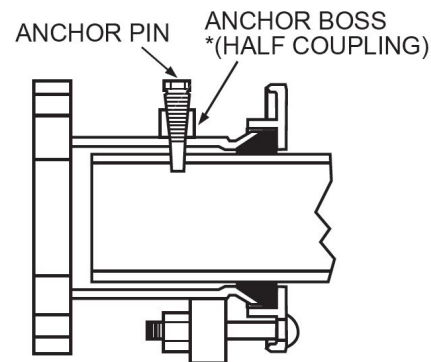


ANCHOR PIN INSTALLATION GUIDE

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.

- 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.



*501 Series pins thread directly into body

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.

SIZE	"X" MIN. PIPE INSERTION			
	501 COUPLING		FCA501	400/FC400
	"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)
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.