

ANCHOR PIN INSTALLATION

FOR USE ON STEEL, DUCTILE AND CAST IRON ONLY.

Pipe requirements: 1/4" wall thickness min.

1. Remove anchor pins from flanged coupling adapter body or coupling center ring.
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 | MIN. CR LGTH | FCA501 | 400/FC400 |
| 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" |

3. Insert pipe into coupling until the end of the center ring aligns to the mark on the pipe.
4. Assemble the flanged coupling adapter or coupling per the installation instructions.
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.
6. Use a 5/16 inch diameter drill to complete the hole through the pipe at the center mark made in step 3.
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.
8. Install anchor pins. Apply a suitable thread sealant and tighten to prevent leakage.

See table below for recommended torque.

BASIC INFORMATION & DRILL SIZE

| 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.

TORQUE REQUIREMENTS

Anchor pins use NPT tapered pipe threads to provide a seal between the pin and the fitting body.

To transfer the restraining forces transmitted and seal the pins, these torque values are required.

SIZE " X" Min Pipe Insertion