/4" wall thickness min. Customer to determine suitability of pipe for anchor pins.
- Pressure ratings depend on product style, pin quantity, pin material, and pipe ODs. See FCA501 Pin Pressure Chart (available on website). Contact Romac Engineering for other configurations.

INSTALLATION INSTRUCTIONS

STEP 1 Remove anchor pins from flanged coupling adapter body or coupling center ring.

STEP 2 Place a reference mark on pipe "X" distance from pipe end for aligning to end of center ring.

	"X" MIN. PIPE INSERTION			
	501 COUPLING		FCA501	400/FC400
SIZE	"X"	MIN. CR LGTH.	"X"	"X"
3"	3.00"	10"	3.00"	N/A
4"	3.00"	7"	3.00"	N/A
6"	3.00"	7"	3.00"	N/A
8"	3.00"	7"	3.00"	N/A
10" OD & IP	2.88"	6" "A"	4.00"	N/A
10" DI	3.00"	7" "B"	4.00"	N/A
12" OD & IP	2.88"	6 "A"	4.00"	N/A
ABOVE 12.75"	N/A	N/A	N/A	4.50"

STEP 3 Insert pipe into coupling until the end of the center ring aligns to the mark on the pipe.

STEP 4 Install the flanged coupling adapter or coupling per the installation instructions. Coupling should not move on pipe after this step. It is critical that alignment is maintained during drilling process so that pins can be inserted into holes.

STEP 5 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.

STEP 6 Use a 5/16 inch diameter drill to complete the hole through the pipe at the center mark made in step 3.

STEP 7 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.

STEP 8 Install Anchor Pins. Apply a suitable thread sealant and torque to specification in table below.

NOM. SIZE	PIN SIZE	THREAD SIZE	DRILL SIZE FOR PIN	TORQUE (FT-LBS)
3" & 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 dependent upon pressure requirements and product type.

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ROMAC INDUSTRIES, INC.

FCA501 ANCHOR PIN PRESSURE CHART

NOM. PIPE SIZE	COLOR CODE	MINIMUM PIPE O.D.	Steel Material		316SS Material				PIN SIZE
			STD QTY	MAX PRESSURE	MIN QTY	MAX PRESSURE	MAX QTY	MAX PRESSURE	
3	RED	3.00*	2	260	2	260	-	-	1/2”
		3.50	2	260	2	260	-	-	1/2”
		4.00	2	260	2	260	-	-	1/2”
4	RED	3.80*	4	260	2	110	4	220	1/2”
		4.00	4	260	2	110	4	220	1/2”
		4.50	4	260	2	130	4	260	1/2”
		4.80	4	260	2	160	4	260	1/2”
	BLACK	4.74*	4	260	2	150	4	260	1/2”
	YELLOW	5.11*	2	260	2	230	4	260	1/2”
6	RED	5.80*	4	245	2	85	4	170	5/8”
		6.00	4	260	2	90	4	180	5/8”
		6.63	4	260	2	120	4	240	5/8”
		6.90	4	260	2	150	4	260	5/8”
	BLACK	6.86*	4	260	2	145	4	260	5/8”
	YELLOW	7.15*	2	260	2	200	4	260	5/8”
8	RED	7.80*	4	260	2	120	4	245	7/8”
		8.00	4	260	2	130	4	260	7/8”
		8.63	4	260	2	170	4	260	7/8”
		9.05	2	260	2	230	4	260	7/8”
	BLACK	8.99*	2	260	2	220	4	260	7/8”
	YELLOW	9.51*	2	260	2	260	-	-	7/8”
10A	RED	9.80*	4	260	2	100	4	205	7/8”
		10.00	4	260	2	110	4	225	7/8”
		10.75	2	260	2	210	4	260	7/8”
10B	BLACK	10.70*	4	245	2	85	6	255	7/8”
		11.10	4	260	2	105	5	260	7/8”
	YELLOW	11.55*	2	260	2	155	4	260	7/8”
12A	RED	11.81*	4	250	2	85	4	175	7/8”
		12.00	4	260	2	100	4	200	7/8”
		12.75	2	260	2	245	4	260	7/8”
12B	BLACK	12.70*	5	260	2	70	6	215	7/8”
		13.20	4	260	2	105	5	260	7/8”
	YELLOW	NA	NA	NA	NA	NA	NA	NA	NA

NOTES

1. Anchor pins for use on cast iron, ductile iron, and steel pipe only.
2. Pipe Requirements: 1/4" wall thickness min. Customer to determine suitability of pipe for anchor pins.
3. FCA501 anchor pin pressures vary depending on pin quantities, material, and pipe OD. Contact Romac engineering for other configurations.
4. 16" and 4" x 3" FCA501 are not available with anchor pins.

*Minimum pipe OD for use with end ring color.

**Pressure ratings only apply when used on pipes with ODs greater than or equal to the listed pipe OD.